

Epocast[®] 1626 C1/D2 Epoxy Syntactic Foam

Product Description

Epocast[®] 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[®] 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[®] 1626 C1/D2 epoxy syntactic foam is qualified to BMS 5-28, Type 26 and SMS 116201, Type 3.

Features

- Toughened foam
- Impact and vibration resistant

Typical Properties*

Property	Test Method	1626 C1 Resin	1626 D2 Hardener	Mixed System
Appearance	Visual	Brown	Off-White	Brown
Density, g/cm ³	ASTM D1622	0.69	0.68	0.69
Viscosity at 77°F (25°C)	ASTM D2196	Soft Paste	Soft Paste	Paste

*Typical properties are based on Huntsman's test methods. Copies are available upon request.

Processing Data

Mix Ratio

Product	Parts by weight
Epocast [®] 1626 C1	100
Epocast [®] 1626 D2	54

Epocast® 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

Material temperatures should be above 65°F (18°C) when mixing. For other mixing and application recommendations, please consult your local Huntsman Advanced Materials representative or one of our distributors.

Processing Data

Parameter	Value
Gel time, 50 g at 77°F (25°C)	12 min
Typical Cure Cycle	5 - 7 days at 25°C or
	Gel at 25°C + 1.5 hour at 127°C

Typical Physical Properties

Unless otherwise stated, the data were determined with typical production batches using standard test methods. They are typical values only, and do not constitute a product specification.

Property	Test Method	Value
Tensile lap shear strength 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

Storage

Epocast® 1626 C1/D2 Epoxy Syntactic Foam should be stored in a dry place, in the original sealed container at temperatures between 2°C and 40°C (35.6°F and 104°F). Tightly reseal containers after each use. Under these storage conditions, and when supplied under Huntsman standard certification, the product has a shelf-life of **6 months** (from date of shipment). The components should not be exposed to direct sunlight.

Precautionary Statement

Huntsman Advanced Materials Americas LLC maintains up-to-date Safety Data Sheets (SDS) 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 SDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

Important Legal Notice

Sales of the product described herein ("Product") are subject to the general terms and conditions of sale of either Huntsman Advanced Materials LLC, or its appropriate affiliate including without limitation Huntsman Advanced Materials (Europe) BVBA, Huntsman Advanced Materials Americas Inc., or Huntsman Advanced Materials (Hong Kong) Ltd. ("Huntsman"). The following supercedes Buyer's documents.

Huntsman warrants that at the time and place of delivery all Products sold to Buyer shall conform to the specifications provided to Buyer by Huntsman.

While the information and recommendations included in this publication are, to the best of Huntsman's knowledge, accurate as of the date of publication, NOTHING CONTAINED HEREIN (EXCEPT AS SET FORTH ABOVE REGARDING CONFORMANCE WITH SPECIFICATIONS PROVIDED TO BUYER BY HUNTSMAN) IS TO BE CONSTRUED AS A REPRESENTATION OR WARRANTY OF ANY KIND, EXPRESS OR IMPLIED, INCLUDING BUT NOT LIMITED TO ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE, NONINFRINGEMENT OF ANY INTELLECTUAL PROPERTY RIGHTS, OR WARRANTIES AS TO QUALITY OR CORRESPONDENCE WITH PRIOR DESCRIPTION OR SAMPLE, AND THE BUYER ASSUMES ALL RISK AND LIABILITY WHATSOEVER RESULTING FROM THE USE OF SUCH PRODUCT, WHETHER USED SINGLY OR IN COMBINATION WITH OTHER SUBSTANCES.

No statements or recommendations made herein are to be construed as a representation about the suitability of any Product for the particular application of Buyer or user or as an inducement to infringe any patent or other intellectual property right. Buyer is responsible to determine the applicability of such information and recommendations and the suitability of any Product for its own particular purpose, and to ensure that its intended use of the Product does not infringe any intellectual property rights.

The Product may be or become hazardous. The Buyer should obtain Material Safety Data Sheets and Technical Data Sheets from Huntsman containing detailed information on Product hazards and toxicity, together with proper shipping, handling and storage procedures for the Product, and should comply with all applicable governmental laws, regulations and standards relating to the handling, use, storage, distribution and disposal of, and exposure to the Product. Buyer shall also take all steps necessary to adequately inform, warn and familiarize its employees, agents, direct and indirect customers and contractors who may handle or be exposed to the Product of all hazards pertaining to and proper procedures for safe handling, use, storage, transportation and disposal of and exposure to the Product, and the containers or equipment in which the Product may be handled, shipped or stored.

Epocast is a registered trademark of Huntsman LLC or an affiliate thereof in one or more, but not all countries.

© 2015 Huntsman Advanced Materials Inc.

Main Offices:

Huntsman Corporation
10003 Woodloch Forest Dr
The Woodlands, TX 77380
888-564-9318

Huntsman Advanced Technology Center
8600 Gosling Rd.
The Woodlands, TX 77381
281-829-7400