

**Advanced Materials****Epocast<sup>®</sup> 1511-A/B****EPOXY SYNTACTIC**

- High Density
- Non-Flow Edge Filler
- 40-60 Minute Work Life
- Room Temperature Cure

**DESCRIPTION :**

Epocast<sup>®</sup> 1511-A/B epoxy syntactic is a non-flowing, two-part paste suitable for edge filling of honeycomb structures and/or metal fairings as well as for bonding applications. Epocast<sup>®</sup> 1511-A/B epoxy syntactic is qualified to BMS 5-28, Type 3.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>1511-A Resin</u>	<u>1511-B Hardener</u>	<u>1511-A/B System</u>	<u>Test Method</u>
Color	Gray	Off-white	Gray	Visual
Density, g/cc.	1.20	1.15	1.25	ASTM-D-1622
Viscosity, cP @ 77°F (25°C)	195,000	Paste	Paste	ASTM-D-2196
Work life, 50 gms at 77°F (25°C), minutes	--	--	40-60	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	12	12	--	--

**MIX RATIO :**

To 100 parts by weight of Epocast<sup>®</sup> 1511-A resin, add 15 parts by weight of Epocast<sup>®</sup> 1511-B hardener. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

**CURE SCHEDULE :**

24 hours at room temperature 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>
Flow maximum, in. (cm)	2.5 (6.4)	BMS 5-28
Compressive strength at 77°F (25°C), Ksi (MPa)	10.0 (69)	ASTM-D-695
Compressive modulus at 77°F, Ksi (MPa)	45 (310)	ASTM-D-695
Tensile lap shear strength, chromic acid etched aluminum, psi (MPa)	1200 (8.3)	ASTM-D-1002
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-H-5606, hydraulic fluid	1.0	
Skydrol 500-A	1.0	
Distilled water	1.0	

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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 12 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).

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**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.

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

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