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ENGINEERING DATA SHEET
EPOXY INSULATOR 3400

3400 is a two-component, 100% solids, high temperature resistant, modified epoxy coating used for electronic circuit and component protection. The mixing ratio for this material is 1: 1 by weight and has a useful pot-life of 15-20 minutes. When properly cured, this product yields a chemically inert film which helps to prevent the effects of corrosion, moisture, oxidation, abrasion, and thermal shock. The cured film can withstand brief exposures to high temperatures of up to 450°F. No ingredients which are corrosive or harmful to electronic components are used in this material.

COMPOSITION PROPERTIES:

Color	Transparent Green
Solids	100%
Viscosity (Mixed)	11.0 Kcps (Brookfield RVT, Spin #7, 20 rpm, 25°C)
Cure Schedule	24 hours @ 25°C or 10-15 minutes @ 100°C
Service Temperature	-55 to 195°F
Dielectric Breakdown	>400 volts/mil
Insulation Resistance	>1 x 10 ¹⁴
Pot Life	15-20 minutes (10 gm mass @ 25°C)
Shelf Life	12 months @ 25°C (Sealed Container)

PROCESSING PARAMETERS:

Surface Preparations	Be sure that all surfaces to be coated with 3400 are clean, dry, and free of any grease or oil.
Mixing	The material should be thoroughly mixed for 1 minute prior to use.
Application	Brushing, rolling, or doctor blade.
Curing	Excellent results have been obtained by convection curing for 10 minutes @ 100°C. Optimum cure cycles using radiant or convection conveyor ovens are best determined experimentally. Product may also be cured for 24 hours @ room temperature (25°C)
Cleanup (Uncured Epoxy)	Use Isopropanol, Acetate, MEK, or Aromatic Hydrocarbon solvents.

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