

# LOCTITE STYCAST 2651 W1 CAT 9

March 2016

## PRODUCT DESCRIPTION

LOCTITE STYCAST 2651 W1 CAT 9 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance (Resin)</b>	Black
<b>Components</b>	Two component - requires mixing
<b>Mix Ratio, by weight - Material:Catalyst</b>	100 : 6 to 7
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• Low cost</li> <li>• Ease of use</li> <li>• High heat stability</li> <li>• Low CTE</li> <li>• Can be color coded to specification</li> </ul>
<b>Cure</b>	Room temperature cure or Heat cure
<b>Application</b>	Encapsulant, Potting
<b>Operating Temperature Range</b>	-75 to +175°C

LOCTITE STYCAST 2651 W1 CAT 9 epoxy encapsulant is designed for general purpose applications and has excellent adhesion to a wide variety of substrates. When fully cured, the material is readily machined with carbide tools.

STYCAST 2651 W1 can be used with a variety of catalysts. For more information on mixed properties when used with other available catalysts, please contact your local technical service representative for assistance and recommendations.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

### Part A Properties LOCTITE STYCAST 2651-40 W1

Density , g/cm <sup>3</sup>	1.6
Storage Life @ 18 to 25°C (from date of manufacture), 365 days	
Flash Point - See SDS	

### Part B Properties LOCTITE CAT 9

Flash Point - See SDS

### Mixed Properties

Mixed Viscosity @ 25 °C, mPa·s (cP)	45,000
Pot Life , 0.5kg mass, minutes	30
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 8 hours @ 25°C or
- 1 hour @ +70 to +80°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.

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Keep LOCTITE CAT 9 away from contact with the skin.
2. Mix resin in the shipping container until it is uniform in texture. This will normally require 2 to 5 minutes in 1 or 5 gallon containers.
3. Mix thoroughly.
4. Pour into mold or container. Use vacuum evacuation only if necessary.
5. Allow to stand at room temperature for 8 hours. The casting can be removed from the mold when hard. This will occur within 1 hour.
6. A cure for 1 hour @ +70 to +80°C will also complete the cure.

## Storage

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

### Optimal Storage : 18 to 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

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

## Disclaimer

### Note:

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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#### Reference 1