

Resin

Permafil® 277

- ▶ Use on cold or hot parts
- ▶ Rapid room temperature drying
- ▶ Compatible with a wide variety of varnishes and resins
- ▶ No VOCs

General description

Permafil® 277 is a unique thixotropic masking agent formulated using DuPont™ Krytox®. It is used for coating horizontal and vertical surfaces before treatment to aid in the easy removal of a wide variety of cured insulating resins including solventless epoxies and polyesters.

Application

Permafil® 277 masking compound is suggested for use on surfaces where adhesion of a cured resin is not desired. It may be applied to lamination surfaces, end shields, machined surfaces, armature shafts*, transformer feet, lug connections, etc.

It quickly dries to a very thin white coating that is easily removed by with fluorinated solvents or by mechanical means such as abrasion (steel wool) and machining.

It can be diluted with IPA if necessary.

Permafil® 277 also acts as a lubricant resulting in a slip plane for press fit bearings, gears, etc.

Processing

Permafil® 277 may be applied by brushing or dipping. A thin film is applied on the area to be masked and allowed to dry prior to resin treatment. After the bake cycle, the resin can be easily removed with a scraper or wire brush. Best results are achieved while the unit is still warm. Thin films will dry in 30 minutes or less. Adequate ventilation improves drying, as does allowing adequate spacing of coated pieces to avoid crowding.

Storage Conditions

Permafil® 277 can be expected to remain stable and perform acceptably when stored for periods of up to one year @ 77°F in the original sealed container. There will be slight settling of the material in storage. The material should be mixed thoroughly before use for best results. IPA may be added to reduce viscosity.

	Value	Test norm
Physical properties		
Viscosity (Brookfield) 77°F (25°C) 2.5 rpm	cps	2500
Viscosity (Brookfield) 77°F (25°C) 20 rpm	cps	400
Thixotropic Index		6-7
Solid content	%	14-16
Flash point	°F (°C)	55 (11) Pensky-Martens Closed Cup
Weight		
Total weight	lbs/gal. (kg)	7.4 (3.4)

Order Data

This product is available in pints, quarts or gallons from Von Roll USA, Inc. or from authorized Von Roll distributors. For the name of your distributor or for more information on this product, contact our Customer Service department, (518) 344-7100.

Standards

The properties shown in this data sheet are typical values only, and should not be used as a basis for preparing specifications. Contact our Customer Service department, (518) 344-7100 for assistance in preparation of specifications for your specific system application.

Health and safety

Material Safety Data Sheets defining the known hazards and describing safety precautions appropriate for this product are available upon request from Von Roll USA, Inc., 200 Von Roll Drive, Schenectady, New York 12306 (518) 344-7100. Similar information sheets for solvents and other chemicals used with this product may be obtained from the appropriate supplier and used accordingly.

Specifications

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The product properties set forth in this data sheet are based on the results of testing of typical material produced by the affiliated companies of Von Roll Holding Ltd. (underneath referred as Von Roll). Some variation in product properties is typical. Comments or suggestions relating to any subject other than product properties are offered only to call the end-user's or other person's attention to considerations which may be relevant in the independent determination of the use and/or manner of use of product. Von Roll does not claim or warrant that the use of its product will have the results described in this data sheet or that the information provided is complete, accurate or useful. The user should test the product to determine its properties and its suitability for the intended use. Von Roll expressly disclaims any liability for any damage, harm, injury, cost or expense to any person resulting directly or indirectly from that person's reliance on any information contained in this data sheet. Nothing contained in this data sheet constitutes representation or warranty as to any matter whatsoever. Von Roll makes no warranties whatsoever in this data sheet, expressed or implied, including any implied warranty or fitness for a particular use or purpose. Von Roll shall in no event be liable for incidental, exemplary, punitive or consequential damages.