

**Advanced Materials****Epocast® 1615-A/B****EPOXY SYNTACTIC**

- Low Density
- Self Extinguishing
- Short Work Life

**DESCRIPTION :**

Epocast® 1615-A/B epoxy syntactic is a low-density edge sealant for honeycomb structures that features flame resistance, high strength, and ease of handling. Epocast® 1615-A/B epoxy syntactic cures to an off-white color and is qualified to BMS 5-28, Type 15.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>1615-A Resin</u>	<u>1615-B Hardener</u>	<u>1615-A/B System</u>	<u>Test Method</u>
Color	Off-white	Amber	Off-white	Visual
Density, g/cc	0.65	1.05	0.70	ASTM-D-1622
Viscosity, cP at 77°F (25°C)	Paste	400	Paste	ASTM-D-2196
Gel time, 50 gms at 77°F (25°C), minutes	--	--	15	ASTM-D-2471
Shelf life at 77°F, unopened, months	6*	6	--	--

NOTE: \*Resin/filler separation may occur in Epocast® 1615A resin. Material must be remixed before dispensing from container.

**MIX RATIO :**

To 100 parts by weight of Epocast® 1615-A resin, add 14 parts by weight of Epocast® 1615-B hardener. Mix both components thoroughly for several minutes to assure complete blending.

**CURE SCHEDULE :**

24 hours at 77°F (25°C) or gel at room temperature plus five hours at 125°F (52°C).

**TYPICAL CURED PROPERTIES (Not for specification purposes)**

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Tensile lap shear, after 5 hours at 125°F (52°C), psi (MPa)	700 (4.8)	ASTM-D-1002
Compressive strength, Ksi (MPa) at 77°F (25°C)	6.0 (41.3)	ASTM-D-695
Compressive modulus, Ksi (MPa) at 77°F (25°C)	450 (3,103)	--
Flammability, horizontal	self extinguishing	--
vertical	self extinguishing	--
Flow at 77°F (25°C), in. (cm), maximum	1.0 (2.5)	BMS-5-28
at 125°F (52°C)	2.0 (5.0)	--
Weight gain on immersion, after 24 hours at 77°F (25°C), %		ASTM-D-543
TT-S-735, Type III test fluid	1.0	--
Mil-M-5606 hydraulic fluid	2.1	--
Skydrol 500-A	2.0	--
distilled water	2.0	--

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**STORAGE/** Syntactic epoxy resins and hardeners should be stored in a dry place in their original, sealed

**SHELF LIFE :** containers at temperatures from 60-90°F (16-32°C). Material temperatures should be above 65°F (18°C) when mixing. After use, tightly reseal containers. Frozen materials should be stored at 0°F (-18°C) or colder and allowed to thaw at room temperature before use.

Under these conditions, syntactic epoxy resins and hardeners will remain useable for 6 months from date of shipping from Huntsman.

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**CAUTION :**

Huntsman Advanced Materials Americas Inc. 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. Copies of the latest MSDS may be requested by calling our customer service group at 800-367-8793 or emailing your request to [adhesives\\_group@huntsman.com](mailto:adhesives_group@huntsman.com).

**FIRST AID !**

Eyes and skin: Flush eyes with water for 15 minutes. Contact a physician if irritation persists. Wash skin thoroughly with soap and water. Remove and wash contaminated clothing before reuse.

Inhalation: Remove subject to fresh air.

Swallowing: Dilute by giving water to drink and contact a physician promptly. Never give anything to drink to an unconscious person.

**KEEP OUT OF REACH OF CHILDREN****FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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