



PRODUCT DATA

13202 Epoxy Resin System

2 Part Press Molding Epoxy Resin System

Part No: 100229210 (A) / 100229210 (B)

DESCRIPTION

ProGlas 13202 Epoxy Resin (Part A -100150202) with Hardener (Part B - 100229210) is a rapid setting, thixotropic, general purpose epoxy resin system that may be used in many diverse applications such as laminating, bonding and is excellent for press molding. While cure can be considered complete after 7 days at room temperature, a moderate post cure is required to reach ultimate thermal and mechanical properties. This system exhibits excellent wetout of all composite reinforcements.

HANDLING PROPERTIES

	VALUE	TEST METHOD
Resin Density at 25°C, lbs/gal	9.8	ASTM D1475
Hardener Density at 25°C, lbs/gal	8.5	ASTM D1475
Resin Viscosity at 25°C, cP	18,000	ASTM D2196
Hardener Viscosity at 25°C, cP	100	ASTM D2196
Mix Ratio By Weight	5.5A : 1B	Calculated
Mix Ratio By Volume	4.7A : 1B	Calculated
Initial Mixed Viscosity at 25°C, cP	3,500	ASTM D2196
Gel Time at 25°C, 150g mass, min.	14	ASTM D2471

PHYSICAL PROPERTIES

	VALUE	TEST METHOD
Appearance	Amber	Visual
Izod Impact, Notched, ft-lb/in	0.68	ASTM D256
Tensile Strength, psi	9,800	ASTM D638
Tensile Modulus, psi	481,000	ASTM D638
Tensile Elongation, %	8.2	ASTM D638
HDT, Room Temperature Cure, °F	136	ASTM D648
HDT, Post Cure, °F	227	ASTM D648
Compressive Strength, psi	13,300	ASTM D695
Flexural Strength, psi	17,700	ASTM D790
Flexural Modulus, psi	506,000	ASTM D790
Density, Cured, g/cm3 (lbs/in3)	1.10 (0.04)	ASTM D792
Volumetric Yield, in3/lb	25.3	ASTM D792
Volumetric Shrinkage, %	4.8	ASTM D792/D1475
Hardness, Shore D	85	ASTM D2240

SYSTEM POST CURE OPTIONS:

Select one of the following cure schedules depending on the available time, the physical properties of the master and the desired physical properties of the final part. Post cure the structure to obtain maximum physical properties from the system. Please contact technical service if you find it necessary to have a different post cure schedule.

CURE INCREMENTS:

	OPTION 1	OPTION 2
24 hrs. at 77°F (25°C)	X (S)	X (S)
*7 days at 77°F (25°C)	X (U)	
4 hrs. at 150°F (66°C)		X (U)

*For full cure at room temperature
S = Supported U = Unsupported

TOOL, MOLD AND/OR PATTERN PREPARATION:

Wood structures should be sealed. Gypsum molds should be dried to remove free moisture and preferably sealed with the PFP process or appropriate sealer. All non-porous tools, molds or patterns should be treated with release or parting agents, which can withstand the temperature that the part will be cured at while remaining in a supported position.

The conditions for your use and application of our products, technical assistance and information (whether verbal, written or by way of production evaluations), including any suggested formulations and recommendations, are beyond our control. Therefore, it is imperative that you test our products, technical assistance and information to determine to your own satisfaction whether they are suitable for your intended uses and applications. This application-specific analysis at least must include testing to determine suitability from a technical as well as health, safety, and environmental standpoint. FIBERLAY, INC. has not necessarily done such testing. All information is given without warranty or guarantee. It is expressly understood and agreed that customer assumes and hereby expressly releases FIBERLAY, INC. from all liability, in tort, contract or otherwise, incurred in connection with the use of our products, technical assistance and information. Any statement or recommendation not contained herein is unauthorized and shall not bind FIBERLAY, INC. Nothing herein shall be construed as a recommendation to use any product in conflict with patents covering any material or its use. No license is implied or in fact granted under the claims of any patent. November 12, 2010.



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STORAGE AND HANDLING:

Store at 60-100°F in a dry place. After use, tightly reseal. (This product may crystallize during storage. If crystallized, vent container and heat to 125-145°F until crystal dissolve. Stir well after product has liquefied.) Always use clean dry tools for mixing and applying. Mix according to the mix ratio stated for the specific product as listed on the front page. Mix together thoroughly and use immediately. Material temperatures should not be below 65°F when mixing.

SAFETY HANDLING:

Work in well ventilated areas using gloves, eye protection and clothing protection. Avoid contact to the skin and eyes. Avoid clothing contamination. Wash thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult Material Safety Data Sheets for complete precautions with this product.

ProGlas has experience only in the compounding of resins and hardeners and not in the actual manufacture of tools or parts. Each piece is different. The user should run tests to assure the suitability of the system for use in a particular application. The test data and results set forth herein are based on laboratory work and do not necessarily indicate the results that the buyer or user will attain.