

Advanced Materials**ARADUR® 125-2 Hardener**

Standard Polyamide Hardener

GENERAL	Aradur® 125-2 hardener is a polyamide material produced by the condensation of dimer acids and selected polyamines. Aradur® 125-2 hardener has good wetting characteristics. When used to cure Araldite® epoxy resins, it provides excellent flexibility, toughness and good overall chemical resistance.	
CHEMICAL DESCRIPTION	Standard polyamide hardener	
APPLICATIONS	Solvent-borne coatings for industrial maintenance Adhesives Castings Caulking Potting compounds Sealing	
ADVANTAGES	Excellent mechanical properties Excellent corrosion resistance Excellent adhesion Non-critical mixing ratio Suitable for the formulation of coatings compliant with FDA 21 CFR 175.300	
TYPICAL PROPERTIES*	Visual Appearance	Clear, no contamination
	Viscosity @ 40°C, mPa s (cPs)	8,000 - 12,000
	Color, Gardner, max.	9
	Amine Value, mg KOH/g	330 - 360
	H ⁺ Active Equivalent, g/eq.	100 - 150
	Density, @ 25°C (77°F), g/cm ³ (lb/gal)	0.96 (8.0)
	Flash Point, Closed Cup, °C (°F)	160 (320)

* Typical properties are based on Huntsman's test methods. Copies are available upon request.

STARTING FORMULATION

Aradur[®] 125-2 hardener may be used to cure both Araldite[®] liquid epoxy resins and low molecular weight solid epoxy resin solutions either at room or elevated temperatures. The ratio of epoxy resin to polyamide resin will determine the ultimate coating properties. The normal range of polyamide to epoxy resin is 33 to 100 phr*, 50 - 70 phr being typical for most general purpose applications.

The cure schedule depends upon the total formulation used (i.e., resin, fillers, solvents, etc.) and the conditions of application (i.e., temperature, humidity, thickness, etc.). The time varies inversely with temperature.

Coal Tar Modified Epoxy Coating

(Corps of Engineers Specification CW 09940)

Part A	Pounds / 100 Gal.
Coal Tar Pitch (70 - 75°C Softening Point ¹)	291
Aradur [®] 125-2	96
Magnesium Silicate ²	258
Xylene	166
Ethyl Alcohol (95%)	8
Thixotropic Agent ³	13
Accelerator 960-1 ⁴	11

Part B

Araldite [®] 6010	215
Total (Parts A & B)	1,058

*phr=parts per hundred resin

Raw Material Suppliers

¹ CP-301-Material manufactured by Allied Chemical specifically to meet CE-1409 (C-200) specification.

² Nylal 3X, R.T. Vanderbilt Co. or equal

³ Bentone 38 (NL Industries) or equal

⁴ Accelerator 960-1, Huntsman

STORAGE

Aradur® 125-2 hardener is supplied in a 420 pound steel drum. It should be stored in a dry place, in the sealed original container, at temperatures between +2°C and +40°C (+35.6°F and 104°F). Under these storage conditions the shelf life is 3 years. The product should not be exposed to direct sunlight.

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First Aid!

Refer to MSDS as mentioned above.

KEEP OUT OF REACH OF CHILDREN

FOR PROFESSIONAL AND INDUSTRIAL USE ONLY

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