

PRO-SET®

Technical Data **SBE-166** **SBE-265**

The New
Standard

ABSOLUTE CLEAR **SURFBOARD EPOXY - SLOW**

EPOXIES for
Laminating
Infusion
Tooling
Assembly

COMBINED FEATURES

Formulated for high-volume production of surfboards, SUPs and other boardsport products requiring a clear, colorless finish over dark surfaces.

Slow cure speed for fill coating, laminating and potting. Slow hardener provides a flip time of approximately 4 hours at 72°F (22°C) which may be accelerated with SBE-460 Accelerator at a maximum loading of 3% by weight. (For faster cure speeds use SBE 262 Fast Hardener.)

Easy processing for hand wet out of lightweight fiberglass. Provides extremely smooth surface when cured¹. Excellent sandability. Reaches full physical properties at room temperature cure.

Optical brightener-free for colorless clarity over dark surfaces.

Shelf life is 3 years for resin and 2 years for hardener when properly stored².

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ISO9001:2015 Certified

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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
+ 3% SBE-460			7-9	6-8	4-6
500g Pot Life	ASTM D2471	minutes	26-32	21-27	16-20
+ 3% SBE-460			7-9	6-8	4-5
Viscosity Mixed	ASTM D2196	cP	1,054	878	661

MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	2.38:1	100:42.0
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—2.27:1	100:51.1—100:44.1

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)

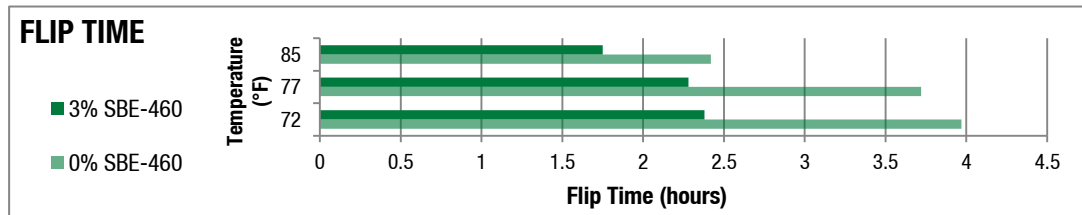
MECHANICAL PROPERTIES

Property	Standard	Units	72°F (22°C) x 2 wk
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 (MPa)	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 (MPa)	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)

FLIP TIME



¹To prevent water spotting, avoid contact with moisture until epoxy is thoroughly cured.

²Store 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).

Typical values, not to be construed as specification.