

Epocast 1636-A/B

Epoxy; Epoxide
Huntsman Advanced Materials

Message:

DESCRIPTION: Epocast ® 1636-A/B epoxy syntactic is a high-performance, two-part system with high strength and good high temperature resistance. The aluminum-filled, medium-viscosity epoxy compound is easy to handle and machines easily in the cured state. Epocast ® 1636-A/B epoxy syntactic is used to reinforce honeycomb structures and is qualified to BMS 5-28, Type 6.

General Information			
Features	High density		
	High strength		
	Machinable		
	Heat resistance, high		
	Medium viscosity		
	Self-extinguishing		
Appearance	Amber		
	Grey		
Forms	Liquid		
Processing Method	potting		
Physical	Nominal Value	Unit	Test Method
Specific Gravity			ASTM D792
-- 1	1.07	g/cm ³	ASTM D792
--	1.72	g/cm ³	ASTM D792
-- 2	1.73	g/cm ³	ASTM D792
Mechanical	Nominal Value	Unit	Test Method
Compressive Modulus			ASTM D695
-- 3	276	MPa	ASTM D695
-- 4	3450	MPa	ASTM D695
-- 5	4140	MPa	ASTM D695
-- 6	5520	MPa	ASTM D695
Compressive Strength			
-- 7	103	MPa	ASTM D695
-- 8	34.5	MPa	ASTM D695
-- 9	193	MPa	ASTM D695
Flammability	Nominal Value		Test Method
Flammability	Self Extinguishing		BSS 7230-F4
Gel Time (25°C) ¹⁰	2.0	hr	ASTM D2471
Cure Time (25°C)	7.0	day	
Tensile Lap Shear - AL/AL	13.8	MPa	ASTM D1002

Weight Gain ¹¹		ASTM D543
Distilled Water : 25°C	%	ASTM D543
Mil-M-5606, hydraulic fluid : 25°C	%	ASTM D543
Skydol hydraulic fluid : 25°C	%	ASTM D543
TT-S-735, Type II test fluid : 25°C	%	ASTM D543

Thermoset	Nominal Value	Unit	Test Method
Thermoset Components			
Resin	Mixing ratio by weight: 100		
Hardening method	Mixing ratio by weight: 8.0		
Shelf Life (25°C)	52	wk	
Thermoset Mix Viscosity			ASTM D2196
25°C	29000	cP	ASTM D2196
25°C ¹²	1000	cP	ASTM D2196
25°C ¹³	38000	cP	ASTM D2196

Additional Information	Nominal Value	Unit	Test Method
CURE SCHEDULE: 7 days at 77°F (25°C), or gel at 77°F (25°C) and raise temperature approximately 5-7°F (3-4°C) per minute to 260°F (127°C), hold 90 minutes, or 350°F (177°C), hold 60 minutes.			

NOTE	
1.	Hardener
2.	Resin
3.	Tested at 350°F after 14 days at 350°F
4.	Tested at 77°F after 14 days at 350°F
5.	Room temperature gel plus 1 1/2 hrs at 250°F
6.	7 days at 77°F
7.	7 days at 77°F
8.	Tested at 350°F after 14 days at 350°F
9.	Room temperature gel plus 1 1/2 hrs at 250°F
10.	50 gms
11.	24 hrs
12.	Hardener
13.	Resin

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