

**Advanced Materials****Epocast<sup>®</sup> 1656-A/B****EPOXY SYNTACTIC**

- Low Density
- Thick Paste Consistency
- Long Work Life

**DESCRIPTION :**

Epocast<sup>®</sup> 1656-A/B epoxy syntactic is a low-density compound with good elevated temperature properties after a room-temperature cure. The epoxy syntactic is useful as a core fill for metal skins to add stiffness and strength to fabricated parts and is also suitable for core splicing and strengthening radii and corners of reinforced plastic structures. Epocast<sup>®</sup> 1656-A/B epoxy syntactic meets requirements of GM-4006-1-2.

**TYPICAL PROPERTIES AS RECEIVED :**

<b><u>Property</u></b>	<b><u>1656-A Resin</u></b>	<b><u>1656-B Hardener</u></b>	<b><u>1656-A/B System</u></b>	<b><u>Test Method</u></b>
Color	Lt. Tan	Amber	Lt. Tan	Visual
Density, gm/cc	0.80	1.00	0.80	ASTM-1622
Viscosity, cP at 77°F (25°C)	Paste	500	Paste	ASTM-D-2196
Gel time, 100 gms at 77°F (25°C), minutes	--	--	50-90	ASTM-D-2471
Shelf life at 77°F (25°C), unopened, months	6	6	--	--

**MIX RATIO :**

To 100 parts by weight of Epocast<sup>®</sup> 1656-A resin, add 12 parts by weight of Epocast<sup>®</sup> 1656-B hardener. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

**CURE SCHEDULE :**

7 days at 77°F (25°C) or gel at 77°F (25°C) followed by 2-3 hours at 150°F (66°C).

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

<b><u>Test</u></b>	<b><u>Result</u></b>	<b><u>Test Method</u></b>
Tensile lap shear, etched AL/AL, at 77°C (25°C), psi (MPa)	700 (4.8)	ASTM-D-1002
Compressive strength (2% strain), psi (MPa)		
at -67°F (-55°C)	9,500 (65.5)	ASTM-D-695
at 77°F (25°C)	8,000 (55.2)	--
at 180°F (83°C)	3,000 (20.6)	--
at 350°F (177°C)	550 (3.8)	--
Flatwise tensile strength at 74°F (23°C), psi (MPa)	2000 (13.8)	ASTM-C-297
at 160°F (71°C)	1000 (6.9)	--

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**STORAGE :**

Epocast<sup>®</sup> 1656-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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Main Offices :  
**Huntsman Corporation**  
10003 Woodloch Forest Dr.  
The Woodlands  
Texas 77380  
(281) 719-6000

**Huntsman Advanced Technology  
Center**  
8600 Gosling Rd.  
The Woodlands  
Texas 77381  
(281) 719-7400