

Advanced Materials**Epocast® 54-A/B****EPOXY LAMINATING SYSTEM**

- High Strength
- Self Extinguishing
- Short Work Life

DESCRIPTION :

Epocast® 54-A/B epoxy laminating system is an unfilled, solvent-free, easy-to-handle product. It is self extinguishing and well suited for the manufacture and repair of composite structures. In addition to laminating applications, the epoxy system can be used for filament winding. Epocast® 54-A/B epoxy laminating system is qualified to AIMS 04-27-000-01.

TYPICAL PROPERTIES AS RECEIVED :

Property	54-A Resin	54-B Hardener	54-A/B System	Test Method
Color	Light Yellow	Straw	Amber	Visual
Density, g/cc.	1.19	1.05	--	ASTM-D-792
Viscosity, cP at 77°F (25°C)	9,000	400	8,000	ASTM-D-2196
Gel time, 100 gms at 77°F (25°C), min.	--	--	15-25	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	12	12	--	--

MIX RATIO :

To 100 parts by weight of Epocast 54-A resin, add 15 parts by weight of Hardener 54-B. Mix both components thoroughly for several minutes to insure a complete and uniform mixture. Mix only that quantity which can be applied within several minutes after mixing to avoid excessive exotherm.

CURE SCHEDULE :

Five days at 77°F (25°C) or two hours at 150-200°F (66-93°C) after room temperature gel. The system can be handled and machined after 24 hours at room temperature.

TYPICAL CURED PROPERTIES (Not for specification purposes)

Test	Results	Test Method
Compressive Strength, 12-ply 7781 glass cloth, at 77°F (25°C), psi (MPa)	49,010 (338)	ASTM D695
Compressive Modulus, 12-ply 7781 glass cloth, at 77°F (25°C), Ksi (MPa)	3,399 (23,442)	ASTM D695
Flammability, 2-ply 7781 glass cloth, 60 sec., vertical		
Self Extinguish Time, sec.	0	FAR 25.853A
Drip Extinguish Time, sec.	0	
Burn Length, in. (cm)	3.5 (8.89)	

STORAGE/ SHELF LIFE : Epoxy resins and hardeners should be stored in a dry place in their original, sealed containers at temperatures from 60-100°F (16-38°C). Material temperatures should be above 65°F (18°C) when mixing. After use, tightly reseal containers.

Under these conditions, 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

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