

**Advanced Materials****Epocast<sup>®</sup> 8623-A Resin  
Hardener 9861****EPOXY SYNTACTIC**

- Low Density Potting Compound
- One Hour Work Life
- Self-Extinguishing

**DESCRIPTION :**

Epocast<sup>®</sup> 8623-A resin/Hardener 9861 epoxy syntactic is a two-part, core-filling compound with a soft paste consistency for easy extrusion through a 1/8-in. (3mm) nozzle. Epocast<sup>®</sup> 8623-A resin/Hardener 9861 epoxy syntactic is self-extinguishing and cures at room temperature, if desired. Elevated temperature cure or post cure will improve elevated temperature properties.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>8623-A Resin</u>	<u>9861 Hardener</u>	<u>8623-A/9861 System</u>	<u>Test Method</u>
Color	White	Amber	Off-White	Visual
Density, g/cc.	0.65	1.05	0.70	ASTM-D-1622
Viscosity, cP @ 77°F (25°C)	Paste	18,000	Soft-paste	ASTM-D-2196
Extrudability, 1/8 in. (3mm) nozzle at 80 psi (5 bars), gm/min.	--	--	30	--
Gel time, 100 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> 8623-A resin, add 20 parts by weight of Hardener 9861. Mix both components thoroughly for several minutes to assure complete blending.

**CURE SCHEDULE :**

24 hours at 77°F (25°C), or gel at 77°F (25°C), plus 1 hour at 180-200°F (83-93°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)	5,000 (34.5)	ASTM-D-695
Compressive modulus at 77°F (25°C), Ksi (MPa)	250 (1,724)	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	<10	BMS-5-28
Weight gain on immersion after 24 hours at 77°F (25°C), %		ASTM-D-543
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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