



## **Olsun Electrics Corporation**

10901 Commercial Street • P.O.Box 1

Richmond, Illinois 60071-0001

Phone: (815) 678-2421 • FAX: (815) 678-4909

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### **Vacuum Pressure Impregnation Process (VPI) Process**

The Olsun Electrics vacuum impregnation process (VPI) is a multi-step procedure.

1. Completed transformer windings (coils) are placed into a vacuum chamber. A vacuum of no less than 29 inches of mercury is drawn on the coil assemblies and maintained for a minimum of one hour.
2. The chamber is then flooded with a 100% solids, epoxy resin which fully submerses the coils.
3. A vacuum of 29 inches of mercury is again drawn on the chamber and held for two hours.
4. The vacuum is released and a pressure of 80 PSI (minimum) is applied to the chamber for at least 30 minutes.
5. The pressure is released and the coils removed from the chamber.
6. The coils are placed into an oven at 285 degrees F for nine hours for curing.
7. Upon completion of the assembly of the VPI coils and the transformer core, a final dip coat of Epoxylite 468-2 resin is applied to the entire assembly.

### **Material (Epoxy Type) Utilized**

The epoxy resin used in the Olsun Electrics VPI process is Epoxylite Corporations "468-2FX", and the final dip coat is Epoxylite "468-2" resin.