ELANTAS
Electrical Insulation

Processing Guide
Secondary Insulation

PG-130 –
Vacuum Impregnating (VI)
Unsaturated Epoxy Copolymer Resin

A member of ALTANA

Processing Guide
PG-130 – Vacuum Impregnating (VI) Unsaturated Epoxy Copolymer Resin

Process Step	***Optimum***	***Minimum***	***Comments***
Preheat	1 hour at 135 - 150°C(275 - 300°F) Once unit reaches temperature	None	Relax magnet wire, drives out moisture, thermosets tapes, assists in penetration
Dry Vacuum	2 hours at 29-30 inches of Hg *see below	1 hour at 27 inches of Hg	Removes air to allow penetration of resin.
Part Temperature when resin is introduced	50 – 55°C (120°F – 130°F)	25 – 50°C (77°F – 120°F)	Temperature has a direct bearing on resin penetration. If too low resin will not penetrate fully. If too high resin can be damaged
Wet vacuum	30 – 60 minutes	None	Wet vacuum removes entrapped air from resin.
Gas to release vacuum	Nitrogen	Dry air	Nitrogen is recommended to release vacuum and pressurize tank to insure the safest operation.
Drain Time	15-30 minutes	10-15 minutes	Longer drain will re-capture more resin.
Cool Resin	Agitate to 18-25°C (65-77°F)	Agitate to 25-27°C (75 - 80°F)	Return to holding tank keeping material cool improves tank life
Bake Schedule	As recommended by product data sheet.	As recommended by product data sheet.	Full cure is required to develop all performance properties.

*Turn off Vacuum pump, close vacuum valve to minimize monomer loss.

Please contact ELANTAS PDG, Inc. Technical Service if you have any questions.

Phone number 1.314.621.5700 Extension 717 or 1.800.325.7492 Extension 717

The above properties are typical values and are not intended for specification use.