

18027 Bishop Avenue  
Carson, CA 90746-4019  
Phone: (800) 374-3872  
Fax: (310) 202-7247  
[www.gracoroberts.com](http://www.gracoroberts.com)



**TECHNICAL DATA SHEET**  
**RF 24**  
**CYCLOALIPHATIC AMINE HARDENER**

**Description**

RF 24 is a cycloaliphatic amine curing agent used to cure various epoxy resins at elevated temperatures. This particular curing agent offers light color, low viscosity, long pot life and high glass transition temperature (Tg). Because of its light color, absence of staining and excellent physical properties, it is recommended as a replacement for aromatic amines.

**Handling Properties, Typical \***

Property	RF 24
Mix Ratio: by Weight by Volume	100:32
Amine Equivalent Weight	60
Color (Gardner)	2 max
Viscosity @ 77°F (25°C), cps	120
Pot Life, 100 grams @ 77°F (25°C)	400 min
Cure Schedule	1 hr @ 180°F + 2 hr @ 250°F

**Physical Properties, Typical Cured Performance \***

** Property	Test Method	Unit	Value
Glass Transition Temperature	TMA	°C	162
Tensile Strength	ASTM D638	psi	11,200
Tensile Modulus	ASTM D638	kpsi	377
Tensile Elongation	ASTM D638	%	5.2

\*\* **Cure:** 1 hour at 180°F plus 3 hours at 300°F

\* All properties are with 190 EEW Bisphenol A epoxy

**SAFETY INFORMATION:** Store at 65-85°F. See Material Safety Data Sheet for additional information.

**SPECIAL NOTICE:** RF 24 is a high purity substance and is subject to crystallization. The product may be restored by heating to 105°C and should remain liquid on cooling to ambient temperature. The container lid should be loosened to equalize pressure, but care should be taken to restrict air flow over the product during the heating process. An inert gas blanket, such as Nitrogen, is preferred but not required. The

functionality of RF 24 will not be harmed by heating under these conditions for short (< 8 hours) periods of time.

Notice to Buyer: Exclusion of Warranties and Limitation of Liability

This data sheet does not constitute a specification. All information supplied by Resin Formulators and E.V. Roberts is considered accurate, but is furnished upon the express condition that the person receiving it shall make their own tests to determine its suitability for their particular purpose. No warranty is expressed or implied regarding such information, the data upon which the same is based, or the results to be obtained from the use of such information or product will not infringe any patent.

Revised: D. Soden 10-08-2015