Technical Data Sheet

LOCTITE® STYCAST 1267

October 2020

PRODUCT DESCRIPTION

LOCTITE® STYCAST 1267 provides the following product characteristics:

Technology	Epoxy
Appearance	Transparent
Components	Two components
Mix Ratio by weight: Part A: Part B	100 : 28
Product Benefits	• Transparent • Low viscosity • Toughness • Impact resistance • Long pot life • Low exotherm • Room temperature cure capability • Good moisture resistance • Good electrical properties • Excellent adhesion to a variety of substrates
Cure	Room temperature cure
Application	Electronic Encapsulants, Potting, Casting

LOCTITE® STYCAST 1267 epoxy encapsulant may be used for display embedments, to bond lenses and sheets of glass for good visibility, and to impregnate windings.

This adhesive can withstand continuous exposure at temperatures as high as 95ºC and short term exposures up to 120ºC with only slight discolouration and no deleterious effects on physical and electrical properties.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Mixed Properties :

Density, g/cm³	1.15
Mixed Viscosity @ 25 ºC, mPa·s (cP)	500
Refractive Index	1.56
Pot Life , minutes	30
Shelf Life @ 25ºC, days	365

TYPICAL CURING PERFORMANCE

Cure Schedule
8 hours @ 25°C

Post Cure
2 hours @ 95°C

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties :

Hardness, Shore D		77.5

Electrical Properties:

Dielectric Strength , kV/mm		15.8
Dielectric Constant / Dissipation Factor @ 1 MHz		3/0.02
Volume Resistivity @ 25°C, ohm-cm		>1×10^{14}

Adhesive Properties:

Compressive Strength	N/mm²	80
	(psi)	(11,600)
Flexural Strength	N/mm²	120
	(psi)	(17,400)

GENERAL INFORMATION

Please consult the Safety Data Sheet (SDS) for safe handling information of this product.

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

DIRECTIONS FOR USE

1. Long exposure of the cured resin to temperatures above 120°C will cause some discolouration. Physical and electrical properties are not appreciably effected.
2. Prepare materials and mold for use.
3. Add 28 parts of Part B to 100 parts by weight of Part A. Mix thoroughly. Pot life will be about 30 minutes. Use small batches. Use multiple pouring for castings over 100 grams.
4. Pour. Use vacuum evacuation if necessary.
5. Allow to stand at room temperature for 8 hours. The casting can be removed from mold when hard. A post cure at 95°C for 2 hours will increase the hardness of the cured resin and its dielectric strength.
6. Curing at temperatures od 50 to 65°C to speed production is possible, and depends both on resin mass, and the geometry of the unit to be potted. To determine optimum conditions, user should run a few experiments on the particular unit.

Storage

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

Optimal Storage: 25°C. Storage below 25°C or greater than 25°C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel Representative.

Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb/F
N/mm x 5.71 = lb/in
psi x 145 = N/mm²
MPa = N/mm²
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

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