

Advanced Materials**Epocast[®] 1656-A/B****EPOXY SYNTACTIC**

- Low Density
- Thick Paste Consistency
- Long Work Life

DESCRIPTION :

Epocast[®] 1656-A/B epoxy syntactic is a low-density compound with good elevated temperature properties after a room-temperature cure. The epoxy syntactic is useful as a core fill for metal skins to add stiffness and strength to fabricated parts and is also suitable for core splicing and strengthening radii and corners of reinforced plastic structures. Epocast[®] 1656-A/B epoxy syntactic meets requirements of GM-4006-1-2.

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>1656-A Resin</u>	<u>1656-B Hardener</u>	<u>1656-A/B System</u>	<u>Test Method</u>
Color	Lt. Tan	Amber	Lt. Tan	Visual
Density, gm/cc	0.80	1.00	0.80	ASTM-1622
Viscosity, cP at 77°F (25°C)	Paste	500	Paste	ASTM-D-2196
Gel time, 100 gms at 77°F (25°C), minutes	--	--	50-90	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	6	6	--	--

MIX RATIO :

To 100 parts by weight of Epocast[®] 1656-A resin, add 12 parts by weight of Epocast[®] 1656-B hardener. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

CURE SCHEDULE :

7 days at 77°F (25°C) or gel at 77°F (25°C) followed by 2-3 hours at 150°F (66°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Tensile lap shear, etched AL/AL, at 77°C (25°C), psi (MPa)	700 (4.8)	ASTM-D-1002
Compressive strength (2% strain), psi (MPa)		
at -67°F (-55°C)	9,500 (65.5)	ASTM-D-695
at 77°F (25°C)	8,000 (55.2)	--
at 180°F (83°C)	3,000 (20.6)	--
at 350°F (177°C)	550 (3.8)	--
Flatwise tensile strength at 74°F (23°C), psi (MPa)	2000 (13.8)	ASTM-C-297
at 160°F (71°C)	1000 (6.9)	--

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

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