

Cardolite® LITE 3025

Epoxy Curing Agent

Technical Datasheet

DESCRIPTION

Cardolite LITE 3025 is a solvent free, light color, medium viscosity phenalkamide curing agent suitable for high solids epoxy coatings and adhesive applications. This curing agent offers advanced performance as fast cure, good dry color stability, and extended overcoat window in addition to excellent bond strength to various substrates.

PROPERTIES

PROPERTY	SPECIFICATION	TEST METHOD
Color (Gardner)	≤ 10	ASTM D1544
Viscosity @ 25°C (cPs)	30,000 - 40,000	ASTM D2196
Amine Value (mg KOH/g)	330 - 360	ASTM D2074
Solids (% by weight)	≥ 99	ASTM D2369-98

PROPERTY	TYPICAL VALUE	TEST METHOD
Appearance	Orange red color liquid	Visual
Theoretical Active Hydrogen Equivalent (AHEW) ¹	103	Calculated
Density @ 25°C (kg/L) (lbs/gal)	0.972 8.11	ASTM D1475
Flash point	207°C / 405°F	ASTM D93
Recommended Use Level (phr, EEW 190)	54	-

Typical properties are not to be construed as specifications

¹Based on total product weight

CURE PROPERTIES

	FORMULATION	TEST METHOD
Liquid Epoxy Resin (pbw, EEW 190)	100	
Cardolite LITE 3025 (pbw)	54	
Mix viscosity @ 25°C (cPs)	18,700	
Gel time, 50 g @ 25°C (min)	170 - 220	NTM-15
Thin film dry times, 6 mils (150 micron) @ 25°C (77°F) (hrs hard/through)	7/11	ASTM D5895

* 20 to 30 mins induction time recommended

REGULATORY STATUS

Please refer to the material safety data sheet (MSDS). Specific information regarding chemical inventory listing can be obtained from your local sales representative.

SAFETY PRECAUTIONS

Please refer to the material safety data sheet (MSDS). Copies of the MSDS can be requested on the Cardolite website or via your local sales representative.

STABILITY AND STORAGE

Cardolite products may absorb moisture and carbon dioxide when left in open containers, which could result in increased viscosity, discoloration, reduction of reactivity, and/or crystallization of the products. These products should be kept tightly sealed in their original containers when not in use, and stored in a cool, dry place.

CONTACT INFORMATION



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