

LOCTITE STYCAST EO 8019

May 2016

PRODUCT DESCRIPTION

LOCTITE STYCAST EO 8019 provides the following product characteristics:

Technology	Epoxy
Appearance	Black
Cure	Heat Cure
Application	Potting and Encapsulating

LOCTITE STYCAST EO 8019 epoxy, is a resilient, non-sag, heat cure glass adhesive. Non-sag properties are at room temperature and to 149°C in a 1/8 inch bead.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Viscosity @ 25 °C, mPa·s (cP)	325,000
Specific Gravity	1.14
Density, lbs/gal	9.5
Non-Sag, Inch Bead @ 149 °C	1/8
Shelf Life @ 8 to 28°C (from date of manufacture), 183 days	
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE**Gel Time**

Gel Time, 20 gm Mass:	
@ 121°C, minutes	40
@ 149°C, minutes	20

Recommended Cure Schedule

2 hours @ 121°C

Alternate Cure Schedule

1 hour @ 149°C

Cure time listed is the time required after the system and the unit reaches the cure temperature.

The above cure profile is a guideline recommendation. 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	82.5
Glass Transition Temperature, °C	35
Coefficient of Thermal Expansion :	
Below Tg, in/in/°C	7.6×10^{-5}
Above Tg, in/in/°C	26.3×10^{-5}

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. This is a one-component system which should be stored refrigerated or frozen.
2. If frozen or refrigerated, allow 24-48 hours for the product to reach room temperature.
3. Apply product.
4. Use low speed mixing to reduce air entrapment. If air bubbles persist, place unit under vacuum.
5. Cure mixture according to cure schedule. Cure time is measured after the product reaches curing temperature.

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 Technical Service Center or Customer Service Representative.

Conversions

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

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