

LOCTITE STYCAST 2850GT CAT 27-1

June 2020

PRODUCT DESCRIPTION

LOCTITE STYCAST 2850GT CAT 27-1 provides the following product characteristics:

| | |
|---|---|
| Technology | Epoxy |
| Appearance (Resin) | Black |
| Components | Two components - requires mixing |
| Mix Ratio, by weight - Material:Catalyst | 100 : 6 |
| Mix Ratio, by Volume - Material:Catalyst | 100 : 14 |
| Product Benefits | <ul style="list-style-type: none"> • Low CTE • Thermally conductive • Electrically Insulating • General purpose • Good chemical resistance • Good physical strength |
| Cure | Oven Cure |
| Application | Encapsulation |
| Operating Temperature | -40 to +175 °C |

LOCTITE STYCAST 2850GT CAT 27-1 is recommended for encapsulation of components that require heat dissipation and thermal shock properties. The fillers in LOCTITE STYCAST 2850GT CAT 27-1 are slightly gritty and hard, requiring the finished product to be grounded for smoothness.

LOCTITE STYCAST 2850GT can be used with a variety of catalysts. For more information on mixed properties when used with other available catalysts, please contact your local technical service representative for assistance and recommendations.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties LOCTITE STYCAST 2850GT

| | |
|--|---------|
| Viscosity Brookfield, mPa (cP) 50 rpm, #7 | 400,000 |
| Density, g/cm ³ | 2.32 |
| Shelf Life @ 25°C, months | 12 |
| Flash Point - See SDS | |

Part B Properties LOCTITE CAT 27-1

| | |
|-------------------------------|------------|
| Viscosity @ 25 °C, mPa-s (cP) | 250 to 300 |
| Flash Point - See SDS | |

Mixed Properties

| | |
|-----------------------------------|-------|
| Mixed Density , g/cm ³ | 2.262 |
| Flash Point - See SDS | |

TYPICAL CURING PERFORMANCE

Cure Schedule

Convection Box Oven:
4 hours @ 120°C

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

| | |
|------------------------------------|--|
| Density, g/cm ³ | 2.348 |
| Hardness, Shore D | 94 |
| Coefficient of Thermal Expansion : | |
| Below Tg, μm/(m.°C) | 28 |
| Above Tg, μm/(m.°C) | 105 |
| Glass Transition Temperature, °C: | |
| (Tg) by DMA @ tan delta | 140 |
| (Tg) by TMA | 147 |
| Thermal Conductivity , W/(m-K) | 1.3 |
| Volume Shrinkage on Cure, % | 1.08 |
| Linear Shrinkage, % | 0.36 |
| Water Absorption, %: | |
| 1 day @ 25°C | 0.02 |
| 1 week @ 25°C | 0.07 |
| Young's modulus (E) : | |
| @ -40°C | N/mm ² 8,914 (psi) (1.29×10 ⁶) |
| @ 0°C | N/mm ² 8,084 (psi) (1.17×10 ⁶) |
| @ 25°C | N/mm ² 7,769 (psi) (1.13×10 ⁶) |
| @ 50°C | N/mm ² 7,348 (psi) (1.07×10 ⁶) |
| @ 100°C | N/mm ² 5,952 (psi) (863,000) |
| @ 150°C | N/mm ² 161 (psi) (23,400) |

Electrical Properties

| | |
|---|-----------------------|
| Volume Resistivity, ohm-cm | 5.53×10 ¹⁵ |
| Surface Resistivity, ohms | 2.59×10 ¹⁵ |
| Dielectric Strength, kV/mm | 20 |
| Dielectric Constant / Dissipation Factor: | |
| @ 50 Hz | 4.5/0.002 |
| @ 1 kHz | 5.0/0.005 |
| @ 1 MHz | 4.7/0.019 |

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Complete cleaning of the substrates should be performed to remove contamination such as oxide layers, dust, moisture, salt and oils which can cause poor adhesion or corrosion in a bonded part.
2. Some separation of components is common during shipping and storage. For this reason, it is recommended that the contents of the shipping container be thoroughly mixed prior to use.
3. Accurately weigh resin and hardener into a clean container in the recommended ratio.
4. Blend components by hand, using a kneading motion, for 2 to 3 minutes. Scrape the bottom and sides of the mixing container frequently to produce a uniform mixture.
5. If possible, power mix for an additional 2 to 3 minutes. Avoid high mixing speeds. This can entrap excessive amounts of air. It can also cause overheating of the mixture, resulting in reduced working life.
6. To ensure a void-free embedment, vacuum deairing should be used to remove any entrapped air introduced during the mixing operation.
7. Pump-down or pull vacuum on the mixture to achieve an ultimate vacuum or absolute pressure of 1 to 5 torr or mm Hg. The foam will rise several times in the liquid height and then subside.
8. Continue vacuum deairing until most of the bubbling has ceased. This usually takes 3 to 10 minutes.
9. To facilitate deairing in difficult to deair materials, add a few drops of an air release agent, such as ANTIFOAM 88 into 100 grams of mixture.
10. Gentle warming will also help, but pot life will be shortened.
11. Pour mixture into cavity or mold.
12. Gentle warming of the mold or assembly reduces the viscosity. This improves the flow of the material into the unit having intricate shapes or tightly packed coils or components.
13. Further vacuum deairing in the mold may be required for critical applications.

STORAGE:

Store in original, tightly covered containers in clean, dry areas. Storage information may be indicated on the product container labeling.

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. Be sure the shipping container is loosely covered during the warming stage to prevent any pressure build-up. Allow contents to cool to room temperature before continuing.

Optimal Storage : 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.

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.

Conversions

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

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. Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

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Reference 1