NANUQ™ CTD-425
Technical Data Summary

• **Blended EP/CE system**
  - CTD-425 is a two-part system with Epoxy (EP) and Cyanate Ester (CE) catalyst in part A and Cyanate Ester (CE) in part B

• **System mixing ratio**
  - Mix 60 parts A (EP) to 40 parts B (CE)

• **Processing**
  - Mixing/Processing Temperature: 45-60°C

• **Initial Viscosity and Potlife**

<table>
<thead>
<tr>
<th></th>
<th>At T=45°C</th>
<th>At T=50°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Initial viscosity</td>
<td>90 mPa·s</td>
<td>70 mPa·s</td>
</tr>
<tr>
<td>Viscosity after 100 hours</td>
<td>150 mPa·s</td>
<td>150 mPa·s</td>
</tr>
</tbody>
</table>

• **Cure Profile**
  - Ramp slowly from processing temperature to 100°C (suggest > 2 hours)
  - 22 hour hold at 100°C; material should gel
  - Ramp slowly from 100°C to 170°C (suggest >3 hours)
  - 24 hour hold at 170°C
  - Cool down SLOWLY to room temperature (suggest > 6 hours)

• **$T_g$ by DMA (from knee of storage modulus)**
  - 185°C

This information, while believed to be completely reliable, is not to be taken as warranty for which we assume legal responsibility. It is offered for consideration, investigation, and verification.

Date Created: September 14, 2009 (Please disregard all previous versions of this data sheet)