

**Processing Guide
Secondary Insulation**

**PG-128 –
Dip Polyester Resin**

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Process Step	Optimum	Minimum	Comments
<i>Preheat</i>	1 hour at 135 - 150°C(275 - 300°F) Once unit reaches temperature	None	Relax magnet wire, drives out moisture, thermosets tapes, assists in penetration
<i>Part Temperature when submerged into resin</i>	25 – 30°C (77 - 86°F)	25 – 30°C (77°F – 86°F)	Temperature has a direct bearing on varnish penetration. If too low resin will not penetrate fully. If too high resin can be damaged
<i>Submerge Units</i>	4 inches per minute	Slow as possible	Hold to 10 – 15 minutes or until bubbles cease
<i>Raise units</i>	4 inches per minute	Slow as possible	Slow removal allows good flow
<i>Drain Time</i>	10-15 minutes	None	Longer drain will re-capture more resin.
<i>Cool Resin</i>	Agitate to 18-25°C (65-77°F)	Agitate to 25-27°C (75 - 80°F)	Keeping material cool improves tank life
<i>Bake Schedule</i>	As recommended by product data sheet.	As recommended by product data sheet.	Full cure is required to develop all performance properties.

Please contact ELANTAS PDG, Inc. Technical Service if you have any questions.

Phone number 1.314.621.5700 Extension 717 or 1.800.325.7492 Extension 717

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

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