



Technical Data

M1005~M2005

HIGH-FLOW EPOXY ADHESIVE

The New Standard

EPOXIES for
Laminating
Infusion
Tooling
Assembly

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ISO9001:2008 Certified

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COMBINED FEATURES

Shear thinning resins and hardeners are thixotropic gels. Will flow and efficiently wet-out the substrate but will resist sagging out of crack or injection point. The material wets out the substrate, making priming or pre-wetting unnecessary on most surfaces, while ensuring a good bond.

Pre-thickened two-part epoxy for injection into stable cracks in concrete and masonry structures.

Translucent green color when mixed to ensure proper metering and mixing.

Fast cure speed hardener provides approximately 2 hours of working time at 72°F (22°C) with 1/16" glue line.

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

High-performance pre-thickened, two-part epoxy adhesives for secondary bonding of laminated composites, steel, aluminum, cast iron, concrete, stone, and most wood species. PRO-SET Adhesives will bond these materials, to one another in any combination.

Shelf life is 18 months for resin and 18 months for hardener when properly stored¹.

HANDLING PROPERTIES

Property	Standard	Units	72°F (22°C)
100g Pot Life	ASTM D2471	minutes	27-33

MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	2.20:1	100:45.5
Volume	2.00:1	100:50.0

DENSITY

State	Units	72°F (22°C)
Mixed	lb/gal (g/cc)	9.7 (1.16)

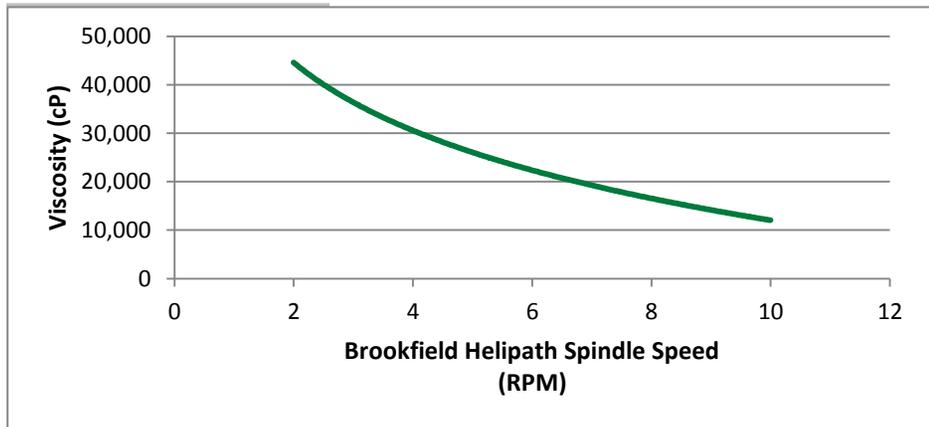
MECHANICAL PROPERTIES

Property	Standard	Units	72°F (22°C) x 2 wk
Compression Yield	ASTM D695	psi (MPa)	11,900 (82)
Tensile Strength	ASTM D638	psi (MPa)	7,230 (50)
Tensile Elongation	ASTM D638	%	3.5
Flexural Strength	ASTM D790	psi (MPa)	11,900 (82)

THERMAL PROPERTIES

Property	Standard	Units	72°F (22°C) x 2 wk
Tg DSC Onset-1st Heat	ASTM E1356	°F (°C)	126 (52)

MIXED SHEAR VISCOSITY



¹ 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.

Test specimens were neat epoxy (without fiber reinforcement) tested after 2 weeks of room temperature curing. Typical values, not to be construed as specification.