

**Advanced Materials****Epocast<sup>®</sup> 1615-A/B****EPOXY SYNTACTIC**

- Low Density
- Self Extinguishing
- Short Work Life

**DESCRIPTION :**

Epocast<sup>®</sup> 1615-A/B epoxy syntactic is a low-density edge sealant for honeycomb structures that features flame resistance, high strength, and ease of handling. Epocast<sup>®</sup> 1615-A/B epoxy syntactic cures to an off-white color and is qualified to BMS 5-28, Type 15.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>1615-A Resin</u>	<u>1615-B Hardener</u>	<u>1615-A/B System</u>	<u>Test Method</u>
Color	Off-white	Amber	Off-white	Visual
Density, g/cc	0.65	1.05	0.70	ASTM-D-1622
Viscosity, cP at 77°F (25°C)	Paste	400	Paste	ASTM-D-2196
Gel time, 50 gms at 77°F (25°C), minutes	--	--	15	ASTM-D-2471

NOTE: \*Resin/filler separation may occur in Epocast<sup>®</sup> 1615A resin. Material must be remixed before dispensing from container.

**MIX RATIO :**

To 100 parts by weight of Epocast<sup>®</sup> 1615-A resin, add 14 parts by weight of Epocast<sup>®</sup> 1615-B hardener. Mix both components thoroughly for several minutes to assure complete blending.

**CURE SCHEDULE :**

24 hours at 77°F (25°C) or gel at room temperature plus five hours at 125°F (52°C).

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**TYPICAL CURED PROPERTIES** (Not for specification purposes)

<b>Test</b>	<b>Result</b>	<b>Test Method</b>
Tensile lap shear, after 5 hours at 125°F (52°C), psi (MPa)	700 (4.8)	ASTM-D-1002
Compressive strength, Ksi (MPa) at 77°F (25°C)	6.0 (41.3)	ASTM-D-695
Compressive modulus, Ksi (MPa) at 77°F (25°C)	450 (3,103)	--
Flammability, horizontal	self extinguishing	--
vertical	self extinguishing	--
Flow at 77°F (25°C), in. (cm), maximum	1.0 (2.5)	BMS-5-28
at 125°F (52°C)	2.0 (5.0)	--
Weight gain on immersion, after 24 hours at 77°F (25°C), %		ASTM-D-543
TT-S-735, Type III test fluid	1.0	--
Mil-M-5606 hydraulic fluid	2.1	--
Skydrol 500-A	2.0	--
distilled water	2.0	--

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**STORAGE :**

Epocast® 1615-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 (expiration date may differ based on customer specification).

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

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**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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