

# Epocast 1635 A/B

Epoxy; Epoxide

Huntsman Advanced Materials

## Message:

Description: Epocast® 1635-A/B syntactic compound is a two-component, high-performance material designed for refilling mis-drilled holes in composite parts. This aluminum filled, high-viscosity system exhibits outstanding compressive strength and dynamic fatigue resistance under load at elevated temperature. This product is qualified to BMS 5-28, Type 31.

General Information			
Features	Good compressive strength		
	Fatigue resistance		
	Heat resistance, high		
	Viscosity, High		
Uses	Components		
	Aerospace applications		
Appearance	Grey		
Processing Method	Extrusion		
Physical	Nominal Value	Unit	Test Method
Density			
-- <sup>1</sup>	1.70	g/cm <sup>3</sup>	ASTM D1622
-- <sup>2</sup>	1.80	g/cm <sup>3</sup>	ASTM D1622
Mechanical	Nominal Value	Unit	Test Method
Compressive Strength			
25°C <sup>3</sup>	172	MPa	ASTM D695
177°C <sup>4</sup>	82.7	MPa	ASTM D695
25°C <sup>5</sup>	103	MPa	ASTM D695
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Resin	Mixing ratio by weight: 100		
Hardening method	Mixing ratio by weight: 23		
Shelf Life			
4°C	52	wk	
25°C	26	wk	
Thermoset Mix Viscosity			ASTM D2196
25°C <sup>6</sup>	> 100000	cP	ASTM D2196
25°C <sup>7</sup>	> 50000	cP	ASTM D2196
25°C <sup>8</sup>	> 300000	cP	ASTM D2196
Gel Time - 100 gms (25°C)	> 1.0	hr	ASTM D2471
Extrudability - 80 psig (25°C)	> 90.0	g/min	BMS 5-28

Lap Shear - etched al/al			ASTM D1002
25°C <sup>9</sup>	10.3	MPa	ASTM D1002
25°C <sup>10</sup>	10.3	MPa	ASTM D1002
Weight Gain <sup>11</sup>		%	ASTM D543
Additional Information	Nominal Value	Unit	Test Method
Cure Schedule: Seven days at 77°F (25°C) or gel at 77°F (25°C) and cure 150 minutes at 200°F (93°C).			
NOTE			
1.	Hardener		
2.	System		
3.	after 2.5 hours @ 200°F		
4.	after 2.5 hours @ 200°F		
5.	after 7 days @ 77°F		
6.	System		
7.	Hardener		
8.	Resin		
9.	after 2.5 hours @ 200°F		
10.	after 7 days @ 77°F		
11.	Fluids: DI water, BMS 3-11 Ty IV CI 1 Gr A hydraulic (Skydrol 500B), MIL-PRF-5606 hydraulic, TT-S-735 Ty III ref fuel		

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#### Recommended distributors for this material

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