

## Technical Data

# INF-114

# INF-211

## INFUSION EPOXY

### COMBINED FEATURES

**Very low viscosity** for rapid saturation of fiberglass, Kevlar® and carbon fiber laminate with resin infusion and VARTM processes.

**Medium cure speed** hardener provides 3 to 4 hours working time at 77°F (25°C). A typical laminate will be gelled in 8 hours.

**This combination** is formulated specifically for resin infusion and VARTM processes. Do not use in open mold applications.

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

**Tg as high as 196° F (91°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 2 years for hardener when properly stored<sup>3</sup>.

### HANDLING PROPERTIES

Property	Standard	Units	72°F (22°C)	77°F (25°C)	85°F (29°C)
150g Pot Life	ASTM D2471	minutes	131	122	72
500g Pot Life	ASTM D2471	minutes	101	85	63
Viscosity Mixed	ASTM D2196	cP	296	245	196
Viscosity (resin)	ASTM D2196	cP	1433		
Viscosity (hardener)	ASTM D2196	cP	14		

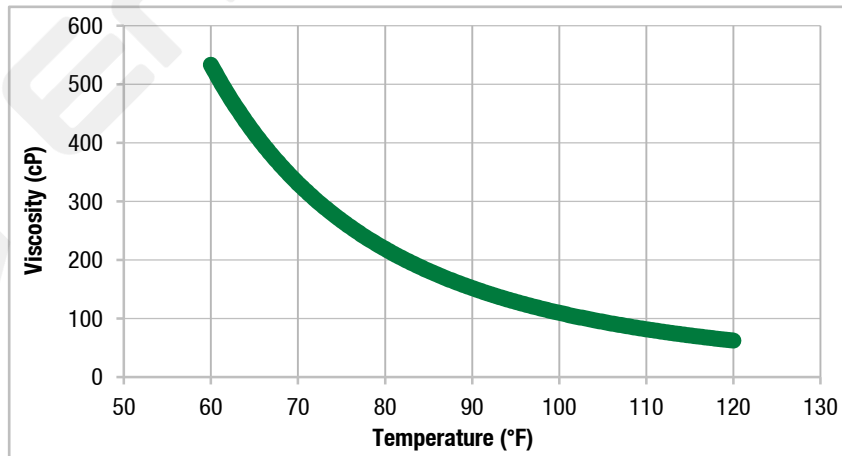
### MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	3.65:1	100:27.4
Weight Range	3.81:1–3.45:1	100:26.3–100:29.0
Volume	3.00:1	100:33.3
Volume Range	3.13:1–2.84:1	100:31.9–100:35.3

### DENSITY

State	Units	72°F (22°C)
Cured	lb/gal (g/cc)	9.5 (1.14)
Resin	lb/gal (g/cc)	9.5 (1.14)
Hardener	lb/gal (g/cc)	7.8 (0.93)

### VISCOSITY VS TEMPERATURE



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

The New  
Standard

EPOXIES for  
Laminating  
Infusion  
Tooling  
Assembly

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

ISO9001:2008 Certified

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## INFUSION EPOXY

### MECHANICAL PROPERTIES

Property	Standard	Units	72°F (22°C) x 4 wk	77°F (25°C) x 2 wk	RT Gelation + 120°F (49°C) x 8 hrs	RT Gelation + 140°F (60°C) x 8 hrs	RT Gelation + 180°F (82°C) x 8 hrs
Hardness	ASTM D2240	Type D	86	86	85	85	85
Compression Yield	ASTM D695	psi (MPa)	14,700 (101)	15,300 (105)	13,700 (94)	13,700 (94)	13,700 (94)
Tensile Strength	ASTM D638	psi (MPa)	7,770 (54)	8,540 (59)	9,540 (66)	9,820 (68)	10,100 (70)
Tensile Modulus	ASTM D638	psi (GPa)	5.24E+5 (3.61)	5.34E+5 (3.68)	5.35E+05 (3.69)	5.11E+05 (3.52)	4.87E+05 (3.36)
Tensile Elongation	ASTM D638	%	1.7	2.0	2.6	3.9	5.3
Flexural Strength	ASTM D790	psi (MPa)	12,300 (85)	15,000 (103)	17,100 (118)	17,600 (121)	18,200 (125)
Flexural Modulus	ASTM D790	psi (GPa)	4.85E+5 (3.34)	4.83E+5 (3.33)	4.97E+05 (3.43)	4.95E+05 (3.41)	4.64E+05 (3.2)

### THERMAL PROPERTIES

Property	Standard	Units	72°F (22°C) x 4 wk	77°F (25°C) x 2 wk	RT Gelation + 120°F (49°C) x 8 hrs	RT Gelation + 140°F (60°C) x 8 hrs	RT Gelation + 180°F (82°C) x 8 hrs
Tg DMA Peak Tan Delta	ASTM E1640 <sup>1</sup>	°F (°C)	158 (70)	157 (70)	176 (80)	195 (91)	215 (102)
Tg DMA Onset Storage Modulus	ASTM E1640 <sup>1</sup>	°F (°C)	145 (63)	145 (63)	157 (69)	176 (80)	196 (91)
Tg DSC Onset– 1st Heat	ASTM E1356	°F (°C)	138 (59)	138 (59)	151 (66)	165 (74)	177 (81)
Heat Deflection Temperature	ASTM D648	°F (°C)	129 (54)	131 (55)	144 (62)	160 (71)	173 (78)
Tg DSC Ultimate	ASTM E1356	°F (°C)			185 (85) <sup>2</sup>		

<sup>1</sup> 1 Hz, 3°C per minute.

<sup>2</sup> Additional post cure may be required; contact Technical Department for details.

<sup>3</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.

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