

**Advanced Materials****Epocast® 1610-A2 Epoxy Syntactic**

- **Flame Retardant**
- **Very Low Density**
- **One Component**

**DESCRIPTION**

Epocast® 1610-A2 epoxy syntactic is a very low density, flame retardant, one component system with a long storage life at room temperature. It can be co-cured with composites in 60 minutes at 260°F (127°C). Epocast® 1610-A2 epoxy syntactic is well suited for replacing pre-cured foam or wood blocks in honeycomb panels. After curing under vacuum, the lightweight epoxy produces high-strength areas for insert potting with no mark off. Epocast® 1610-A2 epoxy syntactic cures to an off-white color.

**TYPICAL PROPERTIES AS RECEIVED**

Property	Test Method	Result
Color	Visual	Off-white
Density, g/cc	ASTM D1622	≤ 0.50
Viscosity, cP at 77°F (25°C)	Visual	Non flow paste
Work life at 77°F (25°C), days	ASTM D1338	30

**CURE SCHEDULE**

Raise temperature 5-7°F (3-4°C) per minute from room temperature to 260°F (127°C), then cure for one hour at 260°F (127°C). Cool under vacuum to 150°F (66°C) before removing part.

## TYPICAL CURED PROPERTIES (Not for specification purposes)

Test	Test Method	Test Temperature	Result
Lap shear strength, Al-Al, psi (MPa)	ASTM D1002	77°F (25°C)	1000 (6.9)
Compressive strength, psi (MPa)	ASTM D695	77°F (25°C)	2,800 (19.3)
		180°F (82°C)	1,600 (11.0)
		250°F (121°C)	470 (3.2)
Compressive modulus, Ksi (MPa)	ASTM D695	77°F (25°C)	220 (1517)
Weight change, 24 hr water immersion, %	ASTM D543	77°F (25°C)	4.0
Flammability, 12-second vertical burn	BMS5-28, Sec 8.9		
Extinguishing time, second			< 2
Burn length, inch			< 2.0

## STORAGE

Epocast® 1610-A2 should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +8°C (+35.6°F and +46.4°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.

**KEEP OUT OF REACH OF CHILDREN. FOR PROFESSIONAL AND INDUSTRIAL USE ONLY.**

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