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LORD Corporation CPD

Technical Bulletin

Epoxy Hardeners

Hardener	Type	Color	Viscosity @ 25°C cps	Specific Gravity @ 25°C	Characteristics
Lord RT-1 (+) Circalok 6010B	Modified aliphatic polyamine	Light Straw	80-105	1.0	Room temperature cure, pot life 1-2 hrs, cure 8-12 hrs @ 25°C or 2-3 hrs @ 65° C, rigid system, suitable for castings up to 200g. HDT* -125°C
Lord RT-1AX (+)	Mixture of aliphatic polyamines	Light Straw	70-100	1.0	Similar properties to RT-1, pot life is shorter and cure is twice as fast, very rigid system. HDT* -125°C
Lord RT-7 (+) Circalok 6252	Modified aliphatic diamine	Light Straw	10-30	1.01	Room temperature cure, excellent air release, very low viscosity, excellent impact resistance, semi-rigid, pot life 1-2 hrs, cure 8-12 hrs @ 25°C, or 2-3 hrs @ 65°C. HDT* -70°C
Lord RT-7LC	Modified aliphatic diamine	Light Straw	30-50	1.01	Identical properties to RT-7, except viscosity is slightly higher. HDT* -80°C
Lord RT-8	Modified tertiary amine	Green	800-1000	.99	Meets MIL-I-16923E, rated at 105°C. Very low exotherm, semi-rigid system, pot life 4-6 hrs, cure 16-24 hrs @ 25°C, much lower viscosity than RT-10 or RT-10LV, excellent image resistance, excellent in large castings. HDT* -120°C
Lord RT-10 (+)	Polyamine	Amber	25,000	.97	Excellent for very large castings, superior adhesion, very low exotherm, ratio may be varied to produce flexible to rigid system, moisture resistance inferior to other hardeners, room temperature cure of 16-24 hrs. HDT* -85°C
Lord RT-10LV Circalok 6251	Polyamine	Amber	12,000	.97	Similar properties to RT-10, but lower viscosity. HDT* -125°C
Lord RT-13 (+) Circalok 6250	Modified polyamine	Amber	300-500	1.0	Room temperature cure, good for large castings, lower viscosity than RT-10 or RT-10LV, semi-rigid system, mix ratio can be varied, excellent impact resistance, good adhesion. Pot life 1-3 hrs, cure 8-12 hrs @ 25°C. HDT* -75°C
Lord RT-1355 (+)	Modified polyamine	Amber	100-150	.99	Room temperature cure, gives properties close to RT-7, not recommended for thin film applications, good for medium size castings, pot life 2-4 hrs, cure 16-24 hrs @ 25°C. HDT* -75°C

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Lord RT-55	Modified aliphatic polyamine	Tan to Yellow	60-80	1.0	Room temperature cure, gives properties close to RT-7, not recommended for thin film applications, good for medium size castings, pot life 2-4 hrs, cure 16-24 hrs @ 25°C.
Lord E-62S (+)	Modified aromatic diamine	Tan	100	1.00	Elevated temperature cure, very rigid system, does not crystallize, pot life 1-2 hrs, cure 24 hrs @ 65°C or 2-6 hrs @ 100° C. HDT* - 155°C
Lord E-62LR Circalok 6044	Modified aromatic diamine	Tan	100	1.00	Same properties as E-62S, except it cures more slowly and is recommended for larger castings. Pot life 2-4 hrs, cure 24 hrs @ 65°C or 4-8 hrs @ 100°C. HDT* -160°C.
Lord HT-75	Anhydride	Tan	Solid wax @ 25°C	1.3	High temperature cure, long pot life, excellent electrical properties at high temperatures, cure 2-4 hrs @ 125°C to 190°C. HDT* -200°C

Shelf Life is 1 year from date of shipment (stored in unopened containers)

*HDT – Heat distortion temperature (ASTM D-648-56)

(+) – These products have an "S" added to the code when added adhesion is required.

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