

LOCTITE STYCAST 930-21

June 2018

PRODUCT DESCRIPTION

LOCTITE STYCAST 930-21 provides the following product characteristics:

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

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
N x 0.225 = lb
N/mm x 5.71 = lb/in
psi x 145 = N/mm²
MPa = N/mm²
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Disclaimer

Note:

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Reference **N/A**