

**Advanced Materials****Epocast<sup>®</sup> 1511-A/B****EPOXY SYNTACTIC**

- High Density
- Non-Flow Edge Filler
- 40-60 Minute Work Life
- Room Temperature Cure

**DESCRIPTION :**

Epocast<sup>®</sup> 1511-A/B epoxy syntactic is a non-flowing, two-part paste suitable for edge filling of honeycomb structures and/or metal fairings as well as for bonding applications. Epocast<sup>®</sup> 1511-A/B epoxy syntactic is qualified to BMS 5-28, Type 3.

**TYPICAL PROPERTIES AS RECEIVED :**

<u>Property</u>	<u>1511-A Resin</u>	<u>1511-B Hardener</u>	<u>1511-A/B System</u>	<u>Test Method</u>
Color	Gray	Off-white	Gray	Visual
Density, g/cc.	1.20	1.15	1.25	ASTM-D-1622
Viscosity, cP @ 77°F (25°C)	195,000	Paste	Paste	ASTM-D-2196
Work life, 50 gms at 77°F (25°C), minutes	--	--	40-60	ASTM-D-2471

**MIX RATIO :**

To 100 parts by weight of Epocast<sup>®</sup> 1511-A resin, add 15 parts by weight of Epocast<sup>®</sup> 1511-B hardener. Mix both components thoroughly for several minutes to insure complete and uniform mixing.

**CURE SCHEDULE :**

24 hours at room temperature or gel at room temperature plus 5 hours at 125°F (52°C)

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

<u>Test</u>	<u>Result</u>	<u>Test Method</u>
Flow maximum, in. (cm)	2.5 (6.4)	BMS 5-28
Compressive strength at 77°F (25°C), Ksi (MPa)	10.0 (69)	ASTM-D-695
Compressive modulus at 77°F, Ksi (MPa)	45 (310)	ASTM-D-695
Tensile lap shear strength, chromic acid etched aluminum, psi (MPa)	1200 (8.3)	ASTM-D-1002
Weight gain on immersion after 24 hours at 77°F (25°C), %		ASTM-D-543
TT-S-735, Type III test fluid	1.0	
Mil-H-5606, hydraulic fluid	1.0	
Skydrol 500-A	1.0	
Distilled water	1.0	

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**STORAGE :**

Epocast<sup>®</sup> 1511-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 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.

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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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