

# LOCTITE STYCAST 2750L

January 2017

## PRODUCT DESCRIPTION

LOCTITE STYCAST 2750L provides the following product characteristics:

<b>Technology (Part A)</b>	Epoxy
<b>Technology (Part B)</b>	Amine
<b>Components</b>	Two components - requires mixing
<b>Appearance - Part A</b>	Black liquid
<b>Appearance - Part B</b>	Clear yellow liquid
<b>Mix Ratio, by weight - Part A: Part B</b>	100 : 22
<b>Cure</b>	Heat cure
<b>Application</b>	Potting or Encapsulant

LOCTITE STYCAST 2750L is a filled, low volatile, two component epoxy encapsulant.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

### Part A Properties

Viscosity @ 25 °C, mPa·s (cP)	20,000
Specific Gravity	1.35
Storage Life @ 18 to 25°C (from date of manufacture), days	183
Flash Point - See SDS	

### Part B(1) Properties

Viscosity @ 25 °C, mPa·s (cP)	24
Specific Gravity	0.99
Storage Life @ 18 to 25°C (from date of manufacture), days	183
Flash Point - See SDS	

### Mixed Properties

Mixed Viscosity @ 25°C, mPa·s (cP)	3,000
Pot Life, hours	3
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Cure Schedule

- 12 hours @ 30°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

### Physical Properties

Hardness, Shore D @ 25 °C	85
Glass Transition Temperature (Tg) by TMA, °C	42
Coefficient of Thermal Expansion :	
Above Tg, ppm/°C	44
Flexural Modulus	GPa 2.2 (N/mm <sup>2</sup> ) (2,200) (psi) (319,000)

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Miscellaneous:

Tensile Strength	N/mm <sup>2</sup> 35 (psi) (5,080)
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## 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.

## 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.

## Conversions

(°C x 1.8) + 32 = °F  
 kV/mm x 25.4 = V/mil  
 mm / 25.4 = inches  
 N x 0.225 = lb  
 N/mm x 5.71 = lb/in  
 psi x 145 = N/mm<sup>2</sup>  
 MPa = N/mm<sup>2</sup>  
 N·m x 8.851 = lb·in  
 N·m x 0.738 = lb·ft  
 N·mm x 0.142 = oz·in  
 mPa·s = cP

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