

Orca 4:1 Fast Curing Agent



4:1 Fast CURING AGENT

Description:

Orca 4:1 Fast Curing Agent is a very reactive modified aliphatic amine adduct, has been developed for applications where relatively short cure periods at room temperature are required. Use with Orca 1300 series Epoxy Resin systems.

Features:

- Reduced vapor pressure
- 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, 77 ° F	>200
Mix ratio, Orca 1300 series	25:100
Pounds/gallon at 77 ° F	
Gel Time 77° F	10-15 minutes
Peak Exotherm Temperature ° F	165.2

Handling Properties at 77 °F

Mixed Viscosity	1300 cps (Orca 1300)
Pot Life at 25 ° C	10-15 minutes (Orca 1300) @ 25:100

Cured Resin

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.

Fiberlay Inc. - 24 S Idaho St Seattle WA, 98134 (800)942-0660

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<u>Test</u>	<u>ORCA 1300</u> <u>Value</u>
Heat deflection temperature, °F	137.3
Barcol Hardness(934-1)	40
Tensile Strength	13369.9 PSI
Flexural Strength	22472.9 PSI
Flexural Modulus	566089.1 PSI
Elongation %	4.1

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 Fast 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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