

**Advanced Materials****Epocast<sup>®</sup> 169-A Resin  
Hardener 9646****EPOXY SYNTACTIC**

- Brown Foam
- Low Density
- Sandable, Machinable

**DESCRIPTION :**

Epocast<sup>®</sup> 169-A resin with Hardener 9646 epoxy syntactic is a low-density foam which cures at room temperature to a carvable, woodlike product. The epoxy syntactic has good dimensional stability under changing humidity conditions and is pourable for easier application as a core fill and honeycomb reinforcement. Epocast<sup>®</sup> 169-A resin can also be used with Hardener 9646-A, at the same mix ratio, to produce a non-flow paste consistency.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>169-A Resin</u>	<u>9646 Hardener</u>	<u>169-A/9646 System</u>	<u>Test Method</u>
Color	Red-brown	Amber	Red-brown	Visual
Density, g/cc	0.56	0.96	0.68	ASTM-D-1622
Viscosity, cP at 77°F (25°C)	Paste	350	Pourable	ASTM-D-2196
Gel time, 50 gms at 77°F (25°C), minutes	--	--	25-40	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	12	12	--	--

**MIX RATIO :**

To 100 parts by weight of Epocast<sup>®</sup> 169-A resin, add 35 parts by weight of Hardener 9646. Mix both components thoroughly for 3 - 5 minutes to insure complete and uniform mixing.

**CURE SCHEDULE :**

24 hours at 75°F ± 5°F (24°C ± 2°C), or room temperature gel plus 2 hours at 150°F ± 10°F (66°C ± 5°C).

**TYPICAL CURED PROPERTIES (Not for specification purposes)**

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Compressive strength, at 77°F (25°C), psi (MPa)	8,000 (55.2)	ASTM D-695
Compressive modulus, at 77°F (25°C), Ksi (MPa)	60.0 (414)	--
Tensile lap shear, AL/AL, at 77°F (25°C), psi (MPa)	1,200 (8.3)	ASTM-D-1002

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**STORAGE/** Syntactic epoxy resins and hardeners should be stored in a dry place in their original, sealed

**SHELF LIFE :** containers at temperatures from 60-90°F (16-32°C). Material temperatures should be above

65°F (18°C) when mixing. After use, tightly reseal containers. Frozen materials should be stored at 0°F (-18°C) or colder and allowed to thaw at room temperature before use.

Under these conditions, syntactic epoxy resins and hardeners will remain useable for 12 months from date of shipping from Huntsman.

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**CAUTION :**

Huntsman Advanced Materials Americas Inc. maintains up-to-date Material Safety Data Sheets (MSDS) on all of its products. These sheets contain pertinent information that you may need to protect your employees and customers against any known health or safety hazards associated with our products. Users should review the latest MSDS to determine possible health hazards and appropriate precautions to implement prior to using this material. Copies of the latest MSDS may be requested by calling our customer service group at 800-367-8793 or emailing your request to [adhesives\\_group@huntsman.com](mailto:adhesives_group@huntsman.com).

**FIRST AID !**

Eyes and skin: Flush eyes with water for 15 minutes. Contact a physician if irritation persists. Wash skin thoroughly with soap and water. Remove and wash contaminated clothing before reuse.

Inhalation: Remove subject to fresh air.

Swallowing: Dilute by giving water to drink and contact a physician promptly. Never give anything to drink to an unconscious person.

**KEEP OUT OF REACH OF CHILDREN****FOR PROFESSIONAL AND INDUSTRIAL USE ONLY**

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