

**DESCRIPTION**

Dicyanex 325 curing agent is a pulverized grade of dicyandiamide containing 3% of an inert flow control additive to inhibit clumping and improve handling. It is designed for use as a latent curing agent for epoxy resins.

**ADVANTAGES**

- High level of inert flow control additive prevents clumping and facilitates dispersion into liquid resins
- Enhanced reactivity versus nonpulverized grades in solvent-free systems
- Shelf stability of up to 6 months @ 77°F (25°C) in properly formulated systems
- Activation temperature can be varied easily from 356°F - 203°F (180°C - 95°C) with appropriate accelerator selection

**APPLICATIONS**

- One-component adhesives
- Recreational and industrial pre-preg composites

**SHELF LIFE**

At least 12 months from the date of manufacture in the original sealed container at ambient temperature. Store away from excessive heat and humidity in tightly closed containers.

**STORAGE AND HANDLING**

Refer to the Safety Data Sheet for Dicyanex 325 curing agent.

**TYPICAL CURE SCHEDULE**

- 1-2 hr @ 356°F (180°C)
- 45 min @ 250°F (120°C) with 0.5 parts Imicure™ AMI-2 curing agent

**TABLE 1: TYPICAL PROPERTIES**

<b>Appearance</b>	White, Crystalline Particles
<b>Melting Point (°F)</b>	405-412
<b>Particle Size (microns):</b>	
<b>90%</b>	<44
<b>50%</b>	<16
<b>Nitrogen as % of Dicyandiamide</b>	99
<b>Equivalent Wt/{H}</b>	21
<b>Recommended Use Level (phr, EEW=190)</b>	4-15

**TABLE 2: TYPICAL HANDLING PROPERTIES**

<b>Gel Time (month) [150 g mass @ 77°F (25°C)]</b>	12
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**TABLE 3: SUGGESTED ACCELERATORS**

<b>Ancamine® 2014AS/2014FG</b>
<b>Amicure™ UR/UR2T</b>
<b>Imidazoles</b>

**TABLE 4: TYPICAL PERFORMANCE**

<b>Tg (°F)*</b>	250
<b>when accelerated with Ancamine 2014AS</b>	115

\*Measured using DSC with 50°F (10°C)/min ramp.

Value will be higher when accelerated with an imidazole.

Epoxy Curing Agents and Modifiers

# DICYANEX® 325 Curing Agent

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