

**Application Guideline
for
Ignition Coil**



1. Recommended ELANTAS Insulation systems

Systems	Distinctive Features
Dobefil 60 + Hardener 7055 + Acc.803 M	Filled, Off White Colored, EP Potting System, Heat Curing
Shimorez 400 + Elan-tron WH 95 + Acc.01 / Filler	Unfilled, Clear, EP Potting System, Heat Curing

2. Application Method: Potting Under Vacuum

- In pre-filled products it is good practice to re-homogenize the material by stirring before use.
- Charge Resin component in resin tank of dispensing machine.
- Charge Hardener and proportionate quantity of Accelerator in Hardener tank of dispensing machine at room temperature (25 - 40 °C). Please note that a premix of Accelerator with Resin is not stable; a premix of Accelerator with Hardener has limited stability.
- Heat Resin at 60-70 °C under stirring and apply vacuum of 0.5 to 5 mbar for 1-2 hours to remove traces of moisture & entrapped air. System is ready for dispensing.
- It is advisable to pre-heat the components at 100 -110 °C and carry out the potting process under vacuum.
- Follow the suggested curing schedule. (refer Sr.No -4)

Filler Addition – In Unfilled Resin System-

- Take Resin in Resin mixer. Heat resin to 50-60°C. Add recommended quantity of filler and mix entire quantity under vacuum of 0.5 to 5 mbar for 1-2 hours.
- Take Hardener + Accelerator in Hardener mixer. Add recommended quantity of filler and mix entire quantity under vacuum of 0.5 to 5 mbar for 1-2 hours.
- Now Individual premixes are ready. The individual premixes can be stored at elevated temperature (about 50°C) for up to 1 week, depending on formulation. Intermittent agitator/stirring during storage is advisable to prevent the filler settling.
- It is advisable to pre-heat the components at 100 – 110 °C and carry out the potting process under vacuum.
- Follow the suggested curing schedule. (Refer Sr.No -4)

3. Known equipment manufacturers



1. HUBERS VM GmbH
-

4. Recommended curing schedule:

Products / Systems	Curing Schedule
Dobefil 60 + Hardener 7055 + Acc.803 M	2 h / 80°C + 3 h / 105°C.
Shimorez 400 + Elan-tron WH 95 + Acc.01 + Filler	2 h / 80°C + 3 h / 105°C.

5. Do's:

- Always store the Resin, Hardener & Accelerator under shed as received.
- The Resin, Hardener & Accelerator must be kept away from any exposure to humidity.
- Ensure that the lids of Resin, Hardener & Accelerator containers are closed tight after use.
- Work place should be clean and well ventilated.
- Workmen should wear protective goggles and gloves.
- Workmen wash their hands with soap & water on completion of job.
- Stir the pre-filled resin part before use.
- In case of splashes in eyes, wash with plenty of water & take immediately medical help.

Don'ts:

- Avoid storage outside.
- Resin, Hardener & Accelerator should not be stored together.
- Don't keep Resin, Hardener & Accelerator containers open.
- Don't Inhale the Hardener & Accelerator.
- Do not eat at work place.

6. Technical Data Sheets (TDS) and Material Safety Data Sheets (MSDS)

TDS & MSDS of relevant products will be available upon request.

7. Company Profile

ELANTAS Beck India Ltd. is a group company of ELANTAS Electrical Insulation Division of ALATNA AG, Germany, an International Specialty Chemical Group currently having 42 operational companies and 46 application and research laboratories worldwide.

In 2006, ELANTAS Beck India completed 50 years of operations in India. The company manufactures a wide range of specialty chemicals for electrical insulation and construction industries. In pursuit of ALTANA's global commitment, ELANTAS Beck India develops new products and processes to meet the changing needs of customers; and utilizes its strengths effectively to be MANUFACTURERS OF RELIABILITY.

Our leadership status ensures we translate our leading technological capabilities and consistent quality standards to the advantage of our customers through contemporary and reliable products and solutions.

Our wide products profile is well supported by comprehensive Technical Service, and an All India Authorised Distributor Network.

ELANTAS Beck India Ltd. has been accredited with the International Quality Management System ISO 9001:2000, Environment Management System Certification ISO 14001:2004 and Occupational Health & Safety Management System BS 18001 : 2007.

8. Manufacturing sites in India



Pimpri, Maharashtra



Ankleshwar, Gujarat



ELANTAS Beck India Ltd.

Technical Services:

147, Mumbai-Pune Road, Pimpri, Pune 411018, India
Tel +91 20 30610 731 / 732. Fax +91 20 30610 880

Regional Sales Offices:

- Bengaluru: Tel: (080) 2528 1649, 2528 3093 Fax: + 91 80 2528 0831
- New Delhi: Tel: (011) 2341 1664, 2341 2940 Fax: + 91 11 2341 3408
- Pune: Tel: (020) 30610800 / 30610672 Fax: + 91 20 30610792
- Kolkata: Tel: (033) 2227 1841 Fax: + 91 33 2227 1843

Head Office & Export:

147, Mumbai Pune Road, Pimpri, Pune 411018, India.
Tel +91 20 30610 800, Fax +91 20 30610 792

www.elantas.com/beck-india