

PRO-SET®

Technical Data **LAM-151-HT** **LAM-251-HT**

LAMINATING EPOXY

COMBINED FEATURES

High temperature, high performance epoxy formulation for synthetic composite mold and tooling manufacture.

T_g as high as 350°F (176°C) with proper post cure providing excellent temperature stability and great part cosmetics.

Medium viscosity for wet out of synthetic composite fabrics; especially effective with carbon fiber.

Extra slow cure speed hardener provides 8 to 10 hours of working time at 77°F (25°C). A typical laminate will be gelled in 14 to 20 hours at room temperature.

Optimized for hand wet out and machine impregnation in contact molding, wet vacuum bagging and Light RTM applications.

Elevated temperature cure is required; thermal and mechanical properties suitable for composite components and high temperature tooling and molds.

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 18 months for hardener when properly stored³.

HANDLING PROPERTIES

Property	Standard	Units	72°F (22°C)	77°F (25°C)	85°F (29°C)
150g Pot Life	ASTM D2471	minutes	358-438	263-323	192-236
500g Pot Life	ASTM D2471	minutes	276-338	211-259	138-170
Viscosity Mixed	ASTM D2196	cP	1885	1508	1046
Viscosity (resin)	ASTM D2196	cP	6300		
Viscosity (hardener)	ASTM D2196	cP	121		

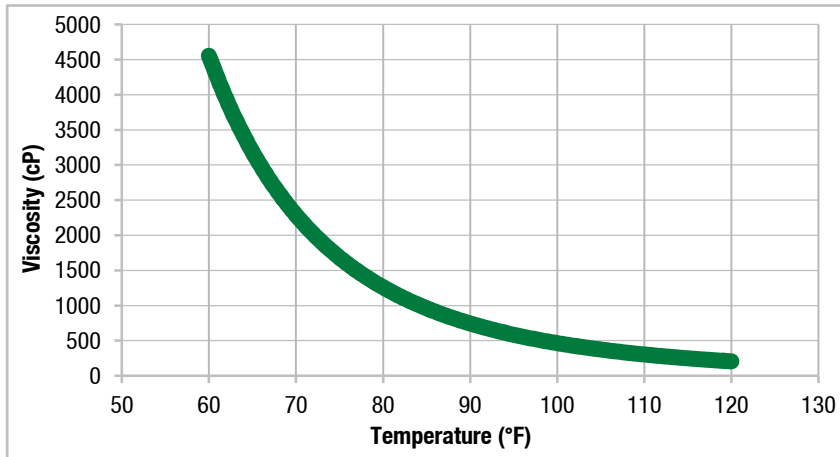
MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	3.5:1	100:28.6
Weight Range	3.75:1-3.30:1	100:26.6-100:30.3
Volume	3.00:1	100:33.3
Volume Range	3.14:1-2.75:1	100:31.9-100:36.3

DENSITY

State	Units	72°F (22°C)
Cured	lb/gal (g/cc)	9.45 (1.13)
Resin	lb/gal (g/cc)	9.69 (1.16)
Hardener	lb/gal (g/cc)	7.86 (0.94)

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

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ISO9001:2008 Certified

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MECHANICAL PROPERTIES

Property	Standard	Units	200°F (93°C) x 12 hrs	250°F (121°C) x 8 hrs	140°F (60°C) x 2 hrs + 302°F (150°C) x 4 hrs
Hardness	ASTM D2240	Type D	89	90	87
Compression Yield	ASTM D695	psi (MPa)	16,600 (114)	16,700 (115)	16,300 (112)
Tensile Strength	ASTM D638	psi (MPa)	12,500 (86)	10,800 (74)	9,240 (64)
Tensile Modulus	ASTM D638	psi (GPa)	4.75E+05 (3.28)	4.56E+05 (3.14)	4.14E+05 (2.85)
Tensile Elongation	ASTM D638	%	5.5	3.9	3.8
Flexural Strength	ASTM D790	psi (MPa)	21,400 (148)	18,800 (130)	15,200 (105)
Flexural Modulus	ASTM D790	psi (GPa)	4.43E+05 (3.05)	4.10E+05 (2.83)	3.84E+05 (2.65)

THERMAL PROPERTIES

Property	Standard	Units	200°F (93°C) x 12 hrs	250°F (121°C) x 8 hrs	140°F (60°C) x 2 hrs + 302°F (150°C) x 4 hrs
Tg DMA Peak Tan Delta	ASTM E1640 ¹	°F (°C)	281 (138)	303 (151)	357 (181)
Tg DMA Onset Storage Modulus	ASTM E1640 ¹	°F (°C)	250 (121)	286 (141)	328 (164)
Tg DSC Onset– 1st Heat	ASTM E1356	°F (°C)	252 (122)	277 (136)	339 (171)
Heat Deflection Temperature	ASTM D648	°F (°C)	251 (122)	282 (139)	324 (162)
Tg DSC Ultimate	ASTM E1356	°F (°C)		346 (175) ²	

¹ 1 Hz, 3°C per minute.

² Additional post cure may be required; contact Technical Department for details.

³ 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 CO₂ and moisture in the atmosphere for extended periods of time. Prevent carbamation by protecting hardeners from exposure until immediately prior to processing.

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