

**Advanced Materials****Epocast<sup>®</sup> 8623-A  
Hardener 946****EPOXY SYNTACTIC**

- Low Density Potting Compound
- Fast Curing
- Self-Extinguishing

**DESCRIPTION :**

Epocast<sup>®</sup> 8623-A/Hardener 946 epoxy syntactic is a two-part, core-filling compound with a soft paste viscosity that provides for easy extrudability through a 1/8-in. (3mm) nozzle. Epocast<sup>®</sup> 8623-A/Hardener 946 epoxy syntactic is self-extinguishing and cures fast at room temperature, permitting filled edges to be sanded within 3-4 hours.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>8623-A Resin</u>	<u>946 Hardener</u>	<u>8623-A/946 System</u>	<u>Test Method</u>
Color	White	Amber	Off-white	Visual
Specific gravity	0.65	1.00	0.70	ASTM-D-792
Viscosity, cP @ 77°F (25°C)	Paste	350	Soft-paste	ASTM-D-2393
Flash point, COC, °F (°C)	>366 (186)	210 (99)	--	ASTM-D-92
Work life, 100 gms at 77°F (25°C), minutes	--	--	12-20	ASTM-D-1338
Shelf life at 77°F (25°C), unopened, months	12	12	--	FTM -204
Solids, %	--	--	100	ASTM-D-1644

**MIX RATIO :**

Too 100 parts by weight of Epocast<sup>®</sup> 8623-A resin, add 14 parts by weight of Hardener 946. Mix both components thoroughly for 2-3 minutes to insure complete and uniform mixing.

**CURE SCHEDULE :**

24 hours at 77°F (25°C) or gel at 77°F (25°C), plus 1 hour at 150°F (66°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)	4,000 (27.6)	ASTM-D-695
Compressive modulus, at 77°F (25°C), Ksi (MPa)	150 (1,034)	ASTM-D-695
Tensile lap shear strength, etched al/al, at 77°F (25°C), psi (MPa)	1,600 (11)	ASTM-D-1002
Flammability, self-extinguishing, seconds	30	BMS-5-28
Weight gain on immersion after 24 hours, at 77°F (25°C), %		ASTM-D-570
Mil-S-3136, Type III test fluid	+0.3	
Mil-M-5606, hydraulic fluid	+0.4	
Skydrol 500-A	+0.6	
Distilled water	+1.5	

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**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 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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