Technical Data Sheet

# LOCTITE STYCAST E 2534 FR CAT 24LV

January 2017

## PRODUCT DESCRIPTION

LOCTITE STYCAST E 2534 FR CAT 24LV provides the following product characteristics:

| | |
|---|---|
| **Technology** | Epoxy |
| Appearance (Resin) | Blue |
| Components | Two components - requires mixing |
| Mix Ratio, (by weight) Resin : Hardener | 100 : 8 |
| Product Benefits | • Flame retardant<br>• Halogen free<br>• High thermal conductivity<br>• High dielectric strength |
| **Cure** | Heat cure |
| **Application** | Potting |
| Operating Temperature - Continuous | -65 to +105°C |
| Operating Temperature - Intermittent | -65 to +120°C |
| UL Flammability Rating | UL 94 V-0 @ 6 mm thickness |

LOCTITE STYCAST E 2534 FR CAT 24LV epoxy potting compound complies with recent demands on environmentally friendly products and does not contain brominated flame retardants .

LOCTITE STYCAST E 2534 FR 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 UNCURED PROPERTIES AS MIXED

**LOCTITE STYCAST E 2534 FR CAT 24LV with LOCTITE CAT 24LV**

Viscosity, Brookfield - DV-2+, 25 °C, mPa·s (cP):
Spindle 6, speed 20 rpm 3,290
Flash Point - See SDS

## TYPICAL CURING PERFORMANCE

**Cure Schedule**

4 hours @ 65°C(Convection Box Oven)

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 | | 91 |
| Thermal Conductivity , W/(m-K) | | 0.99 |
| Young's Modulus: | | |
| @ -40°C | N/mm² | 5,224 |
| | (psi) | (757,677) |
| @ 0°C | N/mm² | 4,479 |
| | (psi) | (64,962) |
| @ 25°C | N/mm² | 4,285 |
| | (psi) | (621,486) |
| @ 50°C | N/mm² | 4,073 |
| | (psi) | (590,738) |
| @ 100°C | N/mm² | 122 |
| | (psi) | (17,694) |
| @ 150°C | N/mm² | 120 |
| | (psi) | (17,404) |
| Glass Transition Temperature, °C: | | |
| DMA, Tangent Delta | | 89 |
| TMA | | 60 |
| Coefficient of Thermal Expansion, TMA: | | |
| Below Tg, µm/-m°C | | 39 |
| Above Tg, µm/m-°C | | 147 |

**Electrical Properties**

| | |
|---|---|
| Volume Resistivity , ohms-cm | $1.2\times10^{15}$ |
| Surface Resistivity, ohms | $4.6\times10^{14}$ |
| Dielectric Constant / Dissipation Factor : | |
| 50Hz | 4.9 / 0.023 |
| 1 kHz | 5.0 / 0.014 |
| 1 MHz | 4.6 / 0.022 |

## TYPICAL PERFORMANCE OF CURED MATERIAL

Tensile Lap Shear Strength :

| | | |
|---|---|---|
| Al to Al | N/mm² | 16 |
| | (psi) | (2,320) |

## GENERAL INFORMATION

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

## DIRECTIONS FOR USE

1. 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.
2. Moderate warming to maximum 40°C of the resin prior to adding the hardener will improve pourability.
3. Pour mixture into cavity or mold.
4. **IMPORTANT:** DO NOT USE CATALYST 27-1 as this hardener is

not compatible with the filler, and will cause foaming.

**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**
(°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
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**
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