

# Epocast 1618 D/B

Epoxy; Epoxide

Huntsman Advanced Materials

## Message:

DESCRIPTION: Epocast® 1618-D/B epoxy syntactic is a low-density, self-extinguishing compound for potting fasteners in honeycomb structures. The lightweight epoxy is easy to extrude through a 1/8 in.(3mm) nozzle orifice, but is non- flowing after application. Epocast® 1618-D/B epoxy syntactic sets quickly at room temperature and is qualified to BMS 5-28, Type 18, Class 1. It is the suggested alternative for Epocast® 1616-A/B epoxy syntactic, Epocast® 1618-A/B epoxy syntactic, and Epocast® 1620-A/B epoxy syntactic systems.

General Information			
Features	Low density		
	Self-extinguishing		
Uses	Components		
	Aerospace applications		
	Fasteners		
Appearance	White		
	Amber		
Processing Method	potting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D1622
-- <sup>1</sup>	0.600	g/cm <sup>3</sup>	ASTM D1622
-- <sup>2</sup>	0.700	g/cm <sup>3</sup>	ASTM D1622
-- <sup>3</sup>	1.00	g/cm <sup>3</sup>	ASTM D1622
Viscosity			ASTM D2196
25°C <sup>4</sup>	Paste		ASTM D2196
25°C <sup>5</sup>	Paste		ASTM D2196
Flammability	Self-extinguishing		
Gel Time - 57 gms (25°C)	15.0	min	ASTM D2471
Tensile Lap Shear - AL/AL (25°C)	4.83	MPa	ASTM D1002
Weight Gain <sup>6</sup>			ASTM D543
Distilled water : 25°C	1.5	%	ASTM D543
Mil-M-5606, hydraulic fluid : 25°C	0.40	%	ASTM D543
Mil-S-3136, Type III test fluid : 25°C	0.30	%	ASTM D543
Skydrol 500-A : 25°C	0.60	%	ASTM D543
Mechanical	Nominal Value	Unit	Test Method
Compressive Modulus	2410	MPa	ASTM D695
Compressive Strength (25°C)	34.5	MPa	ASTM D695
Thermoset	Nominal Value	Unit	Test Method

Thermoset Components			
Resin	Mixing ratio by weight: 100		
Hardening method	Mixing ratio by weight: 14		
Thermoset Mix Viscosity <sup>7</sup> (25°C)	400	cP	ASTM D2196
Additional Information	Nominal Value	Unit	Test Method

CURE SCHEDULE: 24 hours at room temperature or gel at room temperature plus five hours at 125°F (52°C).

NOTE	
1.	Resin
2.	System
3.	Hardener
4.	System
5.	Resin
6.	on immersion - 24 hrs
7.	Hardener

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