

Potting & Encapsulating

Potting and encapsulating compounds are used to provide mechanical reinforcement to housed assemblies, to fill large voids, and to protect components from the effects of exposure to chemicals, moisture, mechanical shock, and vibration. Sealing components with potting and encapsulating compounds prevents corrosion and ensures long-term integrity of the device.

Variables to consider when selecting a potting or encapsulating material include:

- Viscosity of uncured compound
- Dispensing requirements
- Device operating temperature
- Desired chemical resistance
- Desired thermal conductivity
- Desired flame retardance
- Hardness of cured product
- Overall cost

There are a variety of potting and encapsulating compounds to choose from – epoxy, hot melt, silicone, and urethane. The thermal properties of epoxy and silicone systems make them ideally suited for applications exposed to temperatures above 125°C. If a soft, flexible material is needed, particularly at low temperatures, then a urethane, silicone or hot melt material may be used.

What is the best product for my application?

The following chart will work best when selecting a potting or encapsulating compound. This chart is intended to serve as a general guideline to help you determine which categories are best suited for your application. The data presented represents typical properties for each product category; however, individual product properties may differ. It is suggested that, based on the information provided, you consider at least the two best product categories that meet your application criteria. Individual product information can then be found on the pages that follow to help you narrow your search.

This chart should not be used to specify products without specific testing. It is recommended that you conduct on-part testing to ensure product performance before specifying any adhesive.

*Loctite® Adhesives and Sealants Product Specialists are available to assist you with new product designs, or to help you re-engineer an existing application for improved performance and cost savings. They can also set up testing of your parts at the Henkel Customer Engineering Center. For application assistance, call **1-800-LOCTITE** (562-8483) or visit **www.loctite.com** and select "Contact Loctite." In Canada, please call **1-800-263-5043**.*

Potting & Encapsulating Selector Guide

PERFORMANCE CONSIDERATIONS	POTTING AND ENCAPSULATING COMPOUNDS			
	Hot Melts	Polyurethanes	Epoxies	Silicones
BENEFITS	Fast, large gap filling	Excellent toughness/flexibility	Wide range of formulations	Excellent temperature resistance
LIMITATIONS	Low heat resistance	Liquid adhesive sensitive to moisture	Mixing required	Low strength
TEMPERATURE RESISTANCE	-65°C to +125°C	-65°C to +125°C	-65°C to +180°C	-65°C to +200°C
FLUID RESISTANCE				
Polar Solvents ¹	Good (Polyolefins, Polyamides)	Good	Very Good	Good
Non-Polar Solvents ²	Good (Polyamides)	Good	Excellent	Poor
HARDNESS	Semi-soft	Soft	Rigid	Soft
FLEXIBILITY	High	High	Low	Very High
Tg	Low	Low	High	Very Low
PROCESS CONSIDERATIONS	POTTING AND ENCAPSULATING COMPOUNDS			
	Hot Melts	Polyurethanes	Epoxies	Silicones
NUMBER OF COMPONENTS	1	2	2	1
CURE TEMPERATURE	Room Temperature (applied at elevated temperature)	Room Temperature	Room Temperature	UV/Room Temperature
GEL TIME				
Average	60 seconds	1 to 3 hours	1 to 3 hours	30 seconds
Fastest	10 to 20 seconds	15 minutes	15 minutes	5 seconds
FULL CURE TIME	1 hour (or when cooled)	24 hours	24 hours	24 hours
DEPTH OF CURE	Unlimited	Unlimited	Unlimited	Shallow (<1.5")
DISPENSING/CURING EQUIPMENT REQUIRED?	Yes	Yes	Yes	Yes
LIGHT CURE VERSIONS AVAILABLE?	No	No	Yes	Yes
<i>For more information on each compound category refer to pages...</i>	80-81	76-77	76-79	80-81

¹ Examples of Polar Solvents: Water, Ethylene Glycol, IPA, Acetone.

² Examples of Non-Polar Solvents: Motor Oil, Gasoline, Toluene, n-Heptane, ATF.

