

PRO-SET®

Technical Data

INF-114

INF-213

INFUSION EPOXY

The New
Standard

EPOXIES for
Laminating
Infusion
Tooling
Assembly

Wessex Resins & Adhesives

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ISO9001:2015 Certified

REV 3 / Apr 2018

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& Adhesives

COMBINED FEATURES

Very low viscosity for rapid saturation of fibreglass, Kevlar® and carbon fibre laminate with resin infusion and VARTM processes.

Extra slow cure speed hardener provides up to 10 hours of working time at 25°C. A typical laminate will be gelled in approximately 14 to 18 hours at this temperature.

This combination is formulated specifically for resin infusion and VARTM processes. Do not use in open mould applications.

Room temperature cure properties suitable for many composite components and structures.

Tg as high as 89°C with proper post cure providing excellent temperature stability and great part cosmetics.

Cost effective, high performance epoxy formulation for synthetic composite manufacturing.

HANDLING PROPERTIES

Property	Standard	Units	21°C	25°C	29°C
150g Pot Life	ASTM D2471	minutes	424	262	182
500g Pot Life	ASTM D2471	minutes	227	175	135
Viscosity Mixed	ASTM D2196	mPas	325	255	189
Viscosity (resin)	ASTM D2196	mPas	1014		
Viscosity (hardener)	ASTM D2196	mPas	15		

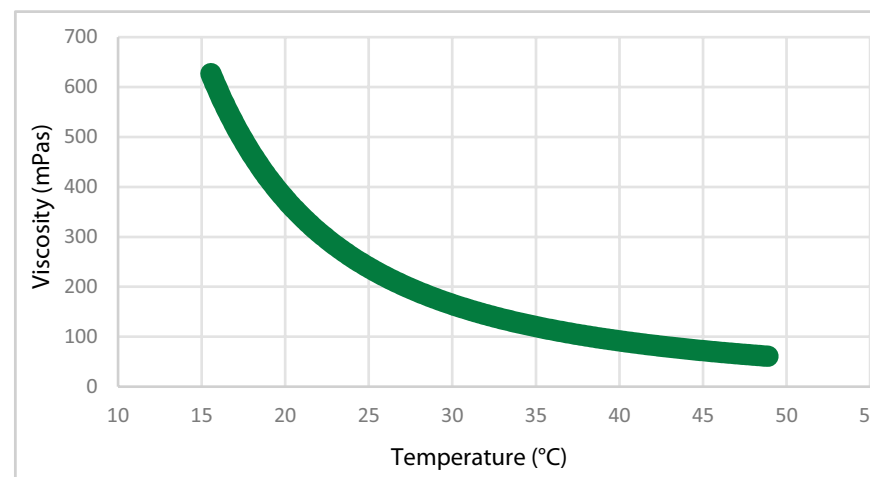
MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	3.65:1	100:27.4
Volume	3.00:1	100:33.3

DENSITY

State	Units	21°C
Cured	gcm ⁻³	1.14
Resin	gcm ⁻³	1.14
Hardener	gcm ⁻³	0.94

VISCOSITY VS TEMPERATURE



Test specimens were neat epoxy (without fibre reinforcement).
Typical values not to be construed as specification.

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MECHANICAL PROPERTIES

Property	Standard	Units	22°C x 4 Weeks	25°C x 2 Weeks	RT Gelation + 49°C x 8 hrs	RT Gelation + 60°C x 8 hrs	RT Gelation + 82°C x 8 hrs
Hardness	ASTM D2240	Shore D	86	86	86	86	86
Compression Yield	ASTM D695	MPa	103	104	97	97	97
Tensile Strength	ASTM D638	MPa	54	58	66	68	70
Tensile Modulus	ASTM D638	GPa	3.72	3.71	3.41	3.21	3.44
Tensile Elongation	ASTM D638	%	1.8	1.9	4.2	4.2	4.2
Flexural Strength	ASTM D790	MPa	82	90	111	112	112
Flexural Modulus	ASTM D790	GPa	3.27	3.24	3.35	3.32	3.14

THERMAL PROPERTIES

Property	Standard	Units	22°C x 4 Weeks	25°C x 2 Weeks	RT Gelation + 49°C x 8 hrs	RT Gelation + 60°C x 8 hrs	RT Gelation + 82°C x 8 hrs
Tg DMA Peak Tan Delta	ASTM E1640*1	°C	68	69	81	92	100
Tg DMA Onset Storage Modulus	ASTM E1640*1	°C	62	62	68	81	89
Tg DSC Onset - 1st Heat	ASTM E1356	°C	56	57	64	72	83
Heat Deflection Temperature	ASTM D648	°C	52	54	55	67	77
Tg DSC Ultimate	ASTM E1356	°C	88*2				

*1 1Hz, 3°C per minute.

*2 Additional post cure may be required; contact Technical Department for details.

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These are typical properties and cannot be construed as a specification. The end users should test the products to ensure the products are suitable for the intended application. Any information, data, advice or recommendation published by Wessex Resins or obtained from Wessex Resins by other means and whether relating to Wessex Resins' materials or other materials, is given in good faith and believed to be reliable.

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