

# LOCTITE STYCAST EE 4215/EB 6026

June 2018

## PRODUCT DESCRIPTION

LOCTITE STYCAST EE 4215/EB 6026 provides the following product characteristics:

|  |                                  |
|--|----------------------------------|
| <b>Technology</b>                                      | Epoxy                            |
| Appearance (Resin)                                     | Black                            |
| Appearance (Hardener)                                  | Amber                            |
| Appearance (cured)                                     | Black                            |
| Components   | Two components - requires mixing |
| Mixing Ratio, by weight<br>Component A:<br>Component B | 100 : 38                         |
| Mix Ratio, by volume -<br>Part A: Part B               | 100 : 50                         |
| <b>Cure</b>  | Heat cure                        |
| <b>Application</b>                                     | Casting                          |

LOCTITE STYCAST EE 4215/EB 6026 is a silica filled epoxy casting system recommended for coils, transformers, and general purpose casting.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

### Part A Properties LOCTITE STYCAST EE4215

|   |                   |
|---|-------------------|
| Filler Content, %   | 48 to 52          |
| Density @ 25°C, gm/cc   | 1.58              |
| Viscosity @ 25°C, Brookfield RVF, cP, max.:<br>Spindle 6, speed 4 rpm | 70,000 to 100,000 |

### Part B Properties LOCTITE STYCAST EB 6026

|  |              |
|--|--------------|
| Filler Content, %  | 0            |
| Density @ 25°C, gm/cc  | 1.19         |
| Viscosity @ 25°C, Brookfield RVF, cP, max.:<br>Spindle 2, speed 20 rpm | 500 to 1,350 |

## TYPICAL CURING PERFORMANCE Recommended Curing Conditions

4 hours @ 110 °C (Recommended cure)

2 hours @ 125 °C (Alternate cure)

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties :

|   |            |
|---|------------|
| Density, gm/cc                                      | 1.43       |
| Shore Hardness , Durometer D                        | 90 to 95   |
| Pot Life @ 200°C, 200 gram mass, hours              | >8         |
| Viscosity, mixed @ 70°C:<br>Spindle 2, speed 20 rpm | 350 to 450 |
| Viscosity, mixed @ 25°C:<br>Spindle 5, speed 20 rpm | 7,000      |

## 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

LOCTITE STYCAST EE 4215 may crystallize during prolonged storage, if stored below 10°C. If crystallization does occur, warm the contents of the shipping container to 50 to 60°C until all crystals have dissolved. Shipping container must be loosely covered during the warming stage to prevent any pressure build-up.

### 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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