

Advanced Materials**Epocast[®] 8623-A
Hardener 946****EPOXY SYNTACTIC**

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

DESCRIPTION :

Epocast[®] 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[®] 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
Solids, %	--	--	100	ASTM-D-1644

MIX RATIO :

Too 100 parts by weight of Epocast[®] 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)

Test	Result	Test Method
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	

STORAGE :

Epocast[®] 8623-A/Hardener 946 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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