

LOCTITE STYCAST EO 8019

August 2016

PRODUCT DESCRIPTION

LOCTITE STYCAST EO 8019 provides the following product characteristics:

Technology	Epoxy
Appearance	Black
Cure	Heat Cure
Application	Potting and Encapsulating

LOCTITE STYCAST EO 8019 epoxy, is a resilient, non-sag, heat cure glass adhesive. Non-sag properties are at room temperature and to 149°C in a 1/8 inch bead.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	325,000
Specific Gravity	1.14
Density, lbs/gal	9.5
Non-Sag, Inch Bead @ 149 °C	1/8
Shelf Life @ -16°C (from date of manufacture), days	182
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Gel Time

Gel Time, 20 gm Mass:	
@ 121°C, minutes	40
@ 149°C, minutes	20

Recommended Cure Schedule

2 hours @ 121°C

Alternate Cure Schedule

1 hour @ 149°C

Cure time listed is the time required after the system and the unit reaches the cure temperature.

The above cure profile is a guideline recommendation. 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	82.5
Glass Transition Temperature, °C	35
Coefficient of Thermal Expansion :	
Below Tg, in/in/°C	7.6×10^{-5}
Above Tg, in/in/°C	26.3×10^{-5}

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.

DIRECTIONS FOR USE

1. This is a one-component system which should be stored refrigerated or frozen.
2. If frozen or refrigerated, allow 24-48 hours for the product to reach room temperature.
3. Apply product.
4. Use low speed mixing to reduce air entrapment. If air bubbles persist, place unit under vacuum.
5. Cure mixture according to cure schedule. Cure time is measured after the product reaches curing temperature.

STORAGE

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage : -16 °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.

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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