

**Advanced Materials****Epocast® 1619-A/B****EPOXY SYNTACTIC**

- Pourable
- Room Temperature Curing
- Self Extinguishing

**DESCRIPTION :**

Epocast® 1619-A/B epoxy syntactic is a low-density, self-extinguishing compound for potting fasteners in honeycomb structures. The lightweight epoxy can be poured or extruded through a 1/8 in. (3mm) nozzle orifice. Epocast® 1619-A/B epoxy syntactic is resistant to water, fungus and most aircraft fluids and is qualified to BMS 5-28, Type 19.

**TYPICAL PROPERTIES AS RECEIVED :**

<b>Property</b>	<b>1619-A Resin</b>	<b>1619-B Hardener</b>	<b>1619-A/B System</b>	<b>Test Method</b>
Color	Off-white	Amber	Off-white	Visual
Density, g/cc	0.60	1.00	0.70	ASTM-D-1622
Viscosity, cP at 77°F (25°C)	Semi-Paste	400	Semi-Paste	ASTM-D-2196
Extrudability, 1/8 in. (3mm) nozzle, gm/minute	--	--	350	--
Gel time, 50 gms at 77°F (25°C), minutes	--	--	20-50	ASTM-D-2471

**MIX RATIO :**

To 100 parts by weight of Epocast® 1619-A resin, add 25 parts by weight of Epocast® 1619-B hardener. Mix both components thoroughly for several minutes to assure complete blending.

**CURE SCHEDULE :**

24 hours at 77°F (25°C), or gel at room temperature plus five hours at 125°F (52°C).

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

<b>Test</b>	<b>Result</b>	<b>Test Method</b>
Compressive strength, Ksi (MPa) at 77°F (25°C)	5.50 (38)	ASTM-D-695
Compressive modulus, Ksi (MPa)	350 (2,413)	ASTM-D-695
Tensile lap shear, AL/AL, psi (MPa)	1,250 (8.6)	ASTM-D-1002
Flammability	self extinguishing	--
Hardness, Shore D	65	ASTM-D-2240
Weight gain on immersion after 24 hours at 77°F (25°C), %		ASTM-D-543
TT-S-735, Type III test fluid	0.3	--
Mil-M-5606 hydraulic fluid	0.4	--
Skydrol 500-A	0.6	--
Distilled water	1.5	--

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**STORAGE:**

Epocast<sup>®</sup> 1619-A/B should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). The product should not be exposed to direct sunlight. Under these storage conditions, and when supplied under Huntsman standard certification, this product has a shelf life of 6 months (expiration date may differ based on customer specification).

Material temperatures should be above 18°C (65°F) when mixing. After use, tightly reseal containers.

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**PRECAUTIONARY STATEMENT**

Huntsman Advanced Materials Americas LLC 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.

**First Aid!**

Refer to MSDS as mentioned above.

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

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