

Advanced Materials**Epocast[®] 169A-1 Resin / 9646 Hardener**

EPOXY SYNTACTIC

- Brown Foam
- Low Density
- Sandable and Machinable

DESCRIPTION:

Epocast[®] 169A-1 resin with 9646 Hardener epoxy syntactic is a low-density foam which cures at room temperature to a carvable, woodlike product. The epoxy syntactic has good dimensional stability under changing humidity conditions and is pourable for easier application as a core fill and honeycomb reinforcement. Epocast[®] 169A-1 resin can also be used with 9646-A Hardener at the same mix ratio, to produce a non-flow paste consistency.

TYPICAL PROPERTIES AS RECEIVED:

<u>Property</u>	<u>169A-1 Resin</u>	<u>9646 Hardener</u>	<u>169A-1/9646 System</u>	<u>Test Method</u>
Color	Red-brown	Amber	Red-brown	Visual
Density, g/cc	0.56	0.96	0.7	ASTM-D-1622
Viscosity, cP at 77°F (25°C)	Paste	350	Pourable	ASTM-D-2196
Gel time, 50 gms at 77°F (25°C), minutes	--	--	30-50	ASTM-D-2471

MIX RATIO:

To 100 parts by weight of Epocast[®] 169A-1 resin, add 35 parts by weight of 9646 hardener. Mix both components thoroughly for 3 - 5 minutes to insure complete and uniform mixing.

CURE SCHEDULE:

24 hours at 75°F ± 5°F (24°C ± 2°C), or room temperature gel plus 2 hours at 150°F ± 10°F (66°C ± 5°C).

TYPICAL CURED PROPERTIES (Not for specification purposes)

Test	Result	Test Method
Ultimate Compressive strength, at 77°F (25°C), psi (MPa)	7,500 (51.7)	ASTM D-695
Compressive strength at yield, at 77°F (25°C), psi (MPa)	2,700 (18.6)	--
Compressive modulus, at 77°F (25°C), Ksi (MPa)	86.0 (593)	--
Tensile lap shear, AL/AL, at 77°F (25°C), psi (MPa)	2,230 (15.4)	ASTM-D-1002

STORAGE:

Epocast® 169A-1 Resin with 9646 Hardener 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 1 year (expiration date may differ based on customer specification).

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

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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