

Advanced Materials

Epocast® 1633-A/B

EPOXY SYNTACTIC

Self -extinguishing
 Quick-setting
 Two-to-one mix ratio

DESCRIPTION :

Epocast® 1633-A/B epoxy syntactic is a medium paste, halogen-free self-extinguishing compound designed for potting fasteners in honeycomb structures. The epoxy syntactic is easily extruded through 1/8 in. (3mm) nozzle orifice, but is non-flowing after application. It is easy to handle in isolated repair areas because the syntactic paste is available in dual-barrel cartridges. Epocast® 1633-A/B epoxy syntactic sets quickly at room temperature.

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>1633-A Resin</u>	<u>1633-B Hardener</u>	<u>1633-A/B System</u>	<u>Test Method</u>
Color	Light Blue	Off-white	Light Blue	Visual
Density, g/cc	0.68	0.66	0.73	ASTM-D-792
Viscosity at 77°F (25°C)	Soft-paste	Soft-paste	Paste	ASTM-D-2196
Work life, 10 grams at 77°F (25°C), minutes	--	--	2-5	ASTM-D-1338
Shelf life at 77± 15°F (25°C ± 8°C), unopened, months	12	12	--	--

MIX RATIO :

To 100 parts by weight of Epocast® 1633-A resin, add 50 parts by weight of Epocast® 1633-B hardener. Mix both components thoroughly for 1 minute to assure complete blending.

CURE SCHEDULE :

Gel at room temperature plus 5 hours at 120°F (49°C) or gel at room temperature plus 2 hours at 150°F (66°C) or 3 days at room temperature.

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)	6,500 (44.8)	ASTM-D-695
Compressive modulus, Ksi (MPa)	270 (1,862)	ASTM-D-695
Tensile lap shear, chromic acid etched al/al, psi (MPa)	1,400 (9.6)	ASTM-D-1002
Percent weight gain, 24 hours immersion at 77°F (25°C)		ASTM-D-570
TTS-735, Type III test fluid	0.3	--
Mil-M-5606 hydraulic fluid	0.4	--
Skydrol 500-A	0.7	--
Distilled water	2.5	--

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.

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

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