



# High Bio-Based Laminating System

High Bio-Based content Epoxy Resin for general laminations and coatings.

## Product Overview

ONE is a general purpose laminating resin with high bio-based content for composite laminating, coating, and adhesive applications. This system features a faster speed, low viscosity and includes quick air-releasing properties ideal for fiber-reinforced composite laminations and coatings.

ONF  
FAST

ONS  
SLOW

### MECHANICAL DATA

	ONF FAST	ONS SLOW
<b>Tensile Modulus</b> (ASTM D638)	385,000 psi (2.7 GPa)	468,000 psi (3.2 GPa)
<b>Tensile Strength</b> (ASTM D638)	7,720 psi (53.2 MPa)	9,800 psi (67.6 MPa)
<b>Elongation</b> (ASTM D638)	6%	6%
<b>Flexural Modulus</b> (ASTM D790)	362,000 psi ( 2.5 GPa)	430,000 psi (3.0 GPa)
<b>Flexural Strength</b> (ASTM D790)	11,910 psi (82.1 MPa)	14,580 psi (100.5 MPa)
<b>Compression Strength</b> (ASTM D695)	11,300 psi (77.9 Mpa)	12,520 psi (86.3 MPa)
<b>Tg Ultimate</b> (DSC, midpoint)	146°F/63°C	128°F/53°C
<b>Hardness</b> (Shore D)	70-80	70-80

### PROCESSING DATA

	ONF FAST	ONS SLOW
<b>Mix Ratio</b> (by volume)	2:1	2:1
<b>Mix Ratio</b> (by weight)	100:43	100:43
<b>Viscosity</b> (A/B/Mixed @ 77°F/25°C)	1870/120/1020	1870/140/1060
<b>Component Density</b> (specific density @ 77°F/25°C)	1.14 (resin), 0.98 (hardener)	1.14 (resin), 0.98 (hardener)
<b>Mixed Density</b> (specific density @ 77°F/25°C)	1.09	1.08
<b>Pot Life</b> (@ 77°F/25°C)	18 min	43 min
<b>Tack Free Time</b> (@ 95°F/35°C)	3 hrs	8 hrs
<b>Recommended Full Cure</b>	7 days @ 77°F/25°C	7 days @ 77°F/25°C Post cure recommended

### ENVIRONMENT DATA

	ONF FAST	ONS SLOW
<b>VOC Content</b> (ASTM D2369)	0.17 lbs/gal (21 g/L)	0.14 lbs/gal (16.3 g/L)
<b>Biobased Carbon Content</b> (ASTM D6866)	30%	29%

This technical information is provided in good faith and is based on the best knowledge of Gougeon Brothers, Inc. We cannot guarantee this data because conditions of product use are beyond our control.  
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