PRO-SET®

Technical Data
ACE-166
ACE-265

The New Standard

ABSOLUTE CLEAR
CLEAR COATING EPOXY - SLOW

EPOXIES for Laminating Infusion Tooling Assembly

Gougeon Brothers, Inc.
P.O. Box 908
Bay City, MI 48707
prosetepoxy.com
888-377-6738

ISO9001:2015 Certified

COMBINED FEATURES

Formulated for extremely clear coatings and laminations with carbon and other reinforcement fibers. Commonly used for clear coatings on wood, surfboard laminations and other boardsport products in a production setting. Provides colorless clarity and UV stability. For ultimate long-term UV stability, use with a UV stable top coat.

Slow cure speed for fill coating, laminating and potting. Slow hardener provides a tack-free cure time of approximately 4 hours at 72°F (22°C).

Easy processing for hand wet out of lightweight reinforcement fabrics or fibers. Provides extremely smooth surface when cured[1]. Excellent sandability. Reaches full physical properties at room temperature cure.

Shelf life is 3 years for resin and 2 years for hardener when properly stored[2].

Rev 2 /Jan 2020

HANDLING PROPERTIES

Property	Standard	Units	72°F (22°C)	77°F (25°C)	85°F (29°C)
150g Pot Life	ASTM D2471	minutes	26-33	24-30	16-20
500g Pot Life	ASTM D2471	minutes	26-32	21-27	16-20
Viscosity Mixed	ASTM D2196	cP	1,054	878	661

MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	2.39:1	100:41.9
Weight Range	2.33:1—2.70:1	100:42.9—100:37.0
Volume	2.00:1	100:50.0
Volume Range	1.96:1—2.26:1	100:51.1—100:44.2

DENSITY

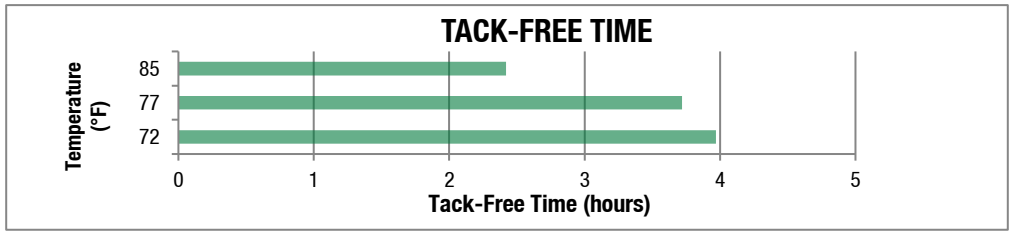
State	Units	72°F (22°C)
Cured	lb/gal (g/cc)	9.60 (1.15)
Resin	lb/gal (g/cc)	9.77 (1.17)
Hardener	lb/gal (g/cc)	8.14 (0.98)

MECHANICAL PROPERTIES

Property	Standard	Units	72°F (22°C) x 2 wk
Durometer Hardness	ASTM D2240	Type D	90
Compression Yield	ASTM D695	psi (MPa)	13,400 (92)
Tensile Strength	ASTM D638	psi (MPa)	8,840 (61)
Tensile Modulus	ASTM D638	psi (GPa)	5.07E+05 (3.5)
Tensile Elongation	ASTM D638	%	2.6
Flexural Strength	ASTM D790	psi (MPa)	13,900 (96)
Flexural Modulus	ASTM D790	psi (GPa)	4.78E+05 (3.3)

THERMAL PROPERTIES

Property	Standard	Units	72°F (22°C) x 2 wk
Tg DSC Onset–1st Heat	ASTM E1356	°F (°C)	122 (50)
Heat Deflection Temperature	ASTM D648	°F (°C)	117 (47)



[1]To prevent water spotting, avoid contact with moisutre until epoxy is thoroughly cured.

[2]Store PRO-SET® Epoxy resins and hardeners at room temperature in sealed containers until shortly before use. As with many high-performance epoxy resins, repeated exposure to low temperatures during storage may cause the resin to crystallize. If this occurs, warm the resin to 125°F and stir to dissolve crystals. Hardeners may form carbamation when exposed to CO_2 and moisture in the atmosphere for extended periods of time. Prevent carbamation by protecting hardeners from exposure until immediately prior to processing.

Test specimens were neat epoxy (without fiber reinforcement).

Typical values, not to be construed as specification.