

ECA-314 Epoxy Hardener

5:1 Mix Ratio

Description:

ECA-314 is a rapid cure hardener capable of curing at room temperature but optimal physical properties occur when cured between 160 – 190 ° F in a heated compression molded press. ECA-314 is designed to minimize skin irritation potential. Use ECA-314 where increased adhesion to difficult substrates, aluminum, stainless steel, UHMW, rubber and ABS is required. Compression molding and Air-Bag press temperatures between 170 – 180 °F will cure skins and boards in approximately 12-15 minutes. Vacuum bagging is also an effective method but elevated temperatures are still recommended. These times and temperature will vary depending on press conditions and ambient temperatures. Test and approve all press conditions and cure profiles in your ski or board design.

For a medium cure hardener with a 21-24 minute pot life use ECA-324.

Advantages:

- Improves adhesion to difficult substrates.
- Rapid cure.
- 5:1 mix ration by weight.
- High strength and excellent chip resistance

Physical Properties:

<u>Property</u>	<u>Method</u>	<u>Value</u>
Mix ratio	Weight	Resin 100 Hardener 20
Color	Visual	Amber
Viscosity @ 77°F (cps)	Brookfield	200-300
Pot Life (150gm 77°F)		10-12 Minutes
Density	Weight/gal	8.5

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