

## EPI-CURE™ Curing Agent 3290

**Introduction** EPI-CURE™ Curing Agent 3290 is a modified aliphatic amine, light colored, low viscosity epoxy curing agent. Systems cured with EPI-CURE 3290 exhibit excellent solvent resistance. Mix ratios are less critical than standard polyamines.

- Features**
- Reduced vapor pressure
  - Less critical mix ratios
  - Low mixed viscosity
  - Low shrinkage
  - Good chemical resistance

- Suggested Uses**
- Metal and plastic adhesives
  - Laminates
  - Automotive body patching compounds
  - Small castings
  - Electrical potting
  - Tooling compounds

<b>Typical Properties</b>	<b>Amine value</b>	990-1,020
	<b>Viscosity at 25 °C, cP</b>	350-450
	<b>Color, Gardner</b>	≤4
	<b>Flash point, ASTM D-3278, °C</b>	>110
	<b>Mix ratio, EPON™ Resin 828</b>	25
	<b>Pounds/gallon at 25 °C</b>	8.5
	<b>Appearance</b>	Clear and free of foreign particles
	<b>Equivalent weight, approx.</b>	48

Table 1/Properties of epoxy systems cured with EPI-CURE™ Curing Agent 3290

<b>Composition (parts by weight)</b>	<b>A</b>	<b>B</b>	<b>C</b>	<b>D</b>
EPON™ Resin 828	100	–	–	–
EPON Resin 813	–	100	–	–
EPON Resin 815	–	–	100	–
EPON Resin 8132	–	–	–	100
EPI-CURE™ 3290 Curing Agent	25	25	25	23
<b>Handling properties at 25 °C</b>				
Initial viscosity, cP	5,400	880	800	800
Pot life, 100 gram mass, min.	23	27	31	33
<b>Cured state properties<sup>1</sup></b>				
Heat deflection temperature, °C	98	55	59	50
Tensile strength, psi	10,740	10,010	7,945	8,838
Tensile elongation at break, %	10.0	6.7	9.6	9.6
Flexural strength, psi	16,954	19,316	16,694	14,162
Initial flexural modulus, 10 <sup>6</sup> psi	0.44	0.57	0.48	0.42
Hardness, Shore D	88	86	84	82
<b>Chemical resistance<sup>2</sup></b>				
Water	0.19	0.15	0.24	0.23
5% acetic acid	1.10	4.24	4.66	3.68
5% sodium hydroxide	0.17	0.12	0.27	0.20
50% xylene / 50% isopropanol	-0.03	2.48	0.41	2.23

<sup>1</sup>Determined on 1/8-inch thick test specimens cured 24 hrs at 25 °C followed by 2 hrs at 100 °C.

<sup>2</sup>Percent weight gain after immersion for 24 hrs at 25 °C.

### Storage

EPI-CURE Curing Agent 3290 should be kept in tightly closed containers in a cool, dry place. Product will absorb moisture and carbon dioxide which may affect viscosity or create foaming when reacted with epoxy resins. This product will have a minimum shelf life of one year if properly stored in unopened containers.

For product prices, availability, or order placement,  
call our toll-free customer service number at:  
1-877-859-2800

For sales in North and South America outside the United States, call:  
1-832-366-2365

For literature and technical assistance, visit our website at:  
[www.hexion.com](http://www.hexion.com)

## SAFETY & HANDLING

These products are capable of producing adverse health effects ranging from minor skin irritation to serious systemic effects. Exposure to these materials should be minimized and avoided, if feasible, through the observance of proper precautions, use of appropriate engineering controls, and proper personal protective clothing and equipment, and adherence to proper handling procedures. **None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheet (MSDS) for these and all other products being used are understood by all persons who will work with them.** Questions and requests for information on Hexion Specialty Chemicals, Inc. ("Hexion") products should be directed to your Hexion sales representative, or the nearest Hexion sales office. Information and MSDSs on non-Hexion products should be obtained from the respective manufacturer.



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