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## LEEPOXY 8-46

### Freon-resistant magnet wire patching epoxy

#### Description

LEEPOXY 8-46 is a proprietary Freon-resistant epoxy specifically developed for patching magnet wire coatings in refrigeration motors whose wires are scraped, nicked, or chipped, thus exposing the copper substrate. It is thixotropic enough not to drip or slump off the wire. After a room temperature set and either an immediate or subsequent post heat cure, LEEPOXY 8-46 forms a highly-cross-linked plastic with excellent adhesion, mechanical and electrical properties. Resistance to Freon is excellent, but only with sufficient post cure. Post cure can occur during dehydration, varnish cure, or other processes any time prior to exposure to Freon.

#### Directions for Use

Since only small quantities of patching compound may be needed, it is important that the two components of 8-46 be weighed accurately and mixed thoroughly. Weigh into a clean, dry vessel 100 parts of Part A and 19 parts of Part B. Mix thoroughly, scraping the sides and bottom of the vessel continuously. Wipe the area to be coated with a clean cloth wetted with xylene or methyl ethyl ketone. Let dry several minutes; then apply the mixed 8-46 A/B epoxy. If the component is to go through a dehydration process or a subsequent varnish

dip with a 1 - 2 hour cure at 250° – 275°F, then only a room temperature set of the patching compound is necessary at the time of application. In any event, optimal performance properties are realized by post-gel cure at elevated temperature any time prior to exposure to Freon or to other harsh refrigerants. See cure cycles suggested below.

Typical Properties		
	8-46 A	8-46 B
Appearance	Burgundy paste	Colorless liquid
Mix ratio, by weight	100	19
Thixotropy, 25°C, cps	1,960,000	20
Viscosity, 25°C, cps	280,000	20
Shelf Life, months	12	12
Density, lbs/gal	9.0	8.0

Typical Handling Properties	
Gel Time, 25°C, 100 g, min.	45
Work Life, 25°C, 20 g, min.	60 – 120
Cure Time, 125°C, hours	2
Suggested Cure Schedules	4 hours @ 100°C
	2 hours @ 125°C
	1 hour @ 150°C

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