



## Technical Data

# M1047 M2053

## CLEAR CASTING EPOXY

The New Standard

EPOXIES for  
Laminating  
Infusion  
Tooling  
Assembly

### COMBINED FEATURES

**Fomulated for use** in pouring thick, clear castings of epoxy into wood cavities.

**Ideal for clear, decorative castings**, filling large voids and thick coatings.

**Slow cure speed** hardener allows additional pours to be applied between 2 and 4 hours at 72°F (22°C) without any surface preparation.

**Cast up to 2" deep** and retain clarity with slight amber tone. If poured into cracks in wood, the wood should be sealed first to prevent bubbles.

**Bubble free coating** can be acheived by quickly passing a propane torch or a light mist of denatured alcohol.

**Clear system** for a transparent, thick casting.

**Shelf life** is 3 years for resin and 2 years for hardener when properly stored<sup>1</sup>.

### HANDLING PROPERTIES

Property	Standard	Units	72°F (22°C)
Peak Exotherm- 1 Inch Cube	-	°F (°C)	115 (46)
Time to Peak Temperature		Minutes	70
Peak Exotherm- 2 Inch Cube	-	°F (°C)	280 (138)
Time to Peak Temperature		Minutes	40
Viscosity Mixed	ASTM D2196	cP	2,000
Viscosity (resin)	ASTM D2196	cP	8,400
Viscosity (hardener)	ASTM D2196	cP	800

### MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	1.20:1	100:83.0
Volume	1.00:1	100:100.0

### DENSITY

State	Temperature	Units	72°F (22°C)
Cured	72°F (22°C)	lb/gal (g/cc)	9.2 (1.1)
Resin	72°F (22°C)	lb/gal (g/cc)	9.68 (1.16)
Hardener	72°F (22°C)	lb/gal (g/cc)	7.93 (0.95)

### THERMAL PROPERTIES

Measurement	Units	
Ultimate Tg via DSC	°F (°C)	100 (38)

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ISO9001:2008 Certified

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<sup>1</sup> 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<sub>2</sub> and moisture in the atmosphere for extended periods of time. Prevent carbamation by protecting hardeners from exposure until immediately prior to processing.

