

PRO-SET®

Technical Data

HTP-180

HTP-280

HIGH TEMPERATURE INFUSION EPOXY

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

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

Tg as high as 150°C with proper post cure. Provides excellent temperature stability and great part cosmetics.

Slow cure speed hardener provides 5 to 6 hours of working time at 22°C. A typical laminate will gel in 10 to 12 hours at room temperature.

This combination is specifically formulated for resin infusion and VARTM processes. Not for use in open mould applications.

Elevated temperature cure is required. Parts can be pulled after 24-48 hours at room temperature or sooner after a mild initial cure of 30-40°C. Post cure 60°C x 2hr + 135°C x 12hr, with ramp rates no greater than 15°C/hour, to achieve maximum properties.

HANDLING PROPERTIES

Property	Standard	Units	22°C
150g Pot Life	ASTM D2471	minutes	180
500g Pot Life	ASTM D2471	minutes	120
Viscosity Mixed	ASTM D2196	mPas	600
Viscosity (resin)	ASTM D2196	mPas	2500
Viscosity (hardener)	ASTM D2196	mPas	35

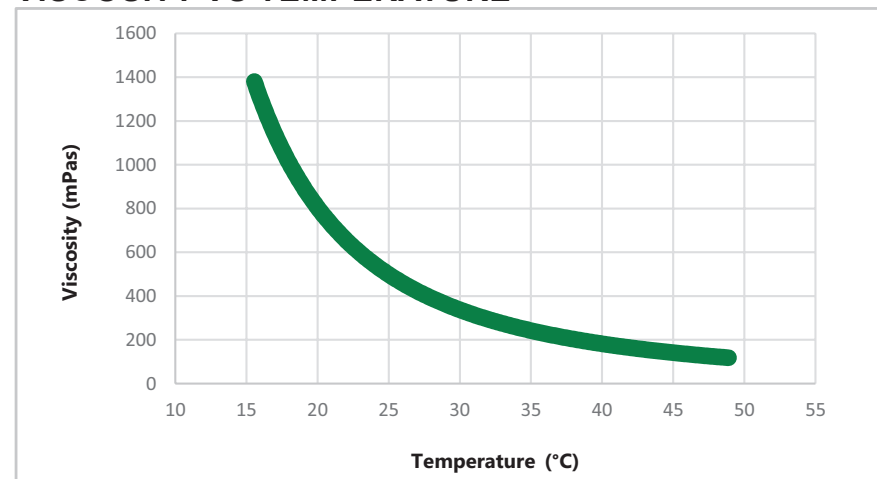
MIX RATIO

Method	Resin:Hardener	Resin:Hardener
Weight	3.70:1	100:27
Volume	3.00:1	100:33.3

DENSITY

State	Units	22°C
Cured	gcm ⁻³	1.15
Resin	gcm ⁻³	1.16
Hardener	gcm ⁻³	0.94

VISCOSITY VS TEMPERATURE



Test specimens were neat epoxy (without fibre reinforcement).
Typical values not to be construed as specification.

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MECHANICAL PROPERTIES

Property	Standard	Units	RT Gelation + (60°Cx 2 hr) + (135°C x 12hr)	
Hardness	ASTM D2240	Shore D	94	
Compression Yield	ASTM D695	MPa	105	
Tensile Strength	ASTM D638	MPa	74	
Tensile Modulus	ASTM D638	GPa	2.99	
Tensile Elongation	ASTM D638	%	5.5	
Flexural Strength	ASTM D790	MPa	123	
Flexural Modulus	ASTM D790	GPa	2.85	
Coefficient of Thermal Expansion	ASTM E831	µm/(m*°C)	93.27	30°C - 130°C

THERMAL PROPERTIES

Property	Standard	Units	RT Gelation + (60°Cx 2 hr) + (135°C x 12hr)	
Tg DMA Peak Tan Delta	ASTM E1640*1	°C	160	
Tg DMA Onset Storage Modulus	ASTM E1640*1	°C	151	
Tg DSC Onset - 1st Heat	ASTM E1356	°C	151	
Heat Deflection Temperature	ASTM E1356	°C	139	

*1 1Hz, 3°C per minute.

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.

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