PRO-SET®

Technical Data
TLG-625-R
TLG-625-H

FAIRING PUTTY EPOXY

The New Standard

EPOXIES for Laminating Infusion Tooling Assembly

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ISO9001:2015 Certified

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COMBINED FEATURES

Low density epoxy fairing putty is designed for filling and fairing applications in custom building or repair situations.

Pre-thickened system to allow for easier mixing and smooth spreading. It is not necessary to add fillers to this combination.

Medium cure speed hardener provides approximately 90 minutes of working time at 72°F (22°C).

Coverage one mixed gallon covers 6.4 square feet at 0.25" thickness.

Low shrinkage epoxy chemistry allows for applications up to 0.50" thick. Additional application necessary to fill deeper voids.

Easy to sand low density epoxy can easily be sanded to achieve a desired contour.

Room temperature cure properties suitable for many composite plugs and molds.

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

Shelf life is 18 months for resin and 18 months for hardener when properly stored[1].

HANDLING PROPERTIES

Property	Standard	Units	65°F (18°C)	72°F (22°C)	85°F (29°C)
100 ml Pot Life	ASTM D2471	minutes	76-94	31-39	27-33
500 ml Pot Life	ASTM D2471	minutes	54-66	27-33	24-30
Viscosity (Mixed)	ASTM D2196	cP	Paste	Paste	Paste

MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	1.79:1	100:55.9
Volume	1:1	100:100

DENSITY

State	Units	72°F (22°C)
Mixed	lb/gal (g/cc)	5.26 (.64)

APPLICATION PROPERTIES

Property	Temperature	Units	Value
Cure time to sand in .25" thickness	72°F (21°C)	hours	8
	90°F (32°C)	hours	4

MECHANICAL PROPERTIES

Property	Standard	Units	77°F (25°C) x 2 wk
Hardness	ASTM D2240	Type D	62
Compression Yield	ASTM D695	psi (MPa)	3,334 (23)

THERMAL PROPERTIES

Property	Standard	Units	77°F (25°C) x 2 wk
Heat Deflection Temperature	ASTM E1357	°F (°C)	117 (47)

MIXING RECOMMENDATIONS

Mixing of Fairing Putty Epoxy requires a folding motion on a flat surface due to the paste-like consistency. If mixing by hand, allow 10 minute induction time for thixotropic recovery before application. Ensure there are no streaks of color when applying, this is a sign of inadequate mixing. Mix only as much as can be applied within the pot life of the mixture.

Some separation may occur during storage. Stir resin and hardener individually

[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 CO^2 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.