

PRO-SET®

Technical Data **LAM-135** **LAM-251-HT**

HIGH-TEMPERATURE LAMINATING EPOXY

The New
Standard

EPOXIES for
Laminating
Infusion
Tooling
Assembly

COMBINED FEATURES

Medium viscosity for good wet out of all synthetic composite fabrics and core materials.

Extra Slow cure speed hardener provides 7 to 8 hours of working time at 77°F (25°C). A typical laminate will be gelled in 12 to 14 hours.

Optimized for hand wet out and machine impregnation in contact molding, vacuum bagging and filament winding applications.

Elevated temperature cure is required; thermal and mechanical properties suitable for composite components and high-temperature tooling and molds.

T_g as high as 286°F (141°C) with proper post cure providing excellent temperature stability and great part cosmetics.

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

Quality-control tinting is available at no extra charge; simply add "QC" after the product code on your order.

Shelf life is 3 years for resin and 18 months for hardener when properly stored³.

HANDLING PROPERTIES

| Property | Standard | Units | 72°F (22°C) | 77°F (25°C) | 85°F (29°C) |
|----------------------|------------|---------|-------------|-------------|-------------|
| 150g Pot Life | ASTM D2471 | minutes | 225-277 | 187-229 | 129-159 |
| 500g Pot Life | ASTM D2471 | minutes | 150-184 | 128-158 | 89-109 |
| Viscosity Mixed | ASTM D2196 | cP | 2955 | 2231 | 1523 |
| Viscosity (resin) | ASTM D2196 | cP | 6890 | | |
| Viscosity (hardener) | ASTM D2196 | cP | 121 | | |

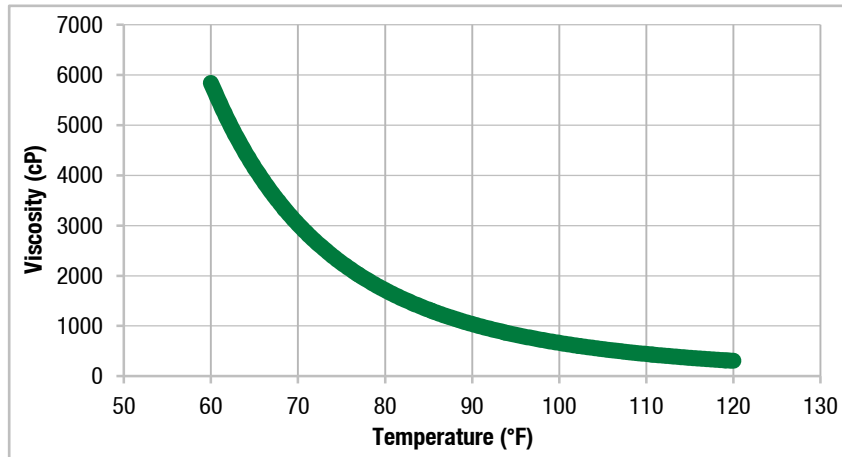
MIX RATIO

| Method | Resin:Hardener | Resin:Hardener |
|--------------|----------------|-------------------|
| Weight | 3.7:1 | 100:27.0 |
| Weight Range | 3.35:1-4.02:1 | 100:29.9-100:24.9 |
| Volume | 3.00:1 | 100:33.3 |
| Volume Range | 2.71:1-3.25:1 | 100:36.9-100:30.8 |

DENSITY

| State | Units | 72°F (22°C) |
|----------|---------------|-------------|
| Cured | lb/gal (g/cc) | 9.53 (1.14) |
| Resin | lb/gal (g/cc) | 9.71 (1.16) |
| Hardener | lb/gal (g/cc) | 9.53 (1.14) |

VISCOSITY VS TEMPERATURE



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

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

ISO9001:2015 Certified

Rev 3 / Dec 2015

LAM-135~LAM-251-HT

HIGH-TEMPERATURE LAMINATING EPOXY

MECHANICAL PROPERTIES

| Property | Standard | Units | 140°F (60°C) x 8 hrs | 250°F (121°C) x 8 hrs |
|--------------------|------------|-----------|-------------------------|--------------------------|
| Hardness | ASTM D2240 | Type D | 88 | 89 |
| Compression Yield | ASTM D695 | psi (MPa) | 16,000 (110) | 17,000 (117) |
| Tensile Strength | ASTM D638 | psi (MPa) | 9,240 (64) | 10,800 (74) |
| Tensile Modulus | ASTM D638 | psi (GPa) | 5.09E+5 (3.51) | 4.06E+5 (2.8) |
| Tensile Elongation | ASTM D638 | % | 2.1 | 5.0 |
| Flexural Strength | ASTM D790 | psi (MPa) | 15,400 (106) | 18,700 (129) |
| Flexural Modulus | ASTM D790 | psi (GPa) | 5.11E+5 (3.52) | 4.07E+5 (2.81) |

THERMAL PROPERTIES

| Property | Standard | Units | 140°F (60°C) x 8 hrs | 250°F (121°C) x 8 hrs |
|------------------------------|-------------------------|---------|-------------------------|--------------------------|
| Tg DMA Peak Tan Delta | ASTM E1640 ¹ | °F (°C) | 225 (107) | 311 (155) |
| Tg DMA Onset Storage Modulus | ASTM E1640 ¹ | °F (°C) | 189 (87) | 286 (141) |
| Tg DSC Onset– 1st Heat | ASTM E1356 | °F (°C) | 173 (78) | 253 (123) |
| Heat Deflection Temperature | ASTM D648 | °F (°C) | 171 (77) | 267 (131) |
| Tg DSC Ultimate | ASTM E1356 | °F (°C) | 269 (131) ² | |

¹ 1 Hz, 3°C per minute.

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

³ 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 CO₂ and moisture in the atmosphere for extended periods of time. Prevent carbamation by protecting hardeners from exposure until immediately prior to processing.

Rev 3 / Dec 2015

135.02
251-HT.02