

**Technical Data:**Issued: Oct.2008  
Revision 4: March, 2023 Page: 1**Resin EP 333/ Hardeners EPC 69-74 /  
EPC 2264-9/EPC 1455****Product  
Description**

EP 333 is a medium viscosity potting and encapsulating epoxy compound. It displays high physical and electrical properties.

EP 333 can be applied with various curing agents depending on customer requests.

**Features & Benefits**

- Room temperature cured
- Suitable for manual and automatic mixing
- Good mechanical properties

**Applications**

High voltage/High power electrical and electronic potting and encapsulating

**Typical  
Uncured  
Properties**

Note:

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

	<b>BASE</b>	<b>Hardeners, EPC</b>		
	<b>EP 333</b>	<b>69-74</b>	<b>2264-9</b>	<b>1455</b>
<b>Appearance</b>	Viscous liquid	liquid	liquid	liquid
<b>Color</b>	black/red	yellowish	yellowish	amber
<b>Viscosity @25°C, mPa*s</b>	7000	100	350	1300
<b>Density, g/cm<sup>3</sup></b>	1.55	1.0	1.0	1.0

**Instructions  
for use**

Premix the EP 333 prior to use in the original container.

Weigh required amount of resin and hardener into a clean container in the recommended ratio. Blend thoroughly being careful to scrape sides and bottom of the container for 3-4 minutes to ensure uniform mixture.

To produce a void-free casting the mixture should be deairing at 2-5 mmHg for 3-4 minutes to remove trapped air.

Pour the mixture into mold.

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Processing	Hardeners		
	EPC 69/74	EPC 2264-9	EPC 1455
Mix Ratio, w/w	100:13	100:10	100:12
Mix Viscosity @ 25°C, mPa*s	2500-4000	3000-5000	5000-6500
Pot life @ 25°C, (100g), min	20-25	15-20	20-25
Gel Time @ 25°C, (100g), min	25-35	20-25	25-35
Typical Curing Schedule	24hr/RT	24hr/RT + 4hr/80°C	24hr/RT

Cured Properties*	Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.		
	Hardness, Shore D	84-88	85-90
Tensile Strength, MPa	37-43	45-50	45-50
Tensile Elongation, %	0.5-1.0	0.3-1.3	0.4-1.6
Flexural Strength, MPa	70-83	72-90	70-100
Flexural Module, MPa	5000-6000	5000-6000	5000-5800
HDT, (0.45MPa), °C	59	69	66
Service temperature, °C	-30 to 90	-30 to 120	-30 to 90
Thermal Conductivity, W/m-K	0.38-0.42		

\*) The data obtained after at least 7 days

**Storage** Store products at 20-35°C for maximum shelf life.  
Certain resins and hardeners are susceptible to crystallization. If crystallization occurs, warm the container to 50-60°C until the crystals have dissolved.  
Stir and allow content to cool to room temperature before use.

**Packaging** Packaging sizes are available from 1L up to 18L pails.

**Shelf Life** These products have a shelf life of 12 months in their unopened original bulk containers.

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