

# LOCTITE STYCAST 930-21

June 2018

## PRODUCT DESCRIPTION

LOCTITE STYCAST 930-21 provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance</b>	Black liquid
<b>Cure</b>	Heat cure
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• Solvent resistant</li> <li>• Heat resistant</li> <li>• Low coefficient of thermal expansion</li> <li>• High thermal conductivity</li> </ul>
<b>Operating Temperature</b>	180°C
<b>Application</b>	Potting

LOCTITE STYCAST 930-21 is a pourable epoxy adhesive and potting compound.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity, Brookfield - HAT, 25 °C, mPa·s (cP):	
Spindle 5, speed 10 rpm	19,000
Specific Gravity @ 25 °C	1.54
Shelf Life (from date of manufacture):	
@ 38°C, days	28
@ 22°C, days	121
@ 10°C, days	243
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Gel Time

- 4 minutes @ 177°C
- 8 minutes @ 160°C
- 1 hour @ 121°C

### Cure Schedule

- 12 minutes @ 177°C
- 30 minutes @ 160°C
- 2.5 hours @ 121°C

For applications involving large substrates, a four hour cure at 121°C is recommended.

This product generates moderate heat during cure. No adverse exotherm effects are obtained when cured at 122°C in masses up to approximately 40 grams.

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

Shore Hardness, Shore D:	
@ 25°C	90
@ 121°C	75
Thermal Conductivity, W/(m·K)	0.64

### Electrical Properties

Dielectric Strength @ 10 mil thickness, volts/mil	1,180
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## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. Certain resins and hardeners are prone to crystallization. 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.

## 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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Reference **N/A**

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