

# LOCTITE STYCAST ES 2510

August 2013

## PRODUCT DESCRIPTION

LOCTITE STYCAST ES 2510 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance (Resin)</b>	Beige liquid
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• General purpose</li> <li>• Low viscosity</li> <li>• Flame retardant</li> <li>• Excellent dielectric properties</li> <li>• RoHS compliant</li> </ul>
<b>Cure</b>	Heat cure
<b>Application</b>	Encapsulant and Potting
<b>Flammability Rating</b>	UL 94 V0 @ 3 mm thickness

LOCTITE STYCAST ES 2510 is a dielectric grade epoxy encapsulant designed for general purpose applications. It is suitable for potting and encapsulating electrical devices that require flame retardancy.

LOCTITE STYCAST ES 2510 is the RoHS compliant version of STYCAST LA-9823-76.

LOCTITE STYCAST ES 2510 can be used with LOCTITE CAT LA 9823-76.

## CATALYST DESCRIPTION

LOCTITE CAT LA 9823-76 provides the following product characteristics:

<b>Cure</b>	Heat cure
Mix Ratio, by weight - Material:Catalyst	100 : 57
Mix Ratio, by Volume - Material:Catalyst	100 : 87

## TYPICAL UNCURED PROPERTIES

### LOCTITE STYCAST ES 2510

Density @ 25 °C, g/cc	1.43
Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):	
Spindle 4, speed 10	4,700
Shelf Life @ 25°C (from date of manufacture), days	274
Flash Point - See MSDS	

## TYPICAL UNCURED PROPERTIES AS MIXED

### LOCTITE STYCAST ES 2510 with LOCTITE CAT LA 9823-76

Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):	
Spindle 4, speed 10 rpm	5,500
Work Life , 100 grams, @ 25°C, hours	2.5
Flash Point - See MSDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

**LOCTITE STYCAST ES 2510 with LOCTITE CAT LA 9823-76**  
2 hours @ 60°C

For optimum performance, follow the initial cure with a post cure of 16 hours @ 40°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

### LOCTITE STYCAST ES 2510 with LOCTITE CAT LA 9823-76

#### Physical Properties

Hardness, Shore D	70
Coefficient of Linear Thermal Expansion, ppm/°C:	
Below Tg	64
Above Tg	194
Glass Transition Temperature, °C	18
Operating temperature range, °C	-40 to +150
Compressive Strength	N/mm <sup>2</sup> (psi)
	124 (18,000)
Linear Shrinkage, %	0.13

#### Electrical Properties

Volume Resistivity @ 25 °C, ohm-cm	1.29×10 <sup>18</sup>
Dielectric Constant/ Dissipation Factor:	
@ 60 Hz	3.09/0.06
@ 1 KHz	2.65/0.048
@ 1 MHz	2.39/0.032

## GENERAL INFORMATION

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

## 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 and 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 which could entrap excessive amounts of air or cause overheating of the mixture resulting in reduced working life.
7. To ensure a void-free embedment, vacuum deairing or degassing should be performed 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 1 to 3 drops of an air release agent, such as ANTIFOAM 88 into 100 grams of mixture.
11. Pour mixture into cavity or mold.
12. 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.
13. Further vacuum deairing in the mold may be required for critical applications.

#### Storage

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

#### 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

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

#### 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.

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