- TECHNICAL DATA SHEET -

HI-THERM BC-325

CLEAR BAKING VARNISH 200°C

DESCRIPTION

HI-THERM BC-325 is a phenolic-based varnish modified with polyester resin.
It has the following outstanding properties:

- Fast curing cycles.
- Tough, smooth, glossy film on which the dust does not adhere.
- High bond strength.
- Excellent oil resistance.
- High dielectric strength.
- U.L. recognized varnish.

Recommended uses

Due to its fast cure and tough film, HI-THERM BC-325 is suggested as a good general purpose varnish.
It is particularly recommended for:

Rotating machinery	Welding transformers	Transformers
Stators	Low and medium speed rotors	

CHARACTERISTICS

Physical properties

Color	clear
Specific gravity at 25°C	970±30 g./l.
Viscosity in Din Cup n.4 at 25°C	30-40"
Viscosity in Demmler Cup n.1 at 30 °C	28-38''
Build-up, D.F.T. (ASTM D-115-55)	0,065-0,090mm.
Thinner	Dolph's T-200
Baking time at 135°C on a copper strip (ASTM D-115-55)	45'
Baking time at 135°C in a 20 grams test cup	60'
Corrosive effects on copper	none
Solids content	47±2%

Electrical properties

Dielectric strength (dry)	3.400Volts/mm.0,025
Dielectric strength after 24h. immersion in water	2.800Volts/mm.0,025

Chemical resistance

Water	Excellent
Acid (10% sulfuric acid)	Excellent
Alkali (1% sodium hydroxide)	Excellent
Salt water	Excellent
Mineral oil (ASTM D-115-55)	Passed

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APPLICATION

HI-THERM BC-325 is suitable for both atmospheric pressure and under vacuum impregnations.
The following cycle is recommended as a starting point in the treatment at atmospheric pressure of most units:

1. Preheat units to 110°C;
2. Cool to 65-70°C;
3. Dip into the varnish for 15-30';
4. Drain 15-30' (to obtain a high build-up, we suggest to shorten the draining period);
5. Place in the oven and bake according to one of the following cycles:

2 – 3 h. at 135°C	1 – 2 h. at 150°C	½ - 1 h. at 160°C

(Time must be taken after the unit reaches the baking temperature).

For specific conditions, please consult us.

GENERAL PROPERTIES

Compatibility with magnet wire coatings

HI-THERM BC-325 is compatible with the following magnet wire coatings:

Polyvinyl Formal	Epoxy	Polyvinyl Formal-Polyamide
Amide-Imide	Polyester	Polyurethane-Polyamide
Polyamide	Polyimide	Polyester Amide-Imide
Polyurethane	Textile	

Heat life HI-THERM BC-325 has a heat life of 20.000h. at 200°C, as determined by ASTM3251 (twisted pairs) specifications.

Solvent Thin with Dolph's T-200.

Impregnation ability Excellent wetting properties assure maximum penetration using either atmospheric or vacuum impregnating systems.

Dip tank stability Long use experiences has proven HI-THERM BC-325 to have an excellent dip tank stability, even in the worst using conditions.

Warning: All the information and application instructions concerning this product are based on technical specifications that we consider reliable, and are provided by way of example, according to our application experience. They do not establish any guarantee but only represent a starting point subject to alterations, according to the application and the kind of material to be treated. Before the product's use the user must determine the suitability for the intended use undertaking all risks and responsibility for whatever may happen in connection with the application. The producer and/or seller will not be considered responsible for any accident, loss or damage (immediate or consequent) originating from the use and/or the inability to use the concerned product. Albesiano Sisa Vernici srl reserves the right to change or modify at any time and without any notice the technical specifications of the product described in this data sheet.

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