

Epocast 1622 FST A/B

Epoxy; Epoxide

Huntsman Advanced Materials

Message:

DESCRIPTION: EPOCAST® 1622 FST A/B is a two-component, low density, pumpable FST epoxy syntactic material designed for potting fasteners and panel joining of honeycomb structures used in aerospace interior applications. It is easily extruded through Semco® dispensing nozzles, yet does not flow after it has been applied. EPOCAST® 1622 FST A/B sets quickly at room temperature and is well suited for aerospace applications requiring a rapid component assembly.

General Information			
Features	Low density		
	High strength		
Uses	Components		
	Aerospace applications		
	Fasteners		
	Adhesive		
Appearance	Amber		
	White-like		
Processing Method	potting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D1622
-- ¹	0.730	g/cm ³	ASTM D1622
-- ²	0.770	g/cm ³	ASTM D1622
-- ³	1.00	g/cm ³	ASTM D1622
Shrinkage	0.41	%	ASTM D6289
Viscosity			ASTM D2196
25°C ⁴	Paste		ASTM D2196
25°C ⁵	Paste		ASTM D2196
Flammability			FAR 25.853
12 second vertical burn - burn length		cm	FAR 25.853
12 second vertical burn - extinguish time		sec	FAR 25.853
Smoke density-at 4 minutes	90		ASTM E662
Gel Time - 55.7g (25°C) ⁶	15.0	min	ASTM D2471
Tensile Lap Shear - AL/AL (23°C)	11.7	MPa	ASTM D1002
Mechanical	Nominal Value	Unit	Test Method
Compressive Modulus	2410	MPa	ASTM D695
Compressive Strength			ASTM D695
70°C	20.7	MPa	ASTM D695

23°C	58.6	MPa	ASTM D695
Thermal	Nominal Value	Unit	Test Method
Glass Transition Temperature	78.0	°C	ASTM E1545
CLTE - Flow			ASTM E831
-- ⁷	3.9E-5	cm/cm/°C	ASTM E831
-- ⁸	8.1E-5	cm/cm/°C	ASTM E831
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Component a	Mixing ratio by weight: 100		
Component B	Mixing ratio by weight: 12		
Shelf Life (25°C)	52	wk	
Thermoset Mix Viscosity ⁹ (25°C)	14.0	cP	ASTM D2196
Additional Information	Nominal Value	Unit	Test Method

CURE SCHEDULE: 3 to 5 days at room temperature or gel at room temperature plus 3 to 5 hours at 125°F (52°C).Insert pull-out strength at 73°F: 300 lbfInsert torque-out strength at 73°F: 100 in-lbExtrusion rate: 350 g/minFlow resistance: <0.1 inch

NOTE

1. Part A
2. System
3. Part B
4. System
5. Part A
6. System
7. below T_g
8. above T_g
9. Part B

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