

LOCTITE STYCAST ES 6020

November 2016

PRODUCT DESCRIPTION

LOCTITE STYCAST ES 6020 provides the following product characteristics:

Technology	Epoxy
Appearance, Resin (Component A)	Black
Appearance, Hardener (Component B)	Amber - green
Components	Two components - requires mixing
Mix Ratio, by volume - Part A: Part B	4 : 1
Mixing Ratio, by weight Component A: Component B	100 : 14
Cure	Room temperature cure
Application	Potting and Encapsulating

LOCTITE STYCAST ES 6020 is a filled, flame retardant, room temperature cure potting compound. It offers a medium gel time and low mixed viscosity.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties

Density, @ 25 °C, g/cm ³	1.68
Viscosity @ 25 °C, mPa·s (cP)	27,000

Part B Properties

Density, @ 25 °C, g/cm ³	0.96
Viscosity @ 25 °C, mPa·s (cP)	240

Mixed Properties

Gel Time, 200 gm mass @ 25 °C, minutes	120
Working Time, 200 gm mass, 25 °C, minutes	60

TYPICAL CURING PERFORMANCE

Recommended Curing Conditions

- 24 hours @ 25 °C (Recommended cure)
- 2 hours @ 66 °C (Alternate cure)

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties :

Viscosity, cps @ 25 °C	3,800
Density, gm/cc	1.56
Hardness, Shore D	80 to 85
Tensile Strength, psi	5,300
Moisture Absorption, 24 hrs immersion, %	0.1
Weight Loss after 168hrs @ 130°C, %	0.9
Weight Loss after 168 hrs @ 155°C, %	2.3
Weight Loss after 168 hrs @ 180 °C, %	3.4

Electrical Properties:

Dielectric Strength, volts/mil	430
Arc Resistance, seconds	146
Dielectric Constant / Dissipation Factor @ 25°C:	
100 Hz	3.7 / 0.03
1 kHz	3.6 / 0.02
10 kHz	3.5 / 0.02
100 kHz	3.5 / 0.02
Volume Resistivity, ohm-cm	2.9×10 ¹⁴

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

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