



TME 2011

PRODUCT STANDARD
TME DIVISION, BHOPAL

TM 88116

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SPECIFICATION OF HEW823 TYPE EPOXY COMPOUND

1. Scope

This specification describes HEW823 type epoxy compound (hereafter abbreviated as HEW823) to be used for adhesion and filler of electrical machines.

2. Ingredient

2.1 HEW823 consists of main resin and hardener.

The composition and mixing ratio are given in Table 1.

Table 1

Composition	Symbol	Color	Mixing ratio (wt)	Shelf life
Main resin	HEW823A	Gray	100	10 months
Hardener	HEW823B	Red	90	at <30°C

2.2 As each composition will be sent separately, they have to be mixed before using.

3. Quality

3.1 Quality of HEW823 before curing which is mixed by Table 1 is given in Table 2 (before curing).

3.2 When HEW823 is cured at 130°C 15hrs., quality of HEW823 is given in Table 2 (after curing).

Table 2

(Testing method : JIS C2105)

Before curing (liquid)		After curing (solid)		
Consistency at 25°C	Pot life (hrs) at 25°C	Adhesive strength (kgf/cm ²) with SUS plate		Weight loss (%) (200°C/72hrs)
		at 25°C	at 130°C	
220±40	≤36	≥50	≥20	≤2

5. This specification is equivalent to CLW specification no. A0256 Alt 02.

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 Table 1 modified
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Distribution

Qty.

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TME
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1
1
2