

LOCTITE STYCAST 2750T

November 2016

PRODUCT DESCRIPTION

LOCTITE STYCAST 2750T provides the following product characteristics:

Technology (Part A)	Epoxy
Technology (Part B)	Amine
Components	Two components - requires mixing
Appearance - Part A	Black liquid
Appearance - Part B	Light yellow liquid
Mix Ratio, by weight - Part A: Part B	100 : 17.5
Cure	Heat cure
Application	Potting or Encapsulant

LOCTITE STYCAST 2750T two component, epoxy encapsulant is designed for circuit board protection applications.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties

Viscosity, mPa·s (cP)	80,000
Specific Gravity	1.34
Shelf Life (from date of manufacture):	
@ -20°C, days	183
@ 0 to 15°C, days	61
Flash Point - See SDS	

Part B Properties

Viscosity, mPa·s (cP)	28
Specific Gravity	0.95
Shelf Life @ 5 to 35°C	183
Flash Point - See MSDS	

Mixed Properties

Mixed Viscosity @ 25°C, mPa·s (cP)	6,700
Pot Life, hours	3
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

- 12 hours @ 40°C or
- 2 hours @ 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.

TYPICAL PROPERTIES OF CURED MATERIAL AS MIXED

Physical Properties

Hardness, Shore D @ 25 °C	89
Glass Transition Temperature, °C	67
Coefficient of Thermal Expansion :	
alpha 1	34

Water Absorption, after 1 hour @ 100°C, % 0.7

Electrical Properties

Volume resistivity @ 500 V, Ω·cm 1×10^{15}

TYPICAL PERFORMANCE OF CURED MATERIAL AS MIXED

Miscellaneous

Lap Shear Strength, Kg/cm ²	N/mm ²	25
	(psi)	(3,625)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Mix thoroughly.
2. Power mixing is preferred to ensure a homogeneous product.
3. Evacuate the resin mixture to remove entrapped air.
4. Pour mixture into cavity or mold.

Conversions

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

STORAGE:

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

Optimal Storage : Part A: -20 to 15°C, Part B: 5 to 35°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.

Disclaimer

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