

LOCTITE STYCAST EE 4183/ HD 0242

August 2019

PRODUCT DESCRIPTION

LOCTITE STYCAST EE 4183/ HD 0242 provides the following product characteristics:

Technology	Epoxy
Appearance, Resin (Component A)	Tan
Appearance, Hardener (Component B)	Dark amber
Appearance (cured)	Tan
Components	Two components - requires mixing
Product Benefits	<ul style="list-style-type: none"> Improved thermal conductivity High heat distortion
Mix Ratio, (by weight) Resin : Hardener	100 : 8
Mix Ratio, (by volume) Resin : Hardener	100 : 12
Cure	Heat cure
Application	Encapsulation and Potting

LOCTITE STYCAST EE 4183/ HD 0242 is a filled system specifically formulated to improve thermal properties. This system is used to encapsulate resistors, coils and similar components that require high heat distortion temperatures.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties LOCTITE STYCAST EE 4183

Viscosity, Brookfield - RVF, 25 °C, cps:	
Spindle 6, speed 4 rpm	80,000
Density @ 25°C, gm/cc	1.6
Filler Content, %	49
Shelf Life @ 25°C (from date of shipment), 180 days	
Flash Point - See SDS	

Part B Properties HD 0242

Viscosity, Brookfield - RVF, 25 °C, cps:	
Spindle 2, speed 20 rpm	80
Density @ 25°C, gm/cc	1.03
Filler Content, %	0
Shelf Life @ 25°C (from date of shipment), 365 days	
Flash Point - See SDS	

Mixed Properties

Viscosity @ 25 °C, cps:	
Spindle 4, speed 2 rpm	25,000
Pot Life, 200 gm mass, @ 25 °C, minutes	55
Gel Time, 200 gm mass @ 40 °C, minutes	25
Gel Time, 10gm mass @ 100 °C, minutes	5.5
Gel Time, 10 gm mass @ 121 °C, minutes	3.0
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE AS MIXED

Recommended Cure Schedule

1 hour @ 40°C plus 2 hours @ 150°C

Alternate Cure Schedule

Gel @ 25 °C plus 2 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 AS MIXED

Physical Properties :

Coefficient of Linear Thermal Expansion, in/in/°C x 10 ⁻⁶ :	
@ 25 to 90°C	51
Thermal Conductivity, cal x cm/sec x cm ² x °C, 10 ⁻⁴	13.5
Glass Transition Temperature (Tg), °C	118
Hardness, Shore D	93
Linear Shrinkage, %	0.85
Moisture Absorption, 24 hrs immersion, %	0.07
Guide to Operating Class, IEEE °C	155

Electrical Properties:

Dielectric Strength, volts/mil	1,400
Arc Resistance, seconds	183
Volume Resistivity, ohm-cm:	
@ 25 °C	1.5×10 ¹⁶
@ 85 °C	1×10 ¹⁴
@ 130°C	1×10 ¹³
Surface Resistivity, ohms:	
@ 25 °C	8.8×10 ¹⁵
@ 85 °C	8×10 ¹⁴
@ 130°C	2×10 ¹³

Dielectric Constant / Dissipation Factor @ 25°C:

@ 100 Hz	4.2/0.008
@ 1 kHz	4.2/0.012
@ 10 kHz	4.1/0.02
@ 100 kHz	3.9/0.021

Dielectric Constant / Dissipation Factor @ 85°C:

@ 100 Hz	4.5/0.007
@ 1 kHz	4.4/0.006
@ 10 kHz	4.4/0.007
@ 100 kHz	4.3/0.014

Dielectric Constant / Dissipation Factor @ 130°C:

@ 100 Hz	4.6/0.023
@ 1 kHz	4.5/0.01
@ 10 kHz	4.4/0.006
@ 100 kHz	4.4/0.006

TYPICAL CURED PERFORMANCE AS MIXED

Tensile Strength	N/mm ²	55.2
	(psi)	(8,000)
Compressive Strength	N/mm ²	155
	(psi)	(22,500)
Flexural Strength	N/mm ²	115
	(psi)	(16,640)

GENERAL INFORMATION

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

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.

STORAGE:

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

Liquid Storage - Liquids should be stored at 25°C or below, in closed containers. If stored below 25°C, the material MUST be allowed to come to room temperature, in the sealed container, to avoid moisture contamination.

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.

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:**

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:

In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana, S.A.S. the following disclaimer is applicable:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation, Resin Technology Group, Inc., or Henkel Canada Corporation, the following disclaimer is applicable:

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage: [Except as otherwise noted] All trademarks in this document are trademarks and/or registered trademarks of Henkel and its affiliates in the U.S. and elsewhere.

Reference 1