



STYCAST 2651-40/Catalyst 9

June 2011

PRODUCT DESCRIPTION

STYCAST 2651-40/Catalyst 9 provides the following product characteristics:

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

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

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 2651-40

| | |
|---------------------------------|-----|
| Viscosity @ 25 °C, | 30 |
| Density , g/cm ³ | 1.5 |
| Shelf Life @ 18 to 25°C, months | 12 |
| Flash Point - See MSDS | |

Viscosity will decrease by elevation of temperature to 40°C.

Mixed Properties

| | |
|-------------------------------------|-------|
| Mixed Viscosity @ 25 °C, mPa·s (cP) | 5,000 |
| Mixed Pot Life , minutes | 30 |
| Flash Point - See MSDS | |

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 their application requirements, as well as customer curing equipment, oven loading and actual oven temperatures.

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. 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.
2. Blend thoroughly.
3. Pour into mold or container. If necessary, trapped air is readily removed by vacuum evacuation..
4. 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: 18 to 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

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

Note

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