

Orca 4:1 Med Curing Agent



4:1 Med

CURING AGENT

Description:

Orca 4:1 Medium is a modified aliphatic amine, light colored, low viscosity epoxy curing agent. Use with Orca 1300 series Epoxy Resin systems.

Features:

- Reduced vapor pressure
- Less critical mix ratios
- Low mixed viscosity
- Low shrinkage
- Good Chemical resistance
- High clarity

Uses:

- Yacht/Boat Construction
- High Performance manufactured parts
- RTM/VARTM/Vacuum bagging
- Hand Lay-up application (fast wet out)
- Electrical Potting
- Tooling compounds
- Metal and plastics adhesive

TYPICAL PROPERTIES 25:100 weight

Uncured Curing Agent

Flash Point, ASTM D-3278, °F	>200
Mix ratio, Orca 1300 series	25:100
Gel Time 77° F	20-25 minutes (Orca 1300)

Handling Properties at 77 °F

Viscosity,	4300 cps (Orca 1300)
Pot Life at 77 °F	20-25 minutes (Orca 1300)

Cured Resin¹

The information herein is general information designed to assist customers in determining whether Orca products are suitable to their applications. Orca products are intended for sale to industrial and commercial customers. We require customers to inspect and test our products before use and to satisfy themselves as to contents and suitability for their specific applications. **Nothing herein constitute any warranty express or implied, including any warranty of merchantability or fitness for a particular purpose**, nor is any protection from any law or patent to be inferred. The exclusive remedy for all proven claims is limited to replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.

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<u>Test</u>	<u>ORCA 1300 Value</u>
Heat deflection temperature, °F	140.8
Tensile strength, psi	11378.7
Flexural strength, psi	20908.3
Flexural modulus	540487.0
Barcol Hardness (934-1)	39

Handling & Storage

All epoxy Resin/ Curing Agents, 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 Resin/Curing Agents. This product will have a minimum shelf life of one year if properly stored in unopened containers.

Orca 4:1 Slow Curing Agent is available in 55-Gallon metal drums.

To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers at temperatures below 75°F and away from heat sources and sunlight. All storage areas and containers should conform to local fire and building codes. Inventory levels should be kept to a reasonable min with first-in, first-out stock rotation.

Safety

Read and understand the Material Safety Data Sheet before working with this product

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