

Advanced Materials

Epocast[®] 1661 Epoxy Syntactic

- One Part (Frozen) Syntactic
- Up to 350°F (177°C) Use
- 8 Hour Work Life

DESCRIPTION :

Epocast[®] 1661 epoxy syntactic is a frozen, one-component compound supplied in patty form. After thawing, the patty can be placed onto honeycomb for vacuum bag application. Epocast[®] 1661 epoxy syntactic may be used for fastener potting, panel edge filling and honeycomb reinforcing.

TYPICAL PROPERTIES AS RECEIVED :

<u>Property</u>	<u>Result</u>	<u>Test Method</u>
Color	Off-white	Visual
Density, g/cc.	0.60	ASTM-D-1622
Viscosity, cP @ 77°F (25°C)	Paste	ASTM-D-2196
Work life, 100 gms at 77°F (25°C), hours	8	ASTM-D-1338

NOTE : Patties may be thawed 1/2 to 1 hour @ 77°F (25°C). Keep patty tightly wrapped with plastic film to prevent moisture contamination from condensation on surface of material. DO NOT IMMERSE PATTY IN WATER.

CURE SCHEDULE :

Heat the material from room temperature to 350°F (177°C) at the rate of 5-7°F (3-4°C) per minute, plus 1 hour at 350°F (177°C) or 90 minutes at 260°F (127°C). (Slow heat rise of 5-7°F (3-4°C) is preferred to reduce shrinkage and eliminate excess gassing during cure).

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