

# AMICURE<sup>®</sup> IC-322

## Curing Agent

### DESCRIPTION

Amicure IC-322 curative is an amine curing agent specifically designed to cure with standard HDI Trimer or Biuret Isocyanates for thin-film commercial and industrial flooring applications up to 20 mils.

Amicure IC-322 curative offers flexibility in formulating a high gloss or a satin finish with the addition of an external matting agent. Amicure IC-322 curative can provide clear and pigmented coatings that exhibit rapid property development, UV stability and high aesthetics. We recommend the use of a high solids or waterborne epoxy primer especially under Damp conditions. Working & dry times are significantly accelerated under high humidity conditions.

### TYPICAL PROPERTIES

Property	Value	Unit	Method
Colour	< 2	Gardner	
Amine Equivalent Weight	373 - 385	AEW	
Density	1.08	g/ml	
Viscosity @ 25°C	90 - 120	cPs	

### ADVANTAGES

- Formulations allow for smooth, satin finish
- Very low viscosity
- Low color and excellent UV durability
- Low temperature cure
- Can be cured with HDI trimer or biurets
- <100 g/L VOC (EPA method 24)

### APPLICATIONS

- High and low gloss
- Clear & Pigmented Floor Coatings

### SHELF LIFE

At least 18 months from the date of manufacture in the original sealed container at ambient temperature. Store away from excessive heat and humidity and avoid contact with moisture. Recommended storage

## STORAGE AND HANDLING

Refer to the Safety Data Sheet for AMICURE IC-322 amine curing agent for polyisocyanate resin.

## TYPICAL HANDLING PROPERTIES

Property	Value	Unit	Method
Isocyanate Resin	HDI Trimer		HDI Trimer = 21.8 wt% NCO, 2500 cPs @ 25°C
Mix Ratio	1.8 to 2		curing agent to Isocyanate by weight
Use Level	180 - 200	phr	
Mix Viscosity @ 25°C	350 - 550	cPs	
Viscosity build	50 - 70	min	time to 12,000 cPs

## DRY FILM TIMES (10MIL THICKNESS, 22°C 50% RH)

Property	Value	Unit	Method
Dry time, set to touch	45	min	
Dry time, tack free time	75	min	
Dry time, through cure	6 - 7	h	

## DRY FILM TIMES (10MIL THICKNESS, 27°C 73% RH)

Property	Value	Unit	Method
Dry time, set to touch	35	min	
Dry time, tack free time	55	min	
Dry time, through cure	5 - 6	h	

## TYPICAL FINAL PROPERTIES

Property	Value	Unit	Method
PersoZ Hardness	150	10 mil	
UV Resistance	3.5	ΔE	QUV-A, 500hrs
Gloss (60°)	92		
Gloss (60°) with matting agent	40 - 45		Acematt® 3600 (Evonik)
Abrasion Resistance	50	mg loss	1000 cycles, 1kg, CS17 Wheel
Gardner Impact Resistance	> 160 / > 160		Direct / Reverse

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