

# Epocast 1614-A1

Epoxy; Epoxide

Huntsman Advanced Materials

## Message:

DESCRIPTION: Epocast ® 1614-A1 epoxy structural syntactic is a low-density, frozen, one-component material for use on honeycomb composite parts requiring high compressive strength at service temperatures up to 350°F (177°C). Epocast ® 1614-A1 epoxy structural syntactic may also be used for fastener or attachment potting and panel edge reinforcing. It is qualified to BMS 5-28, Type 14, Classes 1 and 2 and other specifications.

General Information			
Features	Low density		
	Good compressive strength		
	Self-extinguishing		
Uses	Engineering accessories		
Appearance	Brown		
Forms	Blank		
Processing Method	potting		
	Extrusion		

Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.750	g/cm <sup>3</sup>	ASTM D1622

Mechanical	Nominal Value	Unit	Test Method
Compressive Strength			ASTM D695
177°C	48.0	MPa	ASTM D695
121°C	69.0	MPa	ASTM D695
25°C	100	MPa	ASTM D695

Flammability	Nominal Value		
Flammability	Self Extinguishing		
Extrudability (25°C)	800	g/min	BMS 5-28
Tensile Lap Shear - AL/AL	6.89	MPa	ASTM D1002
Weight Gain <sup>1</sup>			ASTM D543
Distilled Water : 25°C	0.20	%	ASTM D543
Mil-H-5606 hydraulic fluid : 25°C	0.30	%	ASTM D543
Mil-S-3136, Type III test fluid : 25°C	0.10	%	ASTM D543
Skydol hydraulic fluid : 25°C	0.20	%	ASTM D543
Work Life (25°C) <sup>2</sup>	8.0	hr	ASTM D1338

Thermoset	Nominal Value	Unit	Test Method
Shelf Life (-29°C)	13	wk	

Additional Information	Nominal Value	Unit	Test Method
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CURE SCHEDULE: Heat the material from room temperature at the rate of 5-7°F (3-4°C) per minute, plus 1 hour at 350°F (177°C) or 90 minutes at 250°F (121°C). Cure temperature refers to temperature of material as determined by thermocouple. (Slow heat rise at 5-7°F (3-4°C) per minute is preferred to reduce shrinkage and minimize out-gassing during cure).

NOTE

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| 1. | 24 hrs     |
| 2. | after thaw |

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