

Advanced Materials**Epocast® 35-A Resin
Hardener 927****EPOXY LAMINATING SYSTEM**

- High Temperature Performance
- Non-VCHD, Non-MDA
- Long Work Life

DESCRIPTION :

Epocast® 35-A resin/Hardener 927 epoxy laminating system is a two-component, solvent-free material designed to perform at temperatures up to 300°F (149°C). The medium-viscosity liquid laminating system readily wets glass fabrics; its long work life supports extended fabrication times for large composite repairs. Epocast® 35-A resin/Hardener 927 epoxy laminating system is well suited for repair or fabrication of laminated composite structures and other applications requiring good high-temperatures properties. Epocast® 35-A resin/Hardener 927 epoxy laminating system is qualified to BMS 8-214.

TYPICAL PROPERTIES AS RECEIVED :

Property	35-A	927	35-A/927	Test Method
Color	Amber	Dk. Amber	Amber	Visual
Density, g/cc.	1.19	1.00	1.13	ASTM-D-792
Viscosity, cP at 77°F (25°C)	3,200	25,000	7,000	ASTM-D-2196
Work life, 100 gms at 77°F (25°C)	--	--	4-5	ASTM-D-1338

MIX RATIO :

To 100 parts by weight of Epocast® 35-A resin, add 25 parts by weight of Hardener 927. Mix both components thoroughly for several minutes to insure a complete and uniform mixture.

CURE SCHEDULE :

Cure #1: Four hours at 180°F (83°C)

Cure #2: Two hours at 250°F (121°C)

TYPICAL CURED PROPERTIES (Not for specification purposes)

Tested on 12-ply laminate, 1581 glass fabric, resin content 31%

	<u>Cure #1</u>	<u>Cure #2</u>	<u>Test-Method</u>
Durometer hardness, Shore D	93	93	ASTM-D-2240
Flexural strength, as cured, at 77°F (25°C), Ksi (MPa)	77.4 (534)	104.0 (717)	ASTM-D-790
After two hours boiling water, at 77°F (25°C)	52.1 (359)	68.6 (473)	--
Flexural modulus, as cured, at 77°F (25°C), Msi (MPa)	3.02 (20,827)	3.80 (26,206)	--
After two hours boiling water, at 77°F (25°C)	2.77 (19,103)	3.48 (24,000)	--
Compressive strength, as cured, at 77°F (25°C), Ksi (MPa)	61.4 (423)	71.9 (496)	ASTM-D-695
Tested at 300°F (149°C)	2.0 (13.8)	3.4 (23.4)	--
Compressive Modulus, as cured, at 77°F (25°C), Msi (MPa)	3.75 (25,862)	4.03 (27,793)	--
Test at 300°F	0.937 (6,462)	1.36 (9,,379)	--
Tensile Lap Shear, AL/AL, as cured, 77°F (25°C), psi (MPa)		1090 (7.5)	ASTM-D-1002

STORAGE :

Epocast® 35-A Resin/Hardener 927 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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