

Advanced Materials**Epibond® 1544-1 A/C Epoxy Adhesive****FEATURES :**

- Flame Retardant
- Gap Filling Properties
- Early Green Strength
- Off White

DESCRIPTION :

Epibond® 1544-1 A/C epoxy adhesive is a two-component off-white paste. The epoxy adhesive is non-flowing on vertical surfaces and forms excellent bonds between metals, composite laminates, most thermoplastics, and many other dissimilar materials. Epibond® 1544-1 A/C epoxy adhesive can be used to fabricate or repair aircraft interior parts which fulfill FAR 25.853 and O.S.U. requirements when used in conjunction with other flame retardant components. This adhesive is also available in different colors (Epibond® 1544-1 A-71/D Adhesive - White and Epibond® 1544-1 A-82/D - Beige).

TYPICAL PROPERTIES AS SUPPLIED :

Property	1544-1A Resin	1544-C Hardener	1544-1A/C Mixed System	Test Method
Color	Off-White	Cream	Off-White	Visual
Density, g/cc	1.30	1.00	1.25	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	110,000	Paste	Semi-Paste	ASTM-D-2196
Gel time, 100gm at 77°F (25°C), minutes	--	--	20	ASTM-D-2471

MIX RATIO :

To 100 parts by weight of Epibond® 1544-1A resin, add 13 parts by weight of Epibond® 1544 C hardener (same mix ratio applies to all color variations). Mix both components thoroughly for several minutes to assure complete mixing. Avoid air entrapment during mixing.

CURE SCHEDULE :

Twenty-four hours at 77°F (25°C), or gel at 77°F (25°C) plus one hour at 150°F (66°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

Tensile lap shear strength, psi (MPa)

Test Conditions	Results, psi (MPa)	Test Method
Al/Al after 24 hours at 77°F (25°C)	1900 (13.1)	ASTM-D-1002
Al/Al 20 minutes at 250°F 121°C)	3050 (21.0)	--
Al/Al after 7 days immersion in Jet-A	3030 (20.9)	--
Al/Al after 7 days immersion in water	2020 (13.9)	--
Al/Al after 7 days immersion in Mil-S-3136 Type III fluid	2950 (20.3)	--

Flammability (with glass cloth), 60-second ignition, vertical

Self-extinguishing time, second	<1
Burn length, inch	1.5
Drip extinguishing time, second	No drip

STORAGE :

Epibond® 1544-1 Adhesives should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+36 °F and 104°F). The product should not be exposed to direct sunlight. Under these storage conditions, and when supplied under Huntsman standard certification, these adhesive have a shelf life of 2 years (expiration date may differ based on customer specification).

The temperature of both components should be above 18°C (65°F) prior to mixing. After use, tightly reseal containers.

PRECAUTIONARY STATEMENT :

Huntsman Advanced Materials Americas LLC maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material.

First Aid!

Please refer to MSDS

KEEP OUT OF REACH OF CHILDREN

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