

LOCTITE STYCAST ES 6050

March 2014

PRODUCT DESCRIPTION

LOCTITE STYCAST ES 6050 provides the following product characteristics:

Technology	Epoxy
Appearance, Resin (Component A)	white
Appearance, Hardener (Component B)	Rust
Appearance (cured)	Pink
Components	Two components - requires mixing
Mixing Ratio, by volume Component A: Component B	4 : 1
Cure	Room temperature cure
Mixing Ratio, by weight Component A: Component B	100 : 19.3
Operating Temperature	100°C
Application	Potting and Sealing

LOCTITE STYCAST ES 6050 is a two part, low volatile sealing and potting system. Resin and hardener are of different colors, yielding a third color when mixed.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties (Resin)

Specific Gravity, gm/cc	1.31
Viscosity @ 25 °C, mPa·s (cP)	12,500

Part B Properties (Hardener)

Specific Gravity, gm/cc	1.02
Viscosity @ 25 °C, cps	4,500

Mixed Properties

Mixed Viscosity @ 25°C, mPa·s (cP)	8,000
Specific Gravity, gm/cc	1.25
Working Time, 500 gm mass, 25 °C, minutes	30
Shelf Life @ 25°C (from date of manufacture), days	365

TYPICAL CURING PERFORMANCE

Gel Time

Gel Time @ 25°C, 500 gram mass, minutes	60
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Recommended Curing Conditions

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

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 :

Hardness, Shore D

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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

Reference 1

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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