

# HARDENERS & ACCELERATORS

Product Code	Type	% Non Volatiles ±2	Viscosity		Amine Value mg. KOH/g.	Amine eq. wt.	Mixing ratio with 100 part of		Cure Conditions	Notes
			Ref.	Unit			SYNPOL 200	SYNPOL 450XX		
HARDENER 111	Aliphatic polyamine	...	V1	35 - 45	1410-1480	25	10 - 14	5 - 7	16 - 24 hours at 25°C	Electrical potting, encapsulation, casting, hand lay-up lamination and tooling, flooring, surfacing & adhesives. Coal tar modified surface coatings.
HARDENER 222	Aliphatic polyamine	...	V1	7 - 10	1550-1650	21	8 - 12	4 - 6	16 - 24 hours at 25°C	
HARDENER 260	Modified Aliphatic Polyamine	...	V1	70 - 90	900 - 950	32	22 - 24	...	Do	Solvent free epoxy coatings, castings, sealing & laminating. Very good wetting properties of glass fibre in laminating application.
HARDENER 280	Modified Aliphatic Polyamine	...	V2	20 - 30	450 - 500	62	30 - 35	...	Do	High reactivity through built in accelerator, immunity against carbon dioxide & low water miscibility of hardener component, suits for applications under high humidity, even under water & temperature upto 5°C.
HARDENER 340	Modified Aromatic Polyamine	...	V2	40 - 60	...	114	55 - 65	...	Do	Tank linings, linings & coatings for concrete & metal pipes, chemical resisting floorings, concrete structure finishes, marine & under water coatings.
HARDENER 345	Modified Aromatic Polyamine	...	V2	20 - 40	...	114	55 - 65	...	Do	
HARDENER 350	Modified Aromatic Polyamine	...	V2	150-210	...	104	50 - 60	...	Do	
HARDENER 410	Aliphatic amine epoxy adduct	50	V2	10 - 20	200 - 240 of resin solids	...	...	65 - 70	Do	For excellent chemical and solvent resisitant clear & pigmented coatings for maintenance and protection for industrial & marine applications.
HARDENER 410 PM	Aliphatic amine epoxy adduct	48	V2	20 - 60	80 - 100 of resin solution	...	...	80 - 100	Do	
HARDENER 444	Aliphatic amine epoxy adduct	40	V2	2 - 6	280 - 330 of resin solids	...	...	70 - 75	Do	

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<b>HARDENER 465</b>	Aliphatic amine epoxy adduct	...	V2	80 - 120	250 - 300	...	95 - 105	...	Do	Fast curing hardener, very good chemical & high heat resistance on ambient & elevated temperature. epoxy putty having equal mixing ratio. High solids epoxy coatings. Offer excellent resistance against mineral acids, alkalis, water & aromatic hydrocarbons.
<b>HARDENER 473</b>	Aliphatic amine epoxy adduct	...	V2	25 - 65	750 - 850	...	18 - 20	...	Do	Hardener for solvent free high solids & fast curing epoxy coatings for excellent resistant to organic solvents, mild acids and alkalis.
<b>HARDENER 620</b>	Cycloaliphatic amine epoxy adduct	...	V2	2 - 5	280 - 320	...	45 - 55	...	Do	Decorative colour stable, self levelling flooring system, trowelling compounds giving excellent adhesion, low shrinkage, high chemical & mechanical resistance. Very useful for flooring, dairies, food factories, meat packing plants & warehouses.
<b>HARDENER 640</b>	Phenyl alkamine	...	V2	20 - 40	500 - 550	...	40 - 50	...	Do	Solvent free or high solids epoxy coatinga, curing in presence of moisture at low ambient temperature, non-critical mixing ratio, for heavy duty maintenance & marine coatings. It offers very good handling properties, fast cure rates, along with low viscosity, superior chemical resistance & adequate flexibility.
<b>HARDENER 2021</b>	Modified Aliphatic Polyamine adduct	...	V2	3 - 5	385 - 410	...	40 - 50	...	Do	Moderately long pot life hardener. Gives high gloss finishes, specially formulated for high solids and solvent free coatings, flooring, laminates etc.
<b>D M P 30</b>	Accelerator (Tertiary amine)	...	V2	1 - 5	600 - 640	...	5 - 10	...	Do	As accelerator with polyamide & anhydride curing agents & as hardner for casting, laminating & adhesive applications.

**Note:-**

V1 of supply at 25°C., in Cps.

V2 of supply at 25°C., in Poises.