

PRO-SET®

Technical Data

ADV-176

ADV-276

SUPER-TOUGHENED ADHESIVE EPOXY

COMBINED FEATURES

Shear thinning resins and hardeners are thixotropic gels. The mixture fills gaps and will not sag on vertical surfaces. The material wets out the substrate, making priming or pre-wetting unnecessary on most surfaces, while ensuring a good bond.

Medium cure speed hardener provides approximately 90 minutes of working time at 22°C. A bead will gel in 10 to 11 hours.

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

High performance pre-thickened, two-part epoxy adhesive delivers toughness and superior peel strength for heavily loaded applications and difficult to bond substrates including pre-preg, SMC, metals and most plastics. Also for secondary bonding of laminated composites, steel, aluminum, cast iron, concrete, stone, and most wood species. PRO-SET Adhesives bond these materials in any combination.

Coverage one cartridge set dispenses approximately 14m of 6mm bead, or 5m of 12.7mm bead and will cover approximately 0.65m² when spread with a 3mm x 3mm notched spreader, or 1m² with a 1.5mm x 1.5mm notched spreader.

HANDLING PROPERTIES

Property	Standard	Units	22°C
100g Pot Life	ASTM D2471	minutes	45
Working Time (12.7mm bead)	ASTM D2471	minutes	90
Minimum Cure Temperature	ASTM D2196	°C	15
Clamps off cure time (1.5mm bond line)		hours	10
Minimum Storage Temperature		°C	15

MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	2.22:1	100:45.5
Volume	2.00:1	100:50.0

DENSITY

State	Units	22°C
Resin	gcm ⁻³	1.17
Hardener	gcm ⁻³	1.05
Mixed	gcm ⁻³	1.10

MECHANICAL PROPERTIES

Property	Standard	Units	22°C x 2 Weeks
Hardness	ASTM D2240	Shore D	73 (after 1 day)
Hardness	ASTM D2240	Shore D	79
Compression Yield	ASTM D695	MPa	58.56
Tensile Strength	ASTM D638	MPa	35.05
Tensile Modulus	ASTM D638	GPa	2.0
Tensile Elongation	ASTM D638	%	4.3
Flexural Strength	ASTM D790	MPa	89.52
Flexural Modulus	ASTM D790	GPa	1.86
Lap Shear on 1018 Steel	ASTM D1002	MPa	19.85
Lap Shear on 2024T Aluminium	ASTM D1002	MPa	19.74
Tensile Adhesion to 1018 Steel	ASTM D4541	MPa	29.62
Tensile Adhesion to 2024T Aluminium	ASTM D4541	MPa	23.54
Izod Impact, notched	ASTM-256	J/m	77.96

THERMAL PROPERTIES

Property	Standard	Units	22°C x 2 Weeks
Tg DMA Peak Tan Delta	ASTM E1640*1	°C	78.6
Tg DSC Onset - 1st Heat	ASTM E1356	°C	58.2
Tg DSC Ultimate	ASTM E1356	°C	69.7*2
Heat Deflection Temperature	ASTM D648	°C	48

*1 1Hz, 3°C per minute.

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

Test specimens were neat epoxy (without fibre reinforcement).

These are typical properties and cannot be construed as a specification. The end users should test the products to ensure the products are suitable for the intended application. Any information, data, advice or recommendation published by Wessex Resins or obtained from Wessex Resins by other means and whether relating to Wessex Resins' materials or other materials, is given in good faith and believed to be reliable.

The New
Standard

EPOXIES for
Laminating
Infusion
Tooling
Assembly

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& Adhesives

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