

ECA-324 Epoxy Hardener

5:1 Mix Ratio

Description:

ECA-324 is a medium 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-324 is designed to minimize skin irritation potential. Use ECA-324 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 20-25 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 rapid cure hardener with a 10-14 minute pot life use ECA-314.

Advantages:

- Improves adhesion to difficult substrates.
- Medium cure.
- 5:1 mix ratio 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)		20-25 Minutes
Density	Weight/gal	8.5

Quality Controlled Manufacturers of INKS, COATINGS, ADHESIVES, & MOLDING VINYLs and EPOXIES
Recommendations for the use of this product are based on tests believed to be reliable. However, since the use of this product is beyond our control, no guarantee or warranty of any kind express or implied is made with respect to information presented and QCM Co. assumes no responsibility for the results of the use of this product and processes described.

930 Central Ave. S. • Kent, WA 98032 • 1 (800) 321-0170 • (253) 859-0933 • Fax (253) 859-0935
www.qcminks.com • www.qcminds.com