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HUNTSMAN

Product Data

EPOCAST® 1636-A/B

EPOXY SYNTACTIC

- High Density
- High Temperature Potting Compound
- Self-Extinguishing

DESCRIPTION

Epocast 1636-A/B epoxy syntactic is a high-performance, two-part system with high strength and good high temperature resistance. The aluminum-filled, medium-viscosity epoxy compound is easy to handle and machines easily in the cured state. Epocast 1636-A/B epoxy syntactic is used to reinforce honeycomb structures and is qualified to BMS 5-28, Type 6.

TYPICAL PROPERTIES AS RECEIVED

Property	1636-A Resin	1636-B Hardener	1636-A/B System	Test Method
Color	Gray	Dk. Amber	Gray	Visual
Density, g/cc	1.73	1.07	1.72	ASTM-D-792
Viscosity, cP at 77°F (25°C)	38,000	1,000	29,000	ASTM-D-2196
Gel time, 50 gms at 77°F (25°C), minutes	--	--	120	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	12	12	--	--

MIX RATIO

To 100 parts by weight of Epocast 1636-A resin, add 8 parts by weight of Epocast 1636-B hardener. Stir both components thoroughly for several minutes until completely mixed. Mix carefully to minimize air entrapment.

CURE SCHEDULE

7 days at 77°F (25°C), or gel at 77°F (25°C) and raise temperature approximately 5-7°F (3-4°C) per minute to 260°F (127°C), hold 90 minutes, or 350F° (177°C), hold 60 minutes.

TYPICAL CURED PROPERTIES (Not for specification purposes)

Test	Result	Test Method
Compressive strength, Ksi (MPa)		ASTM-D-695
7 days at 77°F (25°C)	15.0 (103)	--
Room temperature gel plus 1½ hours at 250°F (121°C)	28.0 (193)	--
Tested at 77°F after 14 days at 350°F (177°C)	28.0 (193)	--
Tested at 350°F after 14 days at 350°F (177°C)	5.0 (34.5)	--
Compressive modulus, Ksi (MPa)		
7 days at 77°F (25°C)	800 (5,517)	ASTM-D-695
Room temperature gel plus 1½ hours at 250°F (121°C)	600 (4,137)	--
Tested at 77°F after 14 days at 350°F (177°C)	500 (3,448)	--
Tested at 350°F after 14 days at 350°F (177°C)	40 (276)	--
Tensile lap shear, etched AL/AL, psi (MPa)	2,000 (13.8)	ASTM-D-1002
Flammability	self-extinguishing	BSS-7230-F4
Weight gain on immersion after 24 hours at 77°F (25°C), %		ASTM-D-543
TT-S-735, Type III test fluid	<0.1	--
Mil-M-5606, hydraulic fluid	<0.1	--
Skydrol hydraulic fluid	<0.1	--
Distilled water	<0.1	--

CAUTION:

Huntsman Advanced Materials Americas Inc. 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. Copies of the latest MSDS may be requested by calling our customer service group at 800-367-8793 or emailing your request to adhesives_group@huntsman.com.

FIRST AID!

Eyes and skin: Flush eyes with water for 15 minutes. Contact a physician if irritation persists. Wash skin thoroughly with soap and water. Remove and wash contaminated clothing before reuse.
Inhalation: Remove subject to fresh air.
Swallowing: Dilute by giving water to drink and contact a physician promptly. Never give anything to drink to an unconscious person.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

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