

## 8. ADHESIVES **ELFIX**/ Epoxy adhesives/ **ELFIX 410 1K-T**



CABLES



IMPREGNANTS



WIRES



RESEARCH

### Application:

ELFIX 410 1K-T is suitable for bonding of magnets of rotors, alternators and high speed rotating machines for household appliances of class F-H.

### Characteristics:

Elfix 410 1K-T is one component adhesive based on modified epoxy resin. It is typical for its low „VOC = 0“, high bond strength and short time of curing at 160 °C.

### Processing data:

Density (DIN 53 217)	20 °C	[kg/m <sup>3</sup> ]	1150 - 1450
Viscosity (at shear rate 1,5 s <sup>-1</sup> )	40 °C 60 °C	[Pa.s]	135 ± 20 45 ± 10
Shelf life	max. 25 °C	[mesiace]	min. 6
Flash Point (AP)		[°C]	min. 140
Gel time <sup>1)</sup>	160 °C	[min]	17 - 18
Time of curing <sup>3)</sup>	160 °C	[min]	45 - 60



F-11.1.22-30-2/11en

## 8. ADHESIVES **ELFIX**/ Epoxy adhesives/ **ELFIX 410 1K-T**



CABLES



IMPREGNANTS



WIRES



RESEARCH

### Properties after cure:

Curing of test specimen	140 °C	[h]	2
Electric strength <sup>1), 5)</sup>	23 °C after 96 h in 92 % r. v. 23 °C	[kV/mm]	
Dissipation Factor <sup>2)</sup>	23 °C 130 °C	[%]	
Bond strenght <sup>1)</sup>	25 °C 155 °C 180 °C	[MPa]	11,4 ± 0,3

1. DIN 16 945 Verfahren A

2. DIN 46 448 Blatt 1

3. since 130 °C in the winding reached

4. STN 67 31 50 čl. 11, meth. B, after  
60 min at 60 °C

5. Test samples A2, electrodes ø6 mm

6. STN EN 1465

### Packing and storage:

ELFIX 410 1K - T is delivered in clean, non returnable drums in the amount agreed between the producer and client. The product has to be stored in tightly closed drums at temperature max. +10 °C.

The information provided herein accords with our knowledges about the subject on the date of publication. This information might be revised if new knowledges and experience will be available. The data provided fall within the normal range of product properties are related only to the specific material. These data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to set limits or used alone as the basis for design. The data are not intended for substitute of any testing that you might need to do for decision if the specific material is suitable for your particular purposes. Since VUKI ca not anticipate all variants in actual end-use conditions, VUKI makes no warranties and assumes no liability in connection with any use of this information. Nothing in this document is to be considered as a license to application or recommendation to infringe any patent rights.

F-11.1.22-30-2/11en



**VUKI**  
SINCE 1950