

**Advanced Materials****Epocast<sup>®</sup> 169-A Resin  
Hardener 9615****EPOXY SYNTACTIC**

- General Purpose Syntactic
- Low Density
- Sandable, Machinable

**DESCRIPTION :**

Epocast<sup>®</sup> 169-A resin/Hardener 9615 epoxy syntactic is a low-density foam which cures at room temperature to a carvable, wood-like product. The material has good dimensional stability under changing humidity conditions. Epocast<sup>®</sup> 169-A resin/Hardener 9615 epoxy syntactic is qualified to SS-9587, Type 1.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>169-A Resin</u>	<u>9615 Hardener</u>	<u>169-A/9615 System</u>	<u>Test Method</u>
Color	Red-brown	Amber	Red-brown	Visual
Density, g/cc	0.56	0.96	0.68	ASTM-D-1622
Viscosity, cP at 77°F (25°C)	Paste	35,000	Semi-paste	ASTM-D-2196
Gel time, 100 gms at 77°F (25°C), minutes	--	--	90-120	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> 169-A resin, add 50 parts by weight of Hardener 9615. Mix both components thoroughly for 3-5 minutes to insure complete and uniform mixing.

**CURE SCHEDULE :**

24 hours at 75°F ± 5°F (23°C ± 3°C), or room temperature gel plus 2 hours at 150°F ± 10°F (66°C ± 6°C).

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

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Compressive strength, psi (MPa)	2,000 (13.8)	ASTM-D-695
Tensile lap shear, AL/AL, psi (MPa)	1,200 (8.3)	ASTM-D-1002

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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).

**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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