

# LOCTITE STYCAST ES 1904

November 2016

**PRODUCT DESCRIPTION**

LOCTITE STYCAST ES 1904 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance (cured)</b>	Opaque
<b>Components</b>	Two components - requires mixing
<b>Mix Ratio, by volume - Part A: Part B</b>	2 : 1
<b>Mixing Ratio, by weight Component A: Component B</b>	100 : 46
<b>Cure</b>	Room temperature cure
<b>Application</b>	Potting and Encapsulating

LOCTITE STYCAST ES 1904 is an opaque, medium-viscosity epoxy resin formulation recommended for small potting and laminating applications, excellent structural, mechanical and electrical properties are required. This two-part adhesive exhibits good wetting, cures at room temperature and develops strong, low shrinkage bonds to most materials including optical fibers, glass ceramics, most metals. It has excellent dimensional stability over a wide temperature range. This product is typically used in applications with an operating range of -60 °C to +125 °C.

**TYPICAL PROPERTIES OF UNCURED MATERIAL****Part A Properties**

Density, @ 25 °C, g/cm <sup>3</sup>	1.19
Viscosity @ 25 °C, cP	25,000

**Part B Properties**

Density, @ 25 °C, g/cm <sup>3</sup>	1.09
Viscosity @ 25 °C, cP	50,000

**Mixed Properties**

Pot Life @ 25 °C, minutes:	
100 g mass	8 to 10
Gel Time @ 25 °C, minutes:	
100 g mass	9 to 14
Specific Gravity	1.15
Viscosity @ 25 °C, cP	40,000

**TYPICAL CURING PERFORMANCE****Recommended Curing Conditions**

- 12 to 24 hours @ 25 °C (Recommended cure)
- 2 hours @ 65 °C (Alternate cure)
- 1 hour @ 100 °C (Alternate cure)

**TYPICAL PROPERTIES OF CURED MATERIAL****Physical Properties :**

Glass Transition Temperature, °C	80
Coefficient of Thermal Expansion, ppm/°C:	
Pre Tg (Alpha 1)	68
Post Tg (Alpha 2)	190
Shore Hardness , Durometer D	90
24 Hour Water Moisture Absorption, %	0.3
Tensile Elongation, %	6
Tensile Strength, psi	9,900
Compressive Strength, psi	19,000
Flexural Strength, psi	14,500

**Electrical Properties:**

Dielectric Strength, volts/mil	1,640
Volume Resistivity, ohm-cm	3×10 <sup>16</sup>
Surface Resistivity, ohms @ 25°C	3×10 <sup>16</sup>
Dielectric Constant / Dissipation Factor @ 25°C:	
1 kHz	4.0 / 0.009

**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.

**Note:** Before using this product please purge approximately 30 ml. of material prior to application. Discard purged material in accordance with the Material Safety Data Sheet. A video instruction is available upon request.

**STORAGE:**

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

**Optimal Storage: 20 °C to 30 °C. Storage below 20 °C or greater than 30 °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 Technical Service Center or Customer Service Representative.

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

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