

Amicure® CG-325G Curing Agent**DESCRIPTION**

Amicure CG-325G curing agent is a micronized grade of dicyandiamide containing 1.5% 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

- Fine particle size provides enhanced reactivity versus coarser grades
- Excellent dispersibility in liquid resin due to high level of flow additive
- Shelf stability up to 6 months at 77°F in properly formulated systems
- Activation temperature can be easily varied from 355°F to 203°F with appropriate accelerator selection

APPLICATIONS

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

SHELF LIFE

At least 24 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 Amicure CG-325G curing agent.

TYPICAL CURE SCHEDULE

- 1) 1–2 hours at 355°F.
- 2) 45 minutes at 250°F with 0.5 parts Imicure™ AMI-2 curing agent.
- 3) 30 minutes at 285°F with 2–5 parts Ancamine® 2441 curing agent.

TABLE 1: TYPICAL PROPERTIES

Appearance	White, Crystalline Particles
Melt Point (°F)	405-406
Particle Size (microns)	97
90%	<44
50%	<16
Nitrogen as % of Dicy	99
Equivalent Wt/{H}	21
Recommended Use Level (phr, EEW=190)	4-15

TABLE 2: TYPICAL HANDLING PROPERTIES

Gel Time (150g mass @ 77°F) (mo)	12
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TABLE 3: TYPICAL PERFORMANCE

Tg (°F)*	277
Tg (°F) when accelerated with Ancamine 2441	257

* Measured using DSC with 18°F/ min ramp. Value will be higher when accelerated with an imidazole.

SUGGESTED ACCELERATORS

- Amicure® UR series (substituted ureas)
- Imicure™ and Curezol™ series (imidazoles)
- Ancamine® 2014AS (modified amines)
- Ancamine® 2441/2442 (modified amines)

Epoxy Curing Agents and Modifiers

Amicure® CG-325G Curing Agent

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