Epoxies & Polyurethanes

There are a variety of Loctite® potting and encapsulating compounds to choose from – epoxy, hot melt, polyurethane, and silicone. Loctite® potting and encapsulating compounds are designed to protect electrical components from the effects of exposure to chemicals, moisture, thermal shock, mechanical shock, and vibration. Sealing components with Loctite® potting and encapsulating compounds prevents corrosion and ensures long-term integrity of electrical devices.

EPOXIES & POLYURETHANES

Loctite® Hysol® potting and encapsulating compounds are two-part epoxy and polyurethane systems formulated to offer a wide range of performance characteristics matched to specific application requirements. Any epoxy resin can be combined with any epoxy hardener to create a mixed system. The same applies to the polyurethane resins and hardeners.

LOCTITE® HYSOL® EPOXIES					
RESINS	PRODUCT	Item Number	Package Type & Size	Package Weight	Key Features
	3140™	39944 39945*	1 gallon pail 5 gallon pail	12 lbs. 65 lb.	General Purpose
	3141™	39947 39948*	1 gallon pail 5 gallon pail	12 lbs. 63 lbs.	High Temperature
	3142™	39950 39951*	1 gallon pail 5 gallon pail	16 lbs. 65 lbs.	Thermally Conductive
	3145™	40512 40511*	1 gallon pail 5 gallon pail	13 lbs. 65 lbs.	Flame Retardant
HARDENERS	3160™	39958*	5 gallon pail	40 lbs.	Glossy Surface Finish
	3162™	39960 39962*	1 quart can 5 gallon pail	1.8 lbs. 36 lbs.	Fast Cure
	3163™	39964 39965 39966*	1 quart can 1 gallon pail 5 gallon pail	1.7 lbs. 7 lbs. 38 lbs.	Excellent Adhesion
	3164™	39969 39970*	1 gallon pail 5 gallon pail	7 lbs. 40 lbs.	General Purpose
	3165V	39395 39973*	1 quart can 1 gallon pail	1.7 lbs. 7 lbs.	Low Shrinkage

LOCTITE® HYSOL® POLYURETHANES					
RESINS	PRODUCT	Item Number	Package Type & Size	Package Weight	Key Features
	3173™	39984 39985 39986*	1 quart can 1 gallon pail 5 gallon pail	2.5 lbs. 10 lbs. 50 lbs.	General Purpose
	3182™	39995 39996* 39997*	1 gallon pail 5 gallon pail 55 gallon pail	12 lbs. 62 lbs. 625 lbs.	Fast Cure
HARDENERS	3183™	39998 39999*	1 gallon pail 5 gallon pail	7.5 lbs. 37 lbs.	General Purpose
	3184™	39398 39397*	1 gallon pail 5 gallon pail	12 lbs. 625 lbs.	Flame Retardant

* Made-to-order items.

DISPENSING OPTIONS

Loctite® Mix Nozzles are plastic, disposable nozzles that attach directly to Loctite® dispensers. They are designed to automatically mix adhesive as it travels through the static-mix nozzle.

For all available nozzles, accessories, and package sizes, please visit

www.equipment.loctite.com.

Item Numbers: 98430, 98344, 98456, 98457, 98458, 98459, 98460, 98461, 98467, 98469, 98470, 98473, 98474, 98476, 98477, 98478, 989516, and 989518



LOCTITE® HYSOL® EPOXY KITS							
PRODUCT	Item Number	Package Type & Size	COLOR	WORKLIFE	HARDNESS (SHORE)	AGENCY APPROVALS	KEY FEATURES
E-60NC™	29324 29325 29326	50 ml dual cartridge 200 ml dual cartridge 400 ml dual cartridge	Black	60 minutes	85	CFIA	Electrically non-corrosive, low viscosity

