

# PRO-SET®

## Technical Data

# ACE-166

# ACE-265

## ABSOLUTE CLEAR CLEAR COATING EPOXY - SLOW

The New  
Standard

EPOXIES for  
Laminating  
Infusion  
Tooling  
Assembly

### Wessex Resins & Adhesives

Cupernham House  
Cupernham Lane  
Romsey, Hampshire  
SO51 7LF, UK  
pro-set.co.uk  
+44(0)1794 521111

ISO9001:2015 Certified

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& Adhesives

### COMBINED FEATURES

**Formulated for extremely clear coatings and laminations** with carbon and other reinforcement fibres. Commonly used for clear coatings on wood, surfboard laminations and other boardsport products in a production setting. Provides colourless clarity and UV stability. For ultimate long-term UV stability, use with a UV stable topcoat.

**Slow cure speed** for fill coating, laminating and potting. Slow hardener provides a tack-free cure time of approximately 4 hours at 22°C.

**Easy processing.** Optimised for fill coats and hand wet out of lightweight reinforcement fabrics or fibres. Provides an extremely smooth surface when cured. Excellent sandability. Reaches full physical properties at room temperature cure.

### HANDLING PROPERTIES

Property	Standard	Units	22°C	25°C	29°C
150g Pot Life	ASTM D2471	minutes	26-33	24-30	16-20
500g Pot Life	ASTM D2471	minutes	36-32	21-27	16-20
Viscosity Mixed	ASTM D2196	mPas	1054	878	661

### MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	2.39:1	100:41.9
Volume	2.00:1	100:50.0

### DENSITY

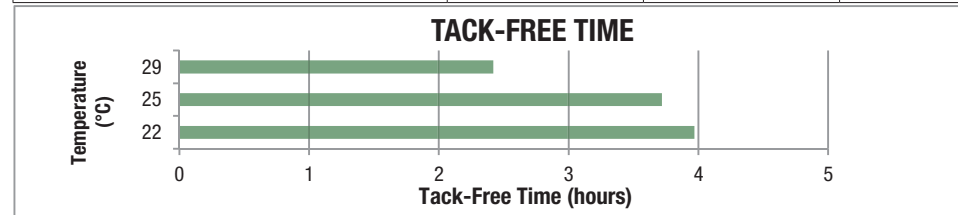
State	Units	22°C
Cured	gcm <sup>-3</sup>	1.15
Resin	gcm <sup>-3</sup>	1.17
Hardener	gcm <sup>-3</sup>	0.98

### MECHANICAL PROPERTIES

Property	Standard	Units	22°C x 2 weeks
Hardness	ASTM D2240	Shore D	90
Compression Yield	ASTM D695	MPa	92
Tensile Strength	ASTM D638	MPa	61
Tensile Modulus	ASTM D638	GPa	3.5
Tensile Elongation	ASTM D638	%	2.6
Flexural Strength	ASTM D790	MPa	96
Flexural Modulus	ASTM D790	GPa	3.3

### THERMAL PROPERTIES

Property	Standard	Units	22°C x 2 weeks
Tg DSC Onset - 1st Heat	ASTM E1356	°C	50
Heat Deflection Temperature	ASTM D648	°C	47



To prevent water spotting, avoid contact with moisture until epoxy is thoroughly cured and top coated. 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 crystallise. If this occurs, warm the resin to 50°C and stir to dissolve crystals. Hardeners may form carbamation when exposed to CO<sub>2</sub> 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 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.