Technical Data Sheet

LOCTITE STYCAST U 2500

August 2016

PRODUCT DESCRIPTION

LOCTITE STYCAST U 2500 provides the following product characteristics:

Technology	Polyurethane
Appearance (Resin)	Black
Appearance (Hardener)	Amber
Components	Two component - requires mixing
Mix Ratio, by weight - Resin : Hardener	100 : 7
Mix Ratio, by volume - Base : Hardener	100 : 8.5
Product Benefits	• Low viscosity • Low CTE • Two component • Flexible polyurethane • Excellent wettability • Room temperature cure
Cure	Room temperature cure
Application	Encapsulant
Operating Temperature	-40 to 125 °C

LOCTITE STYCAST U 2500 is an encapsulant designed for transformer, PCB's and other insulation applications. It allows for complete impregnation when used either on small slightly wound coils or large castings.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Part A Properties

Viscosity @ 25 °C, mPa·s (cP)	12,500
Density, g/cm³	1.5
Shelf Life @ 18 to 25°C, months	6
Flash Point - See SDS	

Part B Properties

Viscosity @ 25 °C, mPa·s (cP)	50
Density, g/cm³	1.25
Flash Point - See SDS	

Mixed Properties

Mixed Viscosity @ 25°C, mPa·s (cP)	6,000
Pot Life @ 25 °C, hours	2
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Cure Schedule

24 hours @ 25°C or
4 hours @ 60°C

Complete cure at room temperature will be obtained after 2 to 3days.

A post cure of 2 hours @ 100 to 120°C will improve final end-properties.

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 A:		
@ 25ºC		73
@ -20ºC		78
Coefficient of Linear Thermal Expansion, ppm/ºC		155
Glass Transition Temperature, °C		-53
Young's Modulus	N/mm² (psi)	6 (870)
Elongation, %		82
Thermal Conductivity, W/(m-K)		0.5
Moisture Absorption, 24 hrs @ 25ºC, %		0.75

Electrical Properties

Volume resistivity @ 500 V, Ω-cm	4×10^{11}
Surface Resistivity, ohms	7×10^{12}
Dielectric Strength, ASTM D149, kV/mm	15
Dielectric Constant/Dissipation Factor @ 1 MHz	5.5/0.05

TYPICAL PERFORMANCE OF CURED MATERIAL

Miscellaneous:

Tensile Strength	N/mm² (psi)	3 (435)
Tensile Lap Shear Strength:		
Al to Al	N/mm² (psi)	6 (870)

GENERAL INFORMATION

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

DIRECTIONS FOR USE

1. Before use, stir Part A to make it homogeneous.
2. Accurately weigh Part A and Part B into a clean container in the recommended ratio.
3. Mix thoroughly, degas and fill the casting.

Storage

This material is moisture sensitive and must be stored in tightly closed containers at the recommended storage temperature. Partially used containers should be blanketed with dry nitrogen before resealing.

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
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
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicity agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Belgium NV, Henkel Electronic Materials NV, Henkel Nederland BV, Henkel Technologies France SAS and Henkel France SA please additionally note the following:
In case Henkel would be nevertheless held liable, on whatever legal ground, Henkel's liability will in no event exceed the amount of the concerned delivery.

In case products are delivered by Henkel Colombiana S.A.S. the following disclaimer is applicable:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. Henkel, is therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
Any liability in respect of the information in the Technical Data Sheet or any other written or oral recommendation(s) regarding the concerned product is excluded, except if otherwise explicitly agreed and except in relation to death or personal injury caused by our negligence and any liability under any applicable mandatory product liability law.

In case products are delivered by Henkel Corporation Resin Technology Group, Inc., or Henkel Canada, Inc. the following disclaimer is applicable:
The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Henkel Corporation specifically disclaims all warranties expressed or implied, including warranties of mechantability or fitness for a particular purpose, arising from sale or use of Henkel Corporation's products. Henkel Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Henkel Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more United States or foreign patents or patent applications.

Trademark usage
Except as otherwise noted, all trademarks in this document are trademarks of Henkel Corporation in the U.S. and elsewhere. ® denotes a trademark registered in the U.S. Patent and Trademark Office.

Reference N/A

This document was created and digitally signed by tdx.henkel.com at 2025-11-27T08:36:00.869Z