

PRO-SET®

LAMINATING
EPOXY

ADHESIVES

PROCESS
EQUIPMENT

Technical Data

185 Resin/285 Hardener

Epoxy Fairing Compound

The 185/285 Fairing Compound is designed for filling and fairing applications in custom building or repair situations. The low density materials mix easily, spread smoothly, are easy to sand and exhibit very low shrinkage. PRO-SET fairing compound can be used on wood, composite, or metal structures.

SURFACE PREPARATION

Surfaces must be free of contaminants and loose paint or primer. Solvent wash if necessary before abrading the surface. Sandblast or grind metal surfaces, and prime with a paint system compatible primer as soon as possible to prevent corrosion prior to fairing application. Sand wood and composite surfaces with 80 grit sandpaper. Remove dust with a shop vacuum after abrading. If peel ply is used during fabrication of the part, test the surface for proper surface profile and adhesion.

MIXING

Some separation may occur during storage. Stir resin and hardener individually before mixing together.

Combine equal parts by volume PRO-SET 185 Resin with PRO-SET 285 Hardener. Use measuring cups or scoops to ensure accurate volume measurements. Measure the resin and hardener and place on a flat plastic or cardboard pallette. Stir the mixture thoroughly, making sure there are no streaks of color. Use a folding motion to blend the materials together. Mix only as much as can be applied within the pot life of the mixture (see page 2).

CURING

The cure rate of epoxy products is affected by mass and temperature. Thicker applications will cure more rapidly than thin layers. Low temperatures increase cure time, while higher temperatures reduce cure time. Minimum application temperature is 60°F. Overnight cure is typically required before sanding.

APPLICATION

Use a trowel or spreader to apply mixed material to the surface. Start by filling the lowest areas first, working toward the highs. Multiple applications may be necessary for filling areas deeper than 1/2". Fairing compound must be sanded to a dull surface before overcoating or re-filling. An epoxy sealer coat or primer must be applied following final fairing to ensure good surface profile and gloss in the final finish coating.

We recommend testing any product using proposed materials and procedures to confirm working and curing characteristics under your shop conditions.

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185/285

HANDLING CHARACTERISTICS *(Not for specification purposes)*

Property	Mixed
Density	5.26 lb/gal
Density	0.64g/ml
Viscosity	Paste

Mix Ratio (185 Resin/285 Hardener)	Target	Acceptable Range
by volume	1:1	1.1:1 to 0.93:1
by weight	100:56	100:51.3 to 100:60.4

Pot Life (ASTM D-2427-71)	100cc	500cc
@65°F	85min	60 min
@72°F	35 min	30 min
@85°F	30 min	27 min

Time to Sand (1/4" thick application)	
@72°F	8 Hr.
@90°F	4 Hr.

Coverage
 6.4 sq. ft / mixed gallon @ 1/4" thickness (0.250")

PHYSICAL PROPERTIES	
Hardness (Shore D)	ASTM 2240 62
Compression Strength (psi)	ASTM D-695 3,334
Izod Impact (Ft-lb/in)	ASTM D-256 0.16
Heat Deflection Temperature (°F)	ASTM D-648 117