

# Cardolite® NC-641

## Epoxy Curing Agent

### Preliminary Technical Datasheet

#### DESCRIPTION

Cardolite NC-641 is an epoxy curing agent based on latest modified phenalkamine technology.

#### TYPICAL PROPERTIES

PROPERTY	TYPICAL VALUES	TEST METHOD
Appearance	Reddish brown liquid	Visual
Color (Gardner)	≤ 17	ASTM D1544
Viscosity @ 25°C (cPs)	15,000 - 40,000	ASTM D2196
Amine Value (mg KOH/g)	280 - 335	ASTM D2074
Theoretical Active Hydrogen Equivalent (AHEW) <sup>1</sup>	130	Calculated
Volatile Loss (% weight)	≤ 3.0	ASTM D2369-98
Density @ 25°C (kg/L) (lbs/gal)	0.98 - 1.00 8.18 - 8.35	ASTM D1475
Flash point	101°C / 214°F	ASTM D93
Recommended Use Level (phr, EEW 190)	68	-

Typical properties are not to be construed as specifications

<sup>1</sup> Based on total product weight

#### CURE PROPERTIES

	FORMULATION	TEST METHOD
Liquid Epoxy Resin (pbw, EEW 190)	100	
Cardolite NC-641 (pbw)	68	
Mix viscosity @ 25°C (cPs)	13,600	
Gel time, 50 g @ 25°C (min)	61	NTM-15
Thin film dry times, 8 mils (200 micron)		
@ 25°C (77°F) (hrs hard/through)	4.0 / 6.5	ASTM D5895
@ 5°C (42°F) (hrs hard/through)	13.5 / 16.5	ASTM D5895
@ 0°C (32°F) (hrs hard/through)	21 / 28	ASTM D5895
Film appearance @ 10°C, 92% RH	Clear	Visual

## REGULATORY STATUS

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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

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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

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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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