



TECH SERVICE BULLETIN

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Fast Cure Applications With Dolphon® CC-1105

CC-1105 is the single best selling electrical impregnation resin on the market with excellent tank stability and superior performance characteristics. Because of this it is used in a wide variety of dip & bake and VPI applications. As supplied, the gel time of CC-1105 is too long to be used in fast curing processes such as trickle treat, but with additional catalyst it can be successfully used in these demanding applications.

Impact of Added Catalyst on Gel Time

<u>Added CA-2011</u>	<u>Gel Time at 212°F, minutes</u>
None	>100
0.5%	40
1.0%	30
2.0%	20
3.0%	15

With 2% added CA-2011, parts have been successfully processed with cure times of 15 – 30 minutes at temperatures from 300 - 350°F.

Adding additional catalyst does shorten the shelf life of CC-1105 and caution must be taken.

Impact of Added Catalyst on Shelf Life and Pot Life

<u>Added CA-2011</u>	<u>Shelf Life at 77°F</u>	<u>Pot Life at 135°F</u>
None	12 months	>2 months
0.5%	10 weeks	11 days
1.0%	2 months	10 days
2.0%	six weeks	8 days
3.0%	1 month	5 days

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