

**Advanced Materials****Epocast<sup>®</sup> 1626 C1/D2 Epoxy Syntactic Foam**

- **Toughened Foam**
- **Impact and Vibration Resistant**

**DESCRIPTION**

Epocast<sup>®</sup> 1626 C1/D2 epoxy syntactic foam is a fast-setting, two-component material designed for core filling, edge sealing, and bushing and fastener potting of honeycomb structures. The easy-handling viscous paste has low-flow characteristics. Epocast<sup>®</sup> 1626 C1/D2 epoxy syntactic foam is a toughened system which resists cracking and is especially suited for applications of high vibration and wide temperature cycling. This product has good retention of strength after environmental aging. Epocast<sup>®</sup> 1626 C1/D2 epoxy syntactic foam is qualified to BMS 5-28, Type 26 and SMS 116201, Type 3.

**TYPICAL PROPERTIES AS RECEIVED**

Property	Test Method	1626 C1 Resin	1626 D2 Hardener	Mixed System
Color	Visual	Brown	Off-White	Brown
Density, g/cc	ASTM D1622	0.69	0.68	0.69
Viscosity at 77°F (25°C), cP	ASTM D2196	Soft Paste	Soft Paste	Paste
Gel Time, 50g at 77°F (25°C), min	ASTM D2471	--	--	12

**MIX RATIO**

To 100 parts by weight of Epocast<sup>®</sup> 1626 C1, add 54 parts by weight of Epocast<sup>®</sup> 1626 D2 (2:1 by volume). Epocast<sup>®</sup> 1626 C1/D2 is available in 400 mL twin cartridges. For best results, dispense using manual or pneumatic dispensing equipment through a suitable mixing nozzle as shown below:

Width / Diameter, in	Number of Elements	Nordson EFD Part Number	Sulzer-Mixpac Part Number
0.34 in	24	7701816	MCQ 08-24T
0.37 in	24	7700979	MCH 10-18T

For other mixing and application recommendations, please consult your local Huntsman Advanced Materials representative or one of our distributors.

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**CURE SCHEDULE**

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5-7 days at 77°F (25°C) or gel at 77°F (25°C) plus 1.5 hour at 260°F (127°C).

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

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Property	Result	Test Method
Tensile lap shear, Al-Al, psi (MPa) at 77°F (25°C) at 140°F (60°C)	ASTM D1002	1,000 (6.9) 200 (1.4)
Compressive Strength, psi (MPa) at 77°F (25°C) at 140°F (60°C)	ASTM D695	1,200 (8.3) 400 (2.8)
T-peel, Al-Al, pli	ASTM D1876	10
Durometer hardness, Shore D	ASTM D2240	50
Tensile strength, psi (MPa)	ASTM D638	1,100 (7.6)
Elongation, %	ASTM D638	10

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**STORAGE**

Epocast<sup>®</sup> 1626-C1/D2 epoxy syntactic foam should be stored in a dry place, in the sealed original container, at temperatures between +2°C to +40°C (+35.6°F and 104°F). Under these storage conditions the shelf life is 6 months from date of shipment. The product should not be exposed to direct sunlight.

Material temperatures should be above 65°F (18°C) 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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