

LOCTITE STYCAST 3050 CAT 11

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PRODUCT DESCRIPTION

LOCTITE STYCAST 3050 CAT 11 provides the following product characteristics:

Technology	Epoxy
Appearance (Resin)	Dark red
Components	Two components - requires mixing
Product Benefits	<ul style="list-style-type: none"> • Very low viscosity • Excellent penetration into tightly packed assemblies • Good machinability • General purpose • Long pot life • Excellent chemical resistance • Good physical and chemical properties at elevated temperatures
Mix Ratio, by weight - Material:Catalyst	100 : 9
Mix Ratio, by Volume - Material:Catalyst	100 : 13
Operating Temperature	-55 to +155°C
Cure	Heat cure
Application	Encapsulation
Typical Assembly Applications	High density circuit assemblies, Coil windings

LOCTITE STYCAST 3050 CAT 11 is designed for potting and encapsulation applications with very small physical spacing between parts. The filler system is non-abrasive and readily machinable. This is a consideration when using a dispensing equipment or where subsequent machining of the cured part is required.

LOCTITE STYCAST 3050 can be used with a variety of catalysts. For more information on mixed properties when used with other available catalysts, please contact your local technical service representative for assistance and recommendations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties LOCTITE STYCAST 3050

Viscosity, Brookfield, ASTM D2393, mPa·s (cP)	2,000
Density, ASTM-D-792, , g/cm ³	1.61
Shelf Life @ 25°C, months	6
Flash Point - See SDS	

Part B Properties LOCTITE CAT 11

Viscosity @ 65 °C, mPa·s (cP)	50
Flash Point - See SDS	

Mixed Properties LOCTITE STYCAST 3050 CAT 11

Viscosity, Brookfield, ASTM D2393, mPa·s (cP)	300
Density, ASTM-D-792, , g/cm ³	1.55
Working Life, 100 grams @ 25°C, hours	>4
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

8 to 16 hours @ 80°C or
2 to 4 hours @ 100°C or
30 to 60 minutes @ 120°C

For optimum performance at temperature above 2 to 4°C, a post cure of hours at °C is recommended.

Alternate cure schedules may also be possible. Contact your Henkel representative for further information.

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

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Hardness, Shore D, ASTM D2240	88
Coefficient of Thermal Expansion, ASTM D3386, 40 ppm/°C	
Thermal Conductivity, ASTM D-2214, W/(m-K)	0.4
Linear Shrinkage, ASTM D2566,, %	0.3

Electrical Properties

Volume Resistivity, ASTM D257, ohms-cm:	
@ 25°C	2×10 ¹⁴
@ 100°C	3×10 ¹⁴
Dielectric Strength, ASTM D149, kV/mm	15.7
Dielectric Constant/ Dissipation Factor, ASTM D150:	
@ 1 MHz	3.9/0.04

Outgassing Properties

Outgassing, ASTM E 595, per NASA Reference Publication 1124:	
Sample cured 15 hrs @ 25°C plus 8 hrs @ 65°C plus 4 hrs @ 100°C	
TML, %	0.84
CVCM, %	0.0

TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous:

Flexural Strength, ASTM D790	N/mm ²	34.5
	(psi)	(5,000)
Compressive Strength, ASTM-D695	N/mm ²	83
	(psi)	(12,000)
Tensile Strength, ASTM D412	N/mm ²	38
	(psi)	(5,500)

GENERAL INFORMATION

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

DIRECTIONS FOR USE

1. Complete cleaning of the components and substrates should be performed to remove contamination such as dust, moisture, salt and oils which can cause electrical failure, poor adhesion or corrosion in an embedded part.
2. Some separation of components is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use.
3. Power mixing is preferred to ensure a homogeneous product.
4. Accurately weigh resin and hardener into a clean container in the recommended ratio. Weighing apparatus having an accuracy in proportion to the amounts being weighed should be used.
5. Blend components by hand, using a kneading motion, for 2 to 3 minutes. Scrape the bottom and sides of the mixing container frequently to produce a uniform mixture.
6. If possible, power mix for an additional 2 to 3 minutes. Avoid high mixing speeds. This can entrap excessive amounts of air. It can also cause overheating of the mixture, resulting in reduced working life.
7. To ensure a void-free embedment, vacuum deairing should be used to remove any entrapped air introduced during the mixing operation.
8. Vacuum deair mixture at 1 to 5 mm mercury. The foam will rise several times the liquid height and then subside.
9. Continue vacuum deairing until most of the bubbling has ceased. This usually takes 3 to 10 minutes.
10. To facilitate deairing in difficult to deair materials, add drops of an air release agent, such as ANTIFOAM 88 into of mixture.
11. Gentle warming will also help, but pot life will be shortened.
12. Pour mixture into cavity or mold.
13. Gentle warming of the mold or assembly reduces the viscosity. This improves the flow of the material into the unit having intricate shapes or tightly packed coils or components.
14. Further vacuum deairing in the mold may be required for critical applications.

STORAGE:

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling. Usable shelf life may vary depending on method of application and storage conditions

Certain resins and hardeners are prone to crystallization. If crystallization does occur, warm the contents of the shipping container to 50 to 60°C until all crystals have dissolved. Be sure the shipping container is loosely covered during the warming stage to prevent any pressure build-up. Allow contents to cool to room temperature before continuing.

Optimal Storage : 25 °C

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 Technical Service Center or Customer Service 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

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\text{N} \times 0.225 = \text{lb/F}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{psi} \times 145 = \text{N/mm}^2$
 $\text{MPa} = \text{N/mm}^2$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

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Reference 0.6