

ECA-408 Epoxy Hardener

4:1 Mix Ratio

Description:

ECA-408 is a hardener capable of heat curing at temperatures up to 230 °F. ECA-408 is specifically formulated to withstand high temperature molding. Temperatures of 190 -230 °F in a compression mold provide optimal physical and adhesion properties in a composite sporting good. ECA-408 has a long pot life critical for complex lay-ups requiring extended working times. ECA-408 has very low viscosity and excellent cloth wetting properties good for use in the resin infusion process.

Compression molding and Air-bag press temperatures between 190 – 200 °F will cure skis and boards in approximately 40-50 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.

Advantages:

- Cures at high temperatures up to 230 °F.
- Low viscosity and long working time.
- 4:1 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 25
Color	Visual	Amber	
Viscosity @ 77°F (cps)	Brookfield	100-200	
Pot Life (150gm 77°F)		44 Minutes	
Density	Weight/gal	8.03	

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