

## 01-97 Epoxy Mould Plate

### Composition

01-97 mica moulding plate is a hot forming plate conforming to NEMA grade 2. Epoxy resin binder in 01-97 is partially cured, so that it will soften under heat and facilitate good moulding.

### Application

For hot moulding of intricate parts, such as mica commutator cones, end bell insulation, slot cells, coil forms, tubes etc.

### Processing

The layout comprising of the required number of layers of thin mica moulding plates (cut to definite shape), is set in a pre determined pattern. It is then heated uniformly to a temperature of 130°C—150°C, till it becomes soft. It takes the required form when moulded under pressure. It retains its form when cooled under pressure. The duration, temperature and pressure will have to be determined by application. These moulded parts, if required, can be fully cured under heat and pressure for several more hours to develop their full properties.

### Typical curing schedule for hot-moulded parts:

Temperature	180°C – 220°C
Pressure	14 - 35 kg/cm <sup>2</sup>
Duration	2 to 4 hrs

Exact curing schedules are to be arrived at by the users, depending on the desired final properties of the moulded parts.

### Product Data

Property	Unit	Value
Thermal Classification	°C	155
Thickness	mm	0.25 - 1.5
Thickness Tolerance	mm	Avg. - Upto 24 mil (0.6 mm) ± 0.025, over 24 mil ± 0.050 Individual ± 0.075
Binder Content	%	12 - 15
Mouldability		When 2 inch wide strip is heated (135°C - 150°C) & moulded over a mandrel of specified diameter: no deflaking to be observed.
Dielectric Strength	kV/mm	> 20

08/00



**Sahney Kirkwood Ltd**  
27 Kirol Vidyavihar (West)  
Bombay 400 086 INDIA  
Fax 91 22 595 1756  
Telephone 595 1750  
insulation@sahney.com

**Shelf Life**

Six months at 20°C from the date of manufacturing.

**Different Grades**

<b>Code No.</b>	<b>Mica Type</b>	<b>Binder content, %</b>	<b>Milled/Unmilled</b>
01 - 97 - 06	6 1st Ruby	14 – 20	Unmilled

**Available Size of sheets**

1050 mm X 780 mm and 900 mm X 900 mm  $\pm$  10 mm

780 mm X 525 mm and 900 mm X 450 mm  $\pm$  10 mm

980 mm X 780 mm  $\pm$  10 mm