

LOCTITE STYCAST E 2534 FR CAT 11

September 2014

PRODUCT DESCRIPTION

LOCTITE STYCAST E 2534 FR CAT 11 provides the following product characteristics:

Technology	Epoxy
Appearance (Resin)	blue
Components	Two components - requires mixing
Mix Ratio, (by weight)	100 : 5
Resin : Hardener	
Product Benefits	<ul style="list-style-type: none"> • Flame retardant • Halogen free • High thermal conductivity • High dielectric strength
Cure	Heat cure
Application	Potting
Operating Temperature - Continuous	-55 to 155°C
Operating Temperature - Intermittent	-55 to 155°C
UL Flammability Rating	UL 94 V-0 @ 6 mm thickness

LOCTITE STYCAST E 2534 FR CAT 11 epoxy potting compound complies with recent demands on environmentally friendly products and does not contain brominated flame retardants.

LOCTITE STYCAST E 2534 FR CAT 11 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 E 2534 FR

Viscosity @ 25 °C, mPa·s (cP)	300,000 to 400,000
Specific Gravity	2.1
Shelf Life @ 18 to 25°C, year	1
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

16 hours @ 75°C or
2 hours @ 100°C or
1 hour @ 150°C

Post Cure

4 hours @ 150°C

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

Coefficient of Thermal Expansion, TMA:	
Below Tg, ppm/°C	37
Glass Transition Temperature (Tg) by TMA, °C	115
Thermal Conductivity, W/(m·K)	1.2
Hardness, Shore D	>90
Water Absorption @ 25°C after 24 hours, %	0.01

Electrical Properties

Dielectric Constant / Dissipation Factor :	
60Hz	6.2 / 0.03
1 kHz	6.0 / 0.02
1 MHz	5.6 / 0.02

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Some filler settling 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. Power mixing is preferred to ensure a homogeneous product.
2. Moderate warming to maximum 75°C of the resin prior to adding the hardener will improve pourability.
3. Pour mixture into cavity or mold.
4. **IMPORTANT:** DO NOT USE CATALYST 27-1 as this hardener is not compatible with the filler, and will cause foaming.

STORAGE:

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage : 18 to 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 $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$ $\text{kV/mm} \times 25.4 = \text{V/mil}$ $\text{mm} / 25.4 = \text{inches}$ $\text{N} \times 0.225 = \text{lb/F}$ $\text{N/mm} \times 5.71 = \text{lb/in}$ $\text{psi} \times 145 = \text{N/mm}^2$ $\text{MPa} = \text{N/mm}^2$ $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$ $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$ $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$ $\text{mPa}\cdot\text{s} = \text{cP}$ **Disclaimer****Note:**

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Reference 2

Americas
+1.888.943.6535

Europe
+32.1457.5611

Asia
+86.21.2891.8000

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