

> CORFIL[®] 625-1 POTTING COMPOUND

TECHNICAL DATA SHEET



DESCRIPTION

CORFIL[®] 625-1 potting compound is a one-part, low density material formulated for use in insert and edge filling of honeycomb core. It may also be used as a syntactic core splice adhesive. It is formulated to have low viscosity making it especially suitable for use with automated equipment. CORFIL 625-1 can be cured at either 250°F (121°C) or 350°F (177°C) with minimal to no exotherm in large applications.

FEATURES & BENEFITS

- One-part pumpable material
- 250°F (121°C)/ 350°F (177°C) cure
- Minimal exotherm
- -67 to 350°F (-55 to 177°C) service range

CHARACTERISTICS

Table 1 | Product Description

Form	Low viscosity, thixotropic paste
Color	White
Cured Density	25 – 31 lb/ft ³
Extrudability at 75°F (24°C)	Extrudes a minimum of 125 grams per minute using a 125" orifice and 60 psi
Slump	≤ 0.01 inches
Shelf Life	6 months from date of shipment at recommended storage
Shop Life	15 days at 75°F (24°C)
Recommended Storage	Store at or below 0°F (-18°C)

PROPERTIES

Table 2 | Compression Strength: Specimen dimensions are 0.5 in. x 0.5 in x 0.5 in (12.7 mm x 12.7 mm x 12.7 mm)

Cure Temperature °F (°C)	Test Temperature °F (°C)	Density	Compression Strength psi (MPa)
250°F (121°C)	75°F (24°C)	28 lb/ft ³	3000 (20.68)
350°F (177°C)	75°F (24°C)	28 lb/ft ³	3100 (21.37)

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Table 3 | Tube Shear Strength, Tubes filled to a void-free state

Cure Temperature °F (°C)	Test Temperature		
	75°F (24°C)	180°F (82°C)	250°F (121°C)
250°F (121°C)	1000 (6.9)	1200 (8.3)	270 (1.9)
350°F (177°C)	1200 (8.3)	1300 (9.0)	300 (2.1)

APPLICATION NOTES

Cure Procedure

Typical cure cycle uses a 3 – 5°F (1.7 – 2.8°C) per minute ramp rate to 250°F or 350°F (121°C or 177°C) and a 60 minute hold at cure temperature. Material may be cured unrestrained or restrained using required pressure.

PRODUCT HANDLING AND SAFETY

Cytec Engineered Materials recommends wearing clean, impervious gloves when working with potting compounds to reduce skin contact and to avoid contamination of the product.

Materials Safety Data Sheets (MSDS) and product labels are available upon request and can be obtained from any Cytec Engineered Materials Office.

DISPOSAL OF SCRAP MATERIAL

Disposal of scrap material should be in accordance with local, state, and federal regulations.

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