

LOCTITE STYCAST ES 2501

September 2012

PRODUCT DESCRIPTION

LOCTITE STYCAST ES 2501 provides the following product characteristics:

Technology	Epoxy
Appearance, Resin (Component A)	Yellow
Appearance, Hardener (Component B)	Yellow
Appearance (cured)	Yellow
Components	Two components - requires mixing
Mix Ratio, by volume - Part A: Part B	1 : 1
Mixing Ratio, by weight Component A: Component B	1 : 1
Cure	Room temperature cure
Application	Encapsulation, Potting

LOCTITE STYCAST ES 2501 is an unfilled, very fast, room temperature cure adhesive system designed to harden in 3 to 5 minutes. It is suitable for bonding to many surfaces, such as metal, wood, concrete, or most plastics.

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

Density, @ 25 °C, g/cm ³	1.16
Viscosity @ 25 °C, cP	15,000

Part B Properties

Density, @ 25 °C, g/cm ³	1.13
Viscosity @ 25 °C, cP	12,000

Mixed Properties

Viscosity @ 25 °C, cP	13,500
Gel Time, 4 gm mass @ 25 °C, minutes	5
Working Time, 4 gm mass, @ 25 °C, minutes	3 to 4

TYPICAL CURING PERFORMANCE**Recommended Cure Schedule**

1 hour @ 25°C

The above cure profile is a guideline recommendation. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of light source, exposure time and the light transmittance of the substrate.

TYPICAL PROPERTIES OF CURED MATERIAL**Physical Properties :**

Shore Hardness , Durometer D	72
Compressive Strength, psi	9,400
Tensile Strength, psi	8,000
Tensile Elongation, %	4.6
Tensile Shear, psi	3,500

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.

Note: Before using this product please purge approximately 30 ml. of material prior to application. Discard purged material in accordance with the Material Safety Data Sheet. A video instruction is available upon request.

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

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

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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