PFLAUMER

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TERAMINE® 654

Co-hardener or Accelerator for Ambient-Cure Epoxy Systems

TYPICAL CHARACTERISTICS

Appearance	Amber Liquid
Color, Gardner	< 6
Amine Value	610 - 640
Weight Per Gallon, Lbs	8.1 - 8.3
Viscosity, cps @ 25°C	125 - 250

COMPATIBILITY

TERAMINE® 654 is a catalyzing additive designed for use in epoxy coating systems. The product facilitates reactions between epoxy resins and various hardener chemistries, accelerating cure times and improving the structural properties of the resulting coating. It is especially recommended for use with polyamides and polyamidoamines.Formulators can adjust the amount of TERAMINE® 654 used for each application as needed, allowing for greater flexibility and customizability in formulation.

APPLICATIONS

When used as an additive along with other hardeners, TERAMINE® 654 acts as a catalyst to speed up cure for epoxy systems across a wide range of applications, including adhesives, electrical casting and impregnation, and high performance composites. The product excels in situations that require specific, carefully controlled cure times, especially when environmental conditions like temperature may otherwise interfere with the coating's properties during application.

TERAMINE® 654 can promote homopolymerization for bisphenol A epoxy resin to be used in applications such as composites.

FEATURES

Accelerant for epoxy systems

Greater control over cure speed

Homopolymerization catalyst

Compliant with FDA Regulation 21 CFR 175.300 (Direct food-contact articles)

RECOMMENDED USE LEVEL

TERAMINE® 654 is for industrial use only. The typical recommendation is to use TERAMINE® 654 at levels not exceeding 5% by weight of epoxy resin when used as a co-hardener with amine-based curing agents. When used as a homopolymerization catalyst, the recommended use level is 5-15% by weight of epoxy resin within the formulation.

SAFETY, STORAGE, AND HANDLING

Consult SDS before use. Store TERAMINE® 654 in tightly sealed containers. Prevent contact with moisture and excess humidity.

Shelf life of product is 24 months from date product is shipped by Pflaumer and then maintained in original closed containers and stored in proper storage conditions at 25°C (75°F). If repackaging, use containers that will prevent moisture contamination.

CONTAINER SIZES

5 Gallon Pail (40 Lbs.)

55 Gallon Drum (441 Lbs.)

275 Gallon Tote (2,204 Lbs.)

PFLAUMER PRODUCTS FOR HIGH-PERFORMANCE COATINGS

Pflaumer offers a wide variety of products to formulate high-performance coatings:

TERAMINE® Hardeners for Epoxies	A wide variety of hardeners for fast-cure, medium-cure, and slow-cure 2K epoxies
TERACHEM® 53-Colorants	Ready-to-use pigment dispersions of masstones and tints for 2K epoxies, polyurethanes and polyaspartics
TERACURE® Aliphatic Polyisocyanates	Complete line of HDI-based trimer and biuret isocyanates
TERASPARTIC® Polyaspartic Amines	A variety of aspartic amine resins to provide slow, medium and fast curing options.
TERACURE® Aromatic Polyisocyanates	MDI-based aromatic isocyanates for polyureas and urethanes
TERACHEM® Polyols	Specialty polyols for urethane coatings
TERACHEM® Reactive Diluents	TERACHEM® A-140 for polyurea and polyaspartic systems
TERAFLEX® Non-Reactive Diluents	TERAFLEX® DME-200 for polyaspartics, polyurethanes, and polyureas
TERACHEM® Moisture Scavengers	Molecular sieve pastes for polyaspartics, polyurethanes, and other applications
Intermediates and Modifiers	TERAMINE® A-136 cycloaliphatic secondary di-amine for polyaspartics, epoxies, and polyureas; Terachem® cycloaliphatic amines (PACM, MACM) for epoxies; Tallicin® 3001 extends pot life for urethanes and polyaspartics
TALLICIN® Wetting Agents, Dispersants, and Grinding Resins	A wide range of surfactants, wetting agents, and dispersants for both solvent-based and water-based formulations; Tallicin® acrylic and modified-acrylic grinding resins
TALLICIN® Surface Tension Agents	A variety of bubble-release, flow and leveling modifiers for solvent-free polyaspartics, epoxies, and polyurethanes
TALLICIN® Catalysts	Tin based catalyst for polyurethanes
TERASIL® Single-Component Moisture-Cure Modified Hydrogel Silane	A modified hydrogel silane for moisture-cure coatings on a wide range of indoor and outdoor substrates, including metal, wood, concrete, plastics, and composites.