HIGH Tg PULTRUSION EPOXY – A-30400/B-29000

**Description:**
High Tg Pultrusion Epoxy is a two-component epoxy system. This high-quality thermoset is designed for pultrusion, filament winding and RTM applications. It has low viscosity and fast property development at elevated temperatures. A long pot life allows for preheating to get lower viscosity and better fiber impregnation. High Tg Pultrusion Epoxy has proprