

Advanced Materials**Epocast[®] 1628 A/B Epoxy Syntactic**

- **Ultra Low Density Paste**
- **Flame Retardant**
- **Extrudable, Non Sag**

DESCRIPTION

Epocast[®] 1628 A epoxy resin is a soft white paste that, after blending with yellow-colored Epocast[®] 1628 B hardener, becomes a pale yellow, ultra low density epoxy syntactic for edge reinforcing of honeycomb structures. The lightweight epoxy paste can be spread with a putty knife or trowel to fill honeycomb core sections or edges of composite sandwich constructions. Epocast[®] 1628 A/B epoxy syntactic can be easily sanded and machined once cured. Epocast[®] 1628 A/B epoxy syntactic is qualified to BMS 5-28, Type 28.

TYPICAL PROPERTIES AS RECEIVED

Property	Test Method	1628 A Resin	1628 B Hardener	Mixed System
Color	Visual	White	Yellow	Pale Yellow
Density, g/cc	ASTM D1622	0.45	0.52	0.50
Viscosity at 77°F (25°C), cP	ASTM D2196	Paste	Paste	Paste
Gel Time, 60g at 77°F (25°C), min	ASTM D2471	--	--	65

MIX RATIO

To 100 parts by weight of Epocast[®] 1628 A resin, add 25 parts by weight of Epocast[®] 1628 B hardener. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

CURE SCHEDULE

48 hours at 77°F (25°C), or gel at room temperature plus 5 hours at 125°F (52°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

Property	Test Method	Results
Compressive Strength, psi (MPa) at 77°F (25°C) at 180°F (82°C) at 250°F (121°C)	ASTM D695	2,800 (19.3) 600 (4.1) 550 (3.8)
Compressive Modulus, ksi (GPa) at 77°F (25°C)	ASTM D695	230 (1.6)
Tensile lap shear, Al-Al, psi (MPa) at 77°F (25°C)	ASTM D1002	800 (5.5)
Flammability, 60-second vertical Extinguish Time, seconds Burn Length, in. (cm)	FAR 25.853	0 0.3 (7.6)
Weight gain on immersion after 24 hours at 77°F (25°C), % Mil-S-3136, Type III test fluid Mil-M-5606, hydraulic fluid Skydrol 500-A Distilled water	ASTM D543	1.5 2.5 3.5 3.4

STORAGE

Epocast® 1628 A/B 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 6 months from date of shipment (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.

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