

Advanced Materials**Epocast[®] 1628-A/B****EPOXY SYNTACTIC**

- Ultra Low Density Paste
- Self Extinguishing
- Extrudable, Non Sag

DESCRIPTION :

Epocast[®] 1628-A epoxy resin is a soft white paste that, after blending with yellow-colored Epocast[®] 1628-B hardener, becomes a pale yellow, ultra low density epoxy syntactic for edge reinforcing of honeycomb structures. The lightweight epoxy paste may be extruded from pneumatic equipment or spread with a putty knife or trowel to fill honeycomb core sections or edges of composite sandwich constructions. Epocast[®] 1628-A/B epoxy syntactic can be easily sanded or machined after cure. Epocast[®] 1628-A/B epoxy syntactic is qualified to BMS 5-28, Type 28.

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>1628-A Resin</u>	<u>1628-B Hardener</u>	<u>1628-A/B System</u>	<u>Test Method</u>
Color	White	Yellow	Pale yellow	Visual
Density, g/cc	0.45	0.52	0.50	ASTM-D-1622
Viscosity, cP at 77°F (25°C)	Paste	Paste	Paste	ASTM-D-2196
Gel time, 60 gms at 77°F (25°C), minutes	--	--	65	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	6	6	--	FTM -204

MIX RATIO :

To 100 parts by weight of Epocast[®] 1628-A resin, add 25 parts by weight of Epocast[®] 1628-B hardener. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

CURE SCHEDULE :

48 hours at 77°F (25°C), or gel at room temperature plus 5 hours at 125°F (52°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Compressive strength, at 77°F (25°C), psi (MPa)	2,800	ASTM-D-695
Compressive modulus, at 77°F (25°C), Ksi (MPa)	230	--
Tensile lap shear, etched AL/AL, psi (MPa)	800	ASTM-D-1002
Flammability, 60-second vertical, Extinguish Time, seconds	0	FAR 25.853
Burn Length, in. (cm)		3 (7.6)
Weight gain on immersion after 24 hours at 77°F (25°C), %		ASTM-D-543
Mil-S-3136, Type III test fluid	1.5	--
Mil-M-5606, hydraulic fluid	2.5	--
Skydrol 500-A	3.5	--
Distilled water	3.4	--

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.

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.

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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