



# Laminating Epoxy Resin

## General Information and Usage

This 2:1 epoxy is a versatile resin that can be used for joints, fillets, glass fabric saturation and clear coating. This is a low-odour epoxy containing no solvents.

It has a slow initial cure time that makes it ideal for unpractised workers. It does not rely on solvents for treating the surface or softening for further coats, thus it is perfect for the amateur builder whose workplace is within close proximity of a living area.

Mix ratio by volume	2:1 (Resin:Activator)
Mix ratio by weight	100:46 (Resin:Activator)
Pot life of 0.5 kg mass at 25°C	approximately 45 minutes
Recoat without sanding at 25°C	between approximately 3-10 hours
Recommended full cure	7 days at 25°C
Shelf life	12 months
Viscosity (resin) at 25°C	2 Pa·s (2000 cP)
Viscosity (activator) at 25°C	0.06 Pa·s (60 cP)
Viscosity (mixed) at 25°C	0.4 Pa·s (400 cP)
Optimal working temperature	15 – 30 °C
Extended working temperature	10 – 35 °C
Coverage (non-porous surface)	approximately 5.4 m <sup>2</sup> /litre

This epoxy must be applied at a temperature greater than 10° C to ensure a proper cure. Cure time may be accelerated by mild heat up to 82° C. Pre-heating the epoxy to 28° C can also improve the penetration into porous substrates such as wood.

## Mechanical Properties of Fully-Cured Epoxy

Tensile strength	65 MPa (9400 psi)
Tensile modulus	2800 MPa (406000 psi)
Tensile elongation	5%
Flexural strength	100 MPa (14500 psi)
Flexural modulus	2950 MPa (428000 psi)
Hardness (Shore D)	75-80

## Use of Solvents and Cleaning Brushes

**Do not use any solvents** to thin the epoxy. Do not use solvents to clean brushes, pots or trays or to prepare a surface for coating with epoxy. Traces of acetone, white spirit or any solvent will prevent the epoxy curing and produce a mottled surface to the coating.

We recommend using disposable brushes and pots. It is safe to use cleaned-out yoghurt pots or similar for this epoxy. Mixing pots can be cleaned with warm water and a little washing up liquid, then rinsed in water.

## Mixing Epoxy

Always wear disposable gloves and eye protection when working with epoxy since the parts contain potentially dangerous chemicals. Any spills of this epoxy can be cleaned using soap and water or vinegar or, better still, an abrasive hand cleaner.

If you are using measuring pumps with your epoxy, make sure they are fitted correctly and primed so that they dispense the correct amount of resin and activator. Follow the instructions that accompany the pumps.

Measure the resin and activator into a mixing pot in the correct ratio (two parts resin to one part activator). Use one depression of each pump if you are using our 2:1 measuring pumps, or you can use a marked dip stick in a straight-sided pot.

Mix the two parts together thoroughly with a stick for 1 minute. Proper mixing is essential: most of the problems associated with using epoxy are the result of not mixing well enough. When you need thickened epoxy, mix in your fillers only after the resin and activator are thoroughly mixed.

Thicken the epoxy with microfibres or silica for laminating wood together.

Thicken the epoxy with microfibres (or silica) and wood flour filleting blend for making fillets.

When wetting out fabric, use unthickened epoxy and ensure that the temperature is constant or falling after application to avoid gas bubbles.

## Use of Epoxy in a Cold Climate

Do not store resin and activator on cold concrete floors – keep them warm. As the resin and activator cool they thicken and become difficult to mix. If cold enough they will go solid. They can be brought back to a usable liquid state by warming the bottles in hot water, but it can take some time; it is easier to keep them warm in the first place. **Never use a naked flame to warm epoxy.**

The mixed epoxy will set at very low temperatures but it may take several days. During this period, glued parts must not be moved nor the coating touched.

Epoxy works best at a temperature between 15° C and 30° C. At temperatures lower than this it will eventually cure but will be very viscous and thus difficult to apply. Your workshop doesn't need to be heated, you just need to keep the resin and activator bottles warm. Keep them near a source of flame-free heat. Alternatively, keep the bottles in a heated or insulated box. Keep them in an airing cupboard or on a radiator when not in use.

It is possible to warm the epoxy once it has been mixed but it is difficult to judge the temperature and often results in the epoxy curing before it can be applied.

Occasionally, an oily or waxy bloom may appear on epoxy that has cured in a cold, damp climate. A bloom is an oily surface to the coating that can be felt even if, by digging a finger nail into the epoxy, it can be established that the epoxy has cured. It must be removed since neither paint, epoxy nor varnish will adhere to it. If a bloom appears, the epoxy must be allowed to harden and then the bloom must be washed off with soap and water. The surface must then be rinsed to remove the soap and finally allowed to dry. The surface will have to be sanded before applying further coats as required.

For further advice on using epoxy visit our website at [www.pecepoxy.co.uk](http://www.pecepoxy.co.uk)