

# LOCTITE STYCAST 2651-40 CAT 9M

March 2022

## PRODUCT DESCRIPTION

LOCTITE STYCAST 2651-40 CAT 9M provides the following product characteristics:

<b>Technology</b>	Epoxy
<b>Appearance (Resin)</b>	Black
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>Two components</li> <li>Ease of use</li> <li>Low viscosity</li> </ul>
<b>Mix Ratio by weight - Material:Catalyst</b>	100 : 8 to 9
<b>Cure</b>	Room temperature and Heat cure
<b>Application</b>	Encapsulation

LOCTITE STYCAST 2651-40 CAT 9M epoxy encapsulant is designed to have excellent adhesion to metals, plastics and ceramics. When fully cured, the material is readily machined with carbide tools.

LOCTITE STYCAST 2651-40 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 2651-40

Viscosity @ 25 °C, mPa·s (cP)	21,100
<i>(Viscosity will decrease by elevation of temperature to 40°C)</i>	
Density, g/cm <sup>3</sup>	1.5
Shelf Life @ 8 to 28°C, days	183

Flash Point - See SDS

### Mixed Properties LOCTITE STYCAST 2651-40 with LOCTITE CAT 9M

Mixed Viscosity @ 25 °C, mPa·s (cP)	9,733
Mixed Pot Life, minutes	30
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### For Castings up to 50 grams

1 hour @ 65°C

Cure time and temperature depend on mass and will vary due to other considerations.

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties

Glass Transition Temperature (Tg) by TMA, °C	78
Coefficient of Thermal Expansion, TMA:	
Below Tg, ppm/°C	48
Above Tg, ppm/°C	187

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

- Mix the resin in the can in which it is received until uniform to texture. This will normally require 2 to 5 minutes in 1 to 5 gallon containers.
- Blend thoroughly.
- Pour into mold or container. If necessary, trapped air is readily removed by vacuum evacuation..
- Allow to stand at room temperature for 8 hours for handling or demolding. Full properties develop over the following 24 hours.

## STORAGE

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

### Optimal Storage : 8 to 28 °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 Henkel Representative.

### Not for product specifications

The technical data contained herein are intended as reference only. Please contact your local Henkel representative for assistance and recommendations on the specifications of this product.

## Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb/F
N/mm x 5.71 = lb/in
N/mm <sup>2</sup> x 145 = psi
N/mm <sup>2</sup> = MPa
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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**Reference 1**