

# LOCTITE STYCAST ES 6510

August 2016

**PRODUCT DESCRIPTION**

LOCTITE STYCAST ES 6510 provides the following product characteristics:

<b>Technology</b>	Epoxy
Appearance (Resin)	Amber
Appearance (Hardener)	Amber
Components	Two component - requires mixing
Mix Ratio, by volume - Part A: Part B	1 : 1
Mixing Ratio, by weight Component A: Component B	1 : 1
<b>Cure</b>	Heat cure
<b>Application</b>	Potting

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

Specific Gravity	1.165
Viscosity @ 23 °C, cps	14,000

**Part B Properties**

Specific Gravity	0.9495
Viscosity @ 25 °C, cps	400

**Mixed Properties**

Mixed Viscosity @ 23°C, mPa·s (cP)	1,100
Specific Gravity	1.08
Pot Life @ 25°C, minutes	60 to 90
Flash Point - See SDS	

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

16 hours @ 23 °C plus 2 hours @ 100 °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****Physical Properties**

Shore Hardness , Durometer D	55
Weight Loss after 24hrs @ 150°C, %	<1.75
Weight Gain after 24 hrs in water @ 23°C, %	<1.25

**Electrical Properties**

Volume Resistivity, ohm-cm	$1.1 \times 10^{13}$
Dielectric Constant / Dissipation Factor @ 23°C: @ 1 KHz	3.71/0.041

**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**

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

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## Reference 1