

**LOCTITE STYCAST 2072**

June 2020

**PRODUCT DESCRIPTION**

LOCTITE STYCAST 2072 provides the following product characteristics:

<b>Technology (Part A)</b>	Epoxy
<b>Technology (Part B)</b>	Amine
Components	Two components - requires mixing
Appearance - Part A	Black liquid
Appearance - Part B	Black liquid
Appearance - Mixed	Black liquid
Mix Ratio by volume: Part A: Part B	100 : 50
Mix Ratio by weight: Part A: Part B	100 : 50
Product Benefits	<ul style="list-style-type: none"><li>• Low viscosity</li><li>• General purpose</li><li>• Good electrical properties</li><li>• Good mechanical properties</li><li>• Used in a wide variety of applications</li><li>• Ease of use and dispensing</li></ul>
<b>Cure</b>	Room temperature and Heat cure
<b>Application</b>	Encapsulation and Potting
Operating Temperature	-40 to 130 °C

LOCTITE STYCAST 2072 is a general purpose encapsulant is formulated using non-abrasive fillers that is ideal for automatic meter/mix equipment dispensing.

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

Viscosity, Brookfield , mPa·s (cP)	22,500
Density, g/cm³	1.67
Flash Point - See SDS	

**Part B Properties**

Viscosity, Brookfield , mPa·s (cP)	5,700
Density, g/cm³	1.47
Flash Point - See SDS	

**Mixed Properties**

Mixed Viscosity, Brookfield , mPa·s (cP)	8,000
Density, g/cm³	1.6
Work Life (100 g mass) @ 25 °C, minutes	90
Shelf Life @ 25°C (from date of manufacture), days	548
Flash Point - See SDS	

**TYPICAL CURING PERFORMANCE****Recommended Cure Schedule**

24 to 48 hours @ 25°C or  
8 to 16 hours @ 45°C or  
2 to 4 hours @ 65°C

For optimum performance, follow the initial cure with a post cure of 2 to 4 hours at the highest expected use temperature.

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	89
Coefficient of Thermal Expansion 10⁻⁶/°C, TMA	61
Thermal Conductivity, W/(m-K)	0.42

**Electrical Properties**

Dielectric Constant/Dissipation Factor @ 1 mHz	4.2/0.01
Dielectric Strength, volts/mil	400
Volume Resistivity @ 25°C, ohm-cm	>1×10¹⁴

**TYPICAL PERFORMANCE OF CURED MATERIAL**

Flexural Strength	N/mm² (psi)	83 (12,000)
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**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**

1. To ensure the long term performance of the potted or encapsulated electrical / electronic assembly, complete cleaning of components and substrates should be performed to remove contamination such as dust, moisture, salt, and oils which can cause electrical failure, poor adhesion or corrosion in an embedded part.
2. Some filler settling 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. Power mixing is preferred to ensure a homogeneous product.
3. Accurately weigh resin and hardener into a clean container in the recommended ratio. Weighing apparatus having an accuracy in proportion to the amounts being weighed should be used.
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. If possible, power mix to an additional 2 to 3 minutes. Avoid high mixing speeds which could entrap excessive amounts of air or cause overheating of the mixture resulting in reduced working life.
5. To ensure a void-free embedment, vacuum deairing or degassing should be performed to remove any entrapped air introduced during the mixing operation. Pump-down or pull vacuum on the mixture to achieve an ultimate vacuum or absolute pressure of 1- 5 torr or mmHg. The foam will rise several times the liquid height and then subside. Continue vacuum deairing until most of the bubbling has ceased. This usually requires 3-10 minutes.
6. To facilitate deairing in difficult to deair materials, add 1-3 drops of an air release agent, such as ANTIFOAM 88, into 100 grams of mixture. Gentle warming will also help, but working life will be shortened.
7. Pour mixture into cavity or mold. 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. Further vacuum deairing in the mold may be required for critical applications.

**HANDLING**

1. Certain resins and hardeners are prone to crystallization.
2. If crystallization does occur, warm the contents of the shipping container to °C until all crystals have dissolved.
3. Be sure the shipping container is loosely covered during the warming stage to prevent any pressure build-up.
4. Allow contents to cool to room temperature before continuing.

**STORAGE:**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**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.

**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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