

Advanced Materials**Epocast[®] 1843-A/B, Type 4
Grades A and B****EPOXY SYNTACTIC FOAM**

- Pourable or Paste Grades
- High Temperature Performance

DESCRIPTION :

Epocast[®] 1843-A/B, Type 4 epoxy syntactic foam is a low-density material for core filling, edge sealing, and fastener potting of honeycomb structures. Epocast[®] 1843-A/B, Type 4, Grade A epoxy syntactic is pourable and Grade B is a paste system. Both versions meet aerospace industry specifications and are capable of extended usage at 350°F (177°C).

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>1843-A/B Grade A System</u>	<u>1843-A/B Grade B System</u>	<u>Test Method</u>
Density gravity, g/cc	0.96	0.96	ASTM-D-1622
Pot Life, 100 gm. at 75°F (23°C), minutes	30-50	25-50	ASTM-D-2471
Mixed Viscosity, cps at 77°F (25°C)	45,000-90,000	Non-Flow	ASTM-D-2196
Shelf life at 77°F (25°C), unopened, months	12	12	--

MIX RATIO :

To 100 parts by weight of Epocast[®] 1843-A, Grade A, add 13 parts by weight 1843-B.
To 100 parts by weight of Epocast[®] 1843-A, Grade B, add 15 parts by weight 1843-B.

CURE SCHEDULE :

Grade A:	6 Hours @ R.T.+ 2 Hours @ 200°F(93°C) + 1 Hour @ 350°F (177°C)	Grade B:	3 Hours @ R.T.+ 1/2 Hour @ 170°F (77°C) + 1 Hour @ 250°F (121°C)
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TYPICAL CURED PROPERTIES :

	<u>Grade A</u>	<u>Grade B</u>	<u>Test Method</u>
Compressive Strength, psi (MPa) at 75°F (23°C)	6,000 (41.4)	6,000 (41.4)	ASTM-D-695
at 350°F (177°C)	1,000 (6.9)	1,000 (6.9)	--
Adhesive Bond Strength, psi (MPa) at 350°F (177°C)	1,000 (6.9)	400 (2.7)	ASTM-D-1002

STORAGE/ SHELF LIFE : Syntactic epoxy resins and hardeners should be stored in a dry place in their original, sealed 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.

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.

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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