



Advanced Materials

**Epocast® 8623-A Resin
 Hardener 9861**

EPOXY SYNTACTIC

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

DESCRIPTION :

Epocast® 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® 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

MIX RATIO :

To 100 parts by weight of Epocast® 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)

Test	Result	Test Method
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	

STORAGE :

Epocast® 8623-A resin/Hardener 9861 should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). The product should not be exposed to direct sunlight. Under these storage conditions, and when supplied under Huntsman standard certification, this product has a shelf life of 1 year (expiration date may differ based on customer specification).

Material temperatures should be above 18°C (65°F) when mixing. After use, tightly reseal containers.

PRECAUTIONARY STATEMENT :

Huntsman Advanced Materials Americas LLC 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.

First Aid!

Refer to MSDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

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