

Advanced Materials**Epocast[®] 1625-A/B****EPOXY SYNTACTIC**

- Core Reinforcing Compound
- 350°F (177°C) Capabilities
- High Strength

DESCRIPTION :

Epocast[®] 1625-A/B epoxy syntactic is an aluminum-filled, high-viscosity, core-reinforcing compound that exhibits outstanding compressive strength and resistance to deformation under load at temperatures up to 350°F (177°C). The high-performance product can be extruded to fill honeycomb core for reinforcing panels to be installed in areas exposed to high temperatures. Epocast[®] 1625-A/B epoxy syntactic is qualified to BMS 5-28, Type 25.

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>1625-A Resin</u>	<u>1625-B Hardener</u>	<u>1625-A/B System</u>	<u>Test Method</u>
Color	Gray	Gray	Visual	
Density, g/cc	1.8	1.0	1.7	ASTM-D-792
Viscosity, cP at 77°F (25°C)	>100,000	450	>100,000	ASTM-D-2196
Gel time, 100 gms at 77°F (25°C), hours	--	--	1-2	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	12	12	--	--

MIX RATIO :

To 100 parts by weight of Epocast[®] 1625-A resin, add 5.7 parts by weight of Epocast[®] 1625-B hardener. Mix both components thoroughly for 3-5 minutes to assure complete dispersion.

CURE SCHEDULE :

Gel at room temperature and cure 30 minutes at 200°F (93°C), plus 1 hour at 250°F (121°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Tensile lap shear, etched AL/AL, psi (MPa)	1,700 (11.7)	ASTM-D-1002
Compressive strength:		
Tested at 77°F (25°C)		
after 24 hours at 77°F (25°C), Ksi (MPa)	11.5 (79.3)	ASTM-D-695
after 30 min. at 200°F (93°C) + 1 hr. at 250°F (121°C)	28.0 (193)	--
after 14 days at 350°F (177°C)	26.0 (179.3)	--
Tested at 350°F (177°C) after 14 days at 350°F (177°C)	10.0 (68.9)	--
Compressive modulus:		
Tested at 77°F (25°C)		
after 24 hours at 77°F (25°C), Ksi (MPa)	370 (2,552)	ASTM-D-695
after 30 min. at 200°F (93°C) + 1 hr. at 250°F (121°C)	770 (5,310)	--
after 14 days at 350°F (177°C)	490 (3,379)	--
Tested at 350°F (177°C) after 14 days at 350°F (177°C)	110 (758.6)	--
Flammability, self-extinguishing, seconds, max	10	BSS -7230

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.

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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Main Offices :

Huntsman Corporation
10003 Woodloch Forest Dr.
The Woodlands
Texas 77380
(281) 719-6000

**Huntsman Advanced Technology
Center**
8600 Gosling Rd.
The Woodlands
Texas 77381
(281) 719-7400