

# Epocast 1633 A/B

Epoxy; Epoxide

Huntsman Advanced Materials

## Message:

DESCRIPTION: Epocast® 1633-A/B epoxy syntactic is a medium paste, halogen-free self-extinguishing compound designed for potting fasteners in honeycomb structures. The epoxy syntactic is easily extruded through 1/8 in. (3mm) nozzle orifice, but is non-flowing after application. It is easy to handle in isolated repair areas because the syntactic paste is available in dual-barrel cartridges. Epocast® 1633-A/B epoxy syntactic sets quickly at room temperature.

General Information	
Features	Halogen-free
	Self-extinguishing
Uses	Components
	Fasteners
Appearance	Light Blue
	White-like
Processing Method	potting
	Extrusion

Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
-- 1	0.660	g/cm <sup>3</sup>	ASTM D792
-- 2	0.680	g/cm <sup>3</sup>	ASTM D792
-- 3	0.730	g/cm <sup>3</sup>	ASTM D792
Viscosity			ASTM D2196
-- 4	Soft-paste		ASTM D2196
-- 5	Soft-paste		ASTM D2196
-- 6	Paste		ASTM D2196
Cure Time (120°C)	5.0	hr	
Tensile Lap Shear - chromic acid etched al/al (25°C)	9.65	MPa	ASTM D1002
Weight Gain <sup>7</sup>			ASTM D570
Distilled water : 25°C	2.5	%	ASTM D570
Mil-M-5606, hydraulic fluid : 25°C	0.40	%	ASTM D570
Skydrol 500-A : 25°C	0.70	%	ASTM D570
TTS-735, Type III test fluid : 25°C	0.30	%	ASTM D570
Work Life - 10 grams (25°C)	2.0 - 5.0	min	ASTM D1338
Mechanical	Nominal Value	Unit	Test Method

Compressive Modulus	1860	MPa	ASTM D695
Compressive Strength (25°C)	44.8	MPa	ASTM D695
Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Resin	Mixing ratio by weight: 100		
Hardening method	Mixing ratio by weight: 50		
Additional Information	Nominal Value	Unit	Test Method
CURE SCHEDULE : Gel at room temperature plus 5 hours at 120°F (49°C) or gel at room temperature plus 2 hours at 150°F (66°C) or 3 days at room temperature.			
NOTE			
1.	Hardener		
2.	Resin		
3.	System		
4.	Resin		
5.	Hardener		
6.	System		
7.	on immersion - 24 hrs		

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