



Technical Data Sheet

Secondary Insulation

Esterlite™ 605

Precatalyzed Polyester Impregnating Resin

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Esterlite™ 605

Product Description

Esterlite™ 605 is a pre-catalyzed, heat-cured unsaturated polyester resin.

Areas of Application

Impregnation of form wound and random wound motor and generator coils

Features and Benefits

- Outstanding bond strength at high temperature
- Excellent tank stability
- High flash point
- Resistant to R-22, R-134a and R-123 refrigerants

Application Methods

Vacuum-Pressure Impregnation (VPI)
Dip-and-Bake

Transportation / Storage

Store below 25°C / 77°F in a dry controlled environment out of direct sunlight. This material should be suitable for use stored under these conditions in the original sealed containers for twelve (12) months from the date of shipment. Failure to store the product as recommended above may lead to deterioration in product performance.

Health / Safety

Refer to the Material Safety Data Sheet.

Typical Properties of Material as Supplied

Property	Conditions	Value	Units
Viscosity	25°C / 77°F	600 – 1000	cP
Density	ASTM D1475	9.6	lbs/gal
Flash Point	ASTM D93	>93 >200	°C °F

Cure Schedule

2 hours at 175°C (347°F), 4 hours at 150°C (302°F) or 6 hours at 135°C (275°F)
 4 hours at 150°C (302°F) plus 2 hours at 180°C (356°F) for rotors, armatures and hermetic applications
 Cure schedule is based on time after unit reaches specified temperature



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Typical Mechanical Properties (hermetic cure schedule)

Property	Conditions	Value	Units
Helical Coil Bond Strength ASTM D2519 over MW 35	25°C / 77°F	41	pounds
	150°C / 302°F	21	pounds
Hardness	Shore D at 25°C / 77°F	85	

Typical Electrical Properties (hermetic cure schedule)

Property	Conditions	Value	Units
Dielectric Strength	ASTM D149 – 0.5 mils	6700	volts/mil
Dielectric Strength	ASTM D149 – 0.5 mils After 24 hours in water	4300	volts/mil

The above properties are typical values and are not intended for specification use.

ELANTAS PDG, Inc. warrants the chemical composition of its products within stated tolerances, but does not guarantee that a product will be appropriate for any particular application. Any recommendation, performance of tests or suggestion is offered merely as a guide and is not a substitute for a thorough evaluation by the user. No representative of ELANTAS PDG, Inc. has the authority to offer a warranty that a product will perform satisfactorily in manufacturing a product and no such representation should be relied upon.