LOCTITE® HYSOL® POLYURETHANE SYSTEMS						
SYSTEM CHARACTERISTICS			3173™/3182™	3173™/3183™	3173™/3184™	
TYPICAL UNCURED PROPERTIES	VISCOSITY (cP)	Resin	75	75	75	
		Hardener	30,000	800	14,000	
		Mixed	5,500	450	2,250	
	WORKING TIME	73°F (23°C)	< 7 minutes @ 300 g	20 to 40 minutes @ 105 g	150 minutes @ 300 g	
	GEL TIME	73°F (23°C)	14 minutes @ 300 g	40 to 70 minutes @ 105 g	150 minutes @ 300 g	
	CURE CYCLE	Normal 73°F (23°C)	90 minutes	24 hours	24 hours	
		Alternate 185°F (85°C)	30 minutes	1 to 3 hours	1 to 3 hours	
	MIX RATIO	By Weight (Resin:Hardener)	13:87	30:70	15:85	
		By Volume (Resin:Hardener)	1:5.2	1:3	1:4.8	
	COLOR	Resin	Dark Brown	Clear Brown	Clear Brown	
		Hardener	Black	Opaque Black	Opaque White	
		Mixed	Black	Opaque Black	Opaque White	
	SPECIFIC GRAVITY	Resin	1.23	1.23	1.23	
		Hardener	1.60	0.96	1.45	
		Mixed	1.55	1.06	1.40	
TYPICAL CURED PROPERTIES	Hardness, Shore A		75	70	80	
	Hardness, Shore 00		N/A	N/A	N/A	
	Tg (°C)		-10	-16	-15	
	CTE above Tg (m/mm°C)		128 x 10e-6	190 x 10e-6	151 x 10e-6	
TYPICAL CURED PROPERTIES	DIELECTRIC CONSTANT	0.1 kHz	4.68	5.92	4.51	
		1.0 kHz	4.02	4.36	4.29	
		10.0 kHz	3.76	3.65	3.94	
		100.0 kHz	3.63	3.31	3.56	
	DISSIPATION FACTOR	0.1 kHz	0.13	0.22	0.02	
		1.00 kHz	0.07	0.17	0.04	
		10.0 kHz	0.04	0.10	0.06	
		100.0 kHz	0.02	0.05	0.07	
	Insulation Resistance (ohms)		2.5x10e+13	1.1x10e+11	1.1x10e+12	
	Volume Resistivity (ohms/cm)		1.5x10e+15	6.83x10e+12	6.61x10e+13	
	Dielectric Strength (Volts/mil)		370	375	370	
	Flammability Rating		N/A	N/A	94V-Ø at 3/8"	
	UL File No. E106917		N/A	N/A	94V-2 at 1/4"	

SYSTEM CHARACTERISTICS			LOCTITE® 3140™ HYSOL® EPOXY SYSTEM					LOCTITE® 3141™ HYSOL® EPOXY SYSTEM				
			3140™/ 3160™	3140™/ 3162™	3140™/ 3163™	3140™/ 3164™	3140™/ 3165™	3141™/ 3160™	3141™/ 3162™	3141™/ 3163™	3141™/ 3164™	3141™/ 3165™
TYPICAL UNCURED PROPERTIES	VISCOSITY (cP)	Resin	11,000	11,000	11,000	11,000	11,000	80,000	80,000	80,000	80,000	80,000
		Hardener	180	120	450	105	55	180	120	450	105	55
		Mixed	1,700	2,000	1,500	1,500	2,000	7,000	5,000	4,000	6,000	13,000
	WORKING TIME	73°F (25°C)	80 to 100 min. @ 200 g	5 to 10 min. @ 100 g	80 to 100 min. @ 200 g	10 to 15 min. @ 400 g	1 to 1.5 hrs. @ 400 g	1.5 to 2 hrs. @ 400 g	5 min. @ 200 g	30 to 45 min. @ 200 g	10 min. @ 400 g	35 to 40 min. @ 200 g
	GEL TIME	73°F (25°C)	2.5 to 3 hrs. @ 200 g	10 to 15 min. @ 105 g	2.5 to 3 hrs. @ 200 g	25 to 35 min. @ 400 g	2 to 3 hrs. @ 400 g	2.5 to 3.5 hrs. @ 400 g	10 to 15 min. @ 200 g	60 to 80 min. @ 200 g	20 to 25 min. @ 200 g	65 to 75 min. @ 200 g
	CURE CYCLE	Normal 73°F (25°C)	24 hours	16 hours	24 hours	16 hours	24 hrs./77°F +4 hrs./200°F	24 hours	24 hours	24 hours	24 hours	24 hrs./77°F +4 hrs./200°F
		Alternate 150°F (60°C)	2 hours	1 hour	2 hours	2 hours	N/A	4 hours	2 hours	2 hours	2 hours	N/A
	MIX RATIO	By Weight (R:H)	100:20	100:18.1	100:29	100:29.5	100:9	4:1	100:19.8	100:30	100:31.5	100:9
		By Volume (R:H)	3.1:1	3.6:1	2:1	2:1	6.5:1	2.5:1	3:1	2:1	2:1	6.5:1
	COLOR	Resin	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
		Hardener	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Amber	Amber	Clear
		Mixed	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
	SPECIFIC GRAVITY	Resin	1.64	1.64	1.64	1.64	1.64	1.61	1.61	1.61	1.61	1.61
		Hardener	1.00	0.99	0.96	0.97	0.96	1.00	0.99	0.96	0.97	0.96
		Mixed	1.48	1.48	1.41	1.42	1.55	1.44	1.46	1.40	1.40	1.40
TYPICAL CURED PROPERTIES	Hardness, Shore D		80	80	80	70	85	85	90	80	85	85
	Tg (°C)		27	35	20	27	67	43	75	38	31	104
	CTE above Tg (mm/mm°C)		130x10e-6	125x10e-6	133x10e-6	150x10e-6	119x10e-6	160x10e-6	135x10e-6	138x10e-6	111x10e-6	115x10e-5
	CTE below Tg (mm/mm°C)		44x10e-6	37.5x10e-6	44.9x10e-6	82.6x10e-6	36.0x10e-6	60.7x10e-6	39.7x10e-6	52.6x10e-6	49.2x10e-6	35x10e-6
TYPICAL ELECTRICAL PROPERTIES	DIELECTRIC CONSTANT	0.1 kHz	4.43	4.25	4.61	4.2	4.87	4.30	3.91	3.58	4.11	4.28
		1.0 kHz	4.37	4.20	4.37	4	4.83	4.22	3.88	3.52	3.97	4.18
		10.0 kHz	4.31	4.16	4.20	3.8	4.75	4.14	3.84	3.46	3.87	4.06
		100.0 kHz	4.24	4.10	4.05	3.7	4.64	4.03	3.79	3.39	3.77	3.92
	DISSIPATION FACTOR	0.1 kHz	0.008	0.010	0.040	0.08	0.003	0.01	0.01	0.01	0.02	0.01
		1.0 kHz	0.008	0.011	0.027	0.04	0.007	0.01	0.01	0.01	0.02	0.02
		10.0 kHz	0.010	0.012	0.026	0.03	0.011	0.02	0.01	0.01	0.02	0.02
		100.0 kHz	0.014	0.013	0.023	0.03	0.014	0.02	0.01	0.02	0.02	0.02
	Insulation Resistance (ohms)		1.14x10e+13	2.67x10e+13	1.61x10e+12	7.5x10e+111	5.19x10e+13	5.72x10e+13	4.09x10e+13	1.23x10e+14	4.57x10e+13	2.15x10e+13
	Volume Resistivity (ohms/cm)		6.03x10e+14	2.53x10e+15	1.02x10e+14	1.5x10e+14	2.69x10e+15	4.03x10e+15	2.61x10e+15	7.41x10e+15	2.98x10e+15	1.37x10e+15
	Dielectric Strength (Volts/mil)		365	385	365	410	350	375	355	385	395	365
	Flammability Rating UL File No. E106917		N/A	N/A	N/A	UL 94B @ 1/16"	N/A	N/A	N/A	N/A	N/A	N/A
	Insulation System UL File No. E106917		N/A	N/A	N/A	UL 1446	N/A	N/A	N/A	N/A	N/A	N/A

SYSTEM CHARACTERISTICS			LOCTITE® 3142™ HYSOL® EPOXY SYSTEM					LOCTITE® 3145™ HYSOL® EPOXY SYSTEM				
			3142™ / 3160™	3142™ / 3162™	3142™ / 3163™	3142™ / 3164™	3142™ / 3165™	3145™ / 3160™	3145™ / 3162™	3145™ / 3163™	3145™ / 3164™	3145™ / 3165™
TYPICAL UNCURED PROPERTIES	VISCOSITY (cP)	Resin	95,000	95,000	95,000	95,000	95,000	32,760	32,760	32,760	32,760	32,760
		Hardener	180	120	450	105	55	180	120	450	105	55
		Mixed	7,500	6,000	7,000	8,000	18,000	5,560	7,150	5,315	5,790	13,355
	WORKING TIME	77°F (25°C)	1.5 to 2 hrs. @ 400 g	5 to 10 min. @ 200 g	2 hrs. @ 400 g	25 min. @ 400 g	80 min. @ 400 g	2.5 to 4 hrs. @ 200 g	15 to 30 min. @ 200 g	3 to 3.5 hrs. @ 200 g	35 to 45 min. @ 200 g	2.5 to 3 hrs. @ 400 g
	GEL TIME	77°F (25°C)	3.5 to 4 hrs. @ 400 g	5 to 30 min. @ 200 g	> 3 hrs. @ 400 g	50 min. @ 400 g	2.5 hrs. @ 400 g	6 to 8 hrs. @ 200 g	35 to 45 min. @ 200 g	6 to 7 hrs. @ 200 g	75 to 90 min. @ 200 g	5 hrs. @ 200 g
	CURE CYCLE	Normal 77°F (25°C)	24 hours	24 hours	48 hours	24 hours	24 hrs./77°F +4 hrs./200°F	24 hours	24 hours	24 hours	24 hours	24 hrs./77°F +2 hrs./200°F
		Alternate 150°F (66°C)	4 hours	2 hrs.	4 hrs.	2 hrs.	4 hrs./+200°F	2 hours	2 hours	4 hours	2 hours	4 hrs./+200°F
	MIX RATIO	By Weight (R:H)	100:10.7	100:9	100:10.9	100:14.3	100:4.1	100:15	100:13	100:15.5	100:20	100:6
		By Volume (R:H)	3.8:1	4.5:1	3.6:1	2.8:1	9.7:1	4:1	4.5:1	3.7:1	2.9:1	9.7:1
	COLOR	Resin	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
		Hardener	Clear	Clear	Amber	Amber	Clear	Clear	Clear	Clear	Clear	Clear
		Mixed	Black	Black	Black	Black	Black	Black	Black	Black	Black	Black
	SPECIFIC GRAVITY	Resin	2.40	2.40	2.40	2.40	2.40	1.67	1.67	1.67	1.67	1.67
		Hardener	1.00	0.99	0.96	0.97	0.96	1.00	0.99	0.96	0.97	0.96
		Mixed	1.54	1.54	1.53	1.50	1.62	1.51	1.54	1.49	1.49	1.58
TYPICAL CURED PROPERTIES	Hardness, Shore D		90	90	90	85	90	80	84	80	75	88
	Tg (°C)		26	42	30	29	84	28	42	38	32	53
	CTE above Tg (mm/mm°C)		104x10e-6	97.2x10e-6	96.1x10e-6	106x10e-6	87.7x10e-6	1.22x10e-6	128x10e-6	130x10e-6	122x10e-6	111x10e-6
	CTE below Tg (mm/mm°C)		29.2x10e-6	28.2x10e-6	33.5x10e-6	51.9x10e-6	26.9x10e-6	39.2x10e-6	42.6x10e-6	49.0x10e-6	59.4x10e-6	40.6x10e-6
	THERMAL CONDUCTIVITY	Watts/Meter°C	0.422	1.40	1.40	1.27	1.14	0.7935	0.8068	0.8119	0.7324	1.0341
TYPICAL ELECTRICAL PROPERTIES	DIELECTRIC CONSTANT	0.1 kHz	5.77	4.87	5.28	5.51	5.65	4.08	3.81	4.27	4.19	4.43
		1.0 kHz	5.69	4.83	5.20	5.35	5.57	4.28	3.85	4.36	4.46	4.45
		10.0 kHz	5.62	4.78	5.12	5.21	5.46	4.15	3.74	4.11	4.22	4.28
		100.0 kHz	5.52	4.72	5.02	5.06	5.34	4	3.63	3.90	3.99	4.11
	DISSIPATION FACTOR	0.1 kHz	0.00	0.01	0.01	0.02	0.01	0.027	0.028	0.033	0.036	0.045
		1.0 kHz	0.001	0.01	0.01	0.02	0.01	0.031	0.025	0.046	0.042	0.036
		10.0 kHz	0.01	0.01	0.01	0.02	0.01	0.025	0.021	0.037	0.037	0.027
		100.0 kHz	0.01	0.01	0.01	0.02	0.01	0.023	0.017	0.031	0.034	0.024
	Insulation Resistance (ohms)		4.61x10e+13	5.31x10e+13	3.65x10e+13	2.75x10e+12	4.09x10e+13	Not Tested	Not Tested	Not Tested	Not Tested	Not Tested
	Volume Resistivity (ohms/cm)		3.00x10e+15	3.47x10e+15	2.55x10e+15	1.65x10e+14	2.61x10e+15	1.10e+14	8.4e+14	2.1e+14	2.5e+13	7.3e+14
	Dielectric Strength (Volts/mil)		360	345	355	345	335	595	693	748	695	794
	Flammability Rating UL File No. E106917		N/A	N/A	N/A	N/A	N/A	N/A	UL 94V-0 @ 1/8"	N/A	N/A	UL 94V-0 @ 1/8"

Hot Melts & Silicones



HOT MELT ADHESIVES

In addition to structural bonding, Loctite® Hysol® hot melt adhesives are also well suited for fast, deep potting applications requiring large gap fills in a high speed manufacturing environment.

LOCTITE® 1942™ HYSOL® HOT MELT ADHESIVE

General Purpose

Medium setting, general purpose hot melt adhesive. Excellent adhesion to wood and many plastics.

LOCTITE® 7901™ HYSOL® HOT MELT ADHESIVE

Polyamide

Low viscosity polyamide used extensively for potting and encapsulating.

SILICONE POTTING COMPOUNDS

Loctite® silicones are single-component, tough protective potting and encapsulating compounds that seal components against moisture, solvents, and environmental conditions. Loctite® Nuva-Sil® products cure in as little as 30 seconds to depths of 0.150" when exposed to UV light or visible light, while Loctite® RTV silicones cure in 24 hours at room temperature when exposed to atmospheric moisture.

LOCTITE® 5031™ NUVA-SIL® SILICONE POTTING COMPOUND

High Adhesion/Visible Light

A low viscosity, self-leveling, UV or visible light curing silicone for high speed deep potting, coating and sealing applications. Provides high adhesion for difficult-to-bond substrates.

LOCTITE® 5040™ RTV SILICONE POTTING COMPOUND

A non-corrosive, self-leveling RTV silicone for shallow potting, sealing and coating of devices, especially for military and industrial applications.

DISPENSING OPTIONS

Loctite® Meter Mix 3000 Dispense Systems – Programmable Shot Size

are versatile dispensing systems for two-part adhesive chemistries and incorporates a variety of feed system options. Available in fixed or variable ratio, these systems offer programmable shot size and integrated PLC controls with convenient touch screen capability. For available valves, spare parts, accessories and dispense tips, please visit www.equipment.loctite.com.

Item Numbers: Fixed: 988908, Variable: 988909

Dimensions: 20" H x 15" W x 28" D

Weight: 75 to 100 lbs.

Package Types & Sizes: Cans, pails, drums, totes



DISPENSING OPTIONS

Loctite® Hysol™ Bulk-34 System is a compact and efficient bulk hot melt unit capable of manual or automatic product delivered up to 75 lbs./hr. This CE certified unit has three independent temperature controls for the tank, hosing and dispense valves that will provide an effective extrusion or spray application for a wide range of hot melt adhesives. For available valves, spare parts, accessories and dispense tips, please visit www.equipment.loctite.com.

Item Number: 98135 **Voltage:** 230
Standard Tank Capacity: 34 lbs. (15.4 kg)
System Power Consumption: 6600 Watts



Loctite® Hysol™ Bulk Hot Melt System Applicators

Henkel offers accurate and convenient styles of dispense applicators. For available valves, spare parts and applicators, please visit

www.equipment.loctite.com.

Item Numbers: 98145, 98146, 98147, 98148, and 98149



For similar equipment, please see our **Loctite® Equipment Sourcebook, LT-3669** or visit us at www.equipment.loctite.com.

Loctite® Hysol® Hot Melt Adhesives Properties Chart

PRODUCT	Item Number	Package Type & Size	COLOR	VISCOSITY (cP) AT DISPENSE TEMPERATURE	TENSILE STRENGTH (PSI)	OPEN TIME	TEMPERATURE RESISTANCE	% ELONGATION	HARDNESS (SHORE A)	AGENCY APPROVALS
1942™ Hysol®	83266	5 lb. sample bag pellets	Tan	5,000	250	30 seconds	142°F	500	N/A	FDA CFR175,105
	83267	40 lb. carton pellets								
	83268	Maxistick™ 7 oz. sample bag								
	83269	Maxistick™ 35 lb. carton								
	83271	PT™ stick 36 lb. carton								
	83272	Ministick™ 35 lb. carton								
	83273	Superstick™ 10" 5 oz. sample bag								
	83274	Superstick™ 10" 25 lb. bag								
	83275	Superstick™ 4" 25 lb. carton								
	83276	Polyshot™ 12 oz. sample bag								
	83277	Polyshot™ 35 lb. Carton								
3650™ Hysol®	31302	22 lb. pellets	Light Beige	2,900	305	60 to 80 seconds	176°F	43	87	N/A
	31297	44 lb. pellets								
3651™ Hysol®	31303	26.4 lb. squares	Beige	10,000	334	80 to 100 seconds	266°F	790	55	N/A
7809FR™ Hysol®	83388	5 lb. sample bag pellets	Amber	7,000	363	35 seconds	240°F	373	85	UL Classified for U.S.
	83390	Superstick™ 10" 13 oz. sample bag								
	83391	Polyshot™ 13 oz. bag								
7811™ Hysol®	83337	5 lb. sample bag pellets	Amber	6,400	400	35 seconds	266°F	1,200	N/A	N/A
	83339	Polyshot™ 13 oz. sample bag								
	83340	Polyshot™ 25 lb. pail								
7901™ Hysol®	83341	5 lb. sample bag pellets	Amber	750	260	35 seconds	300°F	80	84	N/A
	83342	40 lb. carton pellets								
	83343	Polyshot™ 13 oz. sample bag								
	83344	Polyshot™ 25 lb. pail								

Loctite® Silicone Potting Compounds Properties Chart

PRODUCT	Item Number	Package Type & Size	CURE SCHEDULE (CURE/ALT. CURE)	VISCOSITY (cP)	GEL TIME	HARDNESS	AGENCY APPROVALS
5031™ Nuva-Sil®	40086	300 ml cartridge	UV/visible light/moisture 60 seconds @ 40 mW/cm ²	5,500	Seconds	34 shore A	N/A
	40087	40 lb. pail					
5040™	40405	85 g tube	Moisture 24 hours @ 25°C	35,000	< 3 hours (skin over)	30 shore A	MIL-A-46146B
	40404	300 ml cartridge					
	40407	40 lb. pail					
5091™ Nuva-Sil®	17412	300 ml cartridge	UV/moisture 60 seconds @ 40 mW/cm ²	5,500	Seconds	34 shore A	UL Classified for U.S.
	18074	40 lb. pail					