

LOCTITE STYCAST ES 2505 CAT 9

November 2020

PRODUCT DESCRIPTION

LOCTITE STYCAST ES 2505 CAT 9 provides the following product characteristics:

Technology	Epoxy
Appearance (Resin)	Black liquid
Product Benefits	• General purpose • Low viscosity • Flame retardant • Excellent dielectric properties • RoHS compliant
Mix Ratio by weight - LOCTITE STYCAST ES 2505 : LOCTITE CAT 9	100 : 8
Application	Encapsulation and Potting

LOCTITE STYCAST ES 2505 CAT 9 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 2505 CAT 9 meets UL 94 HB and UL 94 V-0 Flammability classifications.

LOCTITE STYCAST ES 2505 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

LOCTITE ES 2505

Density @ 25°C, gm/cc	1.52
Viscosity, Brookfield - RVF, 25 °C, mPa·s (cP):	
Spindle 6, speed 20 rpm	16,000
Shelf Life @ 25°C (from date of manufacture), days	274
Flash Point - See SDS	

TYPICAL UNCURED PROPERTIES AS MIXED

LOCTITE STYCAST ES 2505 CAT 9

Mixed Viscosity, mPa·s (cP)	4,320
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TYPICAL CURING PERFORMANCE

Cure Schedule

4 hours @ 65°C in Convection oven

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

TYPICAL PROPERTIES OF CURED MATERIAL

LOCTITE STYCAST ES 2505 CAT 9

Physical Properties

Hardness, Shore D	85
Glass Transition Temperature, °C:	
TMA	86
Tan Δ Max	105
Coefficient of Thermal Expansion, :	
Below Tg, μm/m-°C	56
Above Tg, μm/m-°C	172
Storage Modulus:	
@ -40°C	N/mm ² 4,481 (psi) (649,914)
@ -25°C	N/mm ² 4,291 (psi) (622,356)
@ 0°C	N/mm ² 4,042 (psi) (586,242)
@ 25°C	N/mm ² 3,892 (psi) (564,486)
@ 50°C	N/mm ² 3,701 (psi) (536,784)
@ 75°C	N/mm ² 3,316 (psi) (480,945)
@ 100°C	N/mm ² 463 (psi) (67,152)
@ 125°C	N/mm ² 94 (psi) (13,633)
Thermal Conductivity, W/(m-K)	0.64

Electrical Properties

Volume Resistivity, ohms-cm	1.58×10 ¹⁵
Surface Resistivity, ohms	3.24×10 ¹⁵
Dielectric Constant / Dissipation Factor:	
@ 50 Hz	3.25/0.004
@ 1 KHz	3.35/0.011
@ 1 MHz	3.15/0.0135

TYPICAL PERFORMANCE OF CURED MATERIAL

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Shear Strength

Tensile Lap Shear Strength	N/mm ² 14.5 (psi) (2,103)
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GENERAL INFORMATION

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

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. 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. This can entrap excessive amounts of air. It can also 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 Henkel 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

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

Disclaimer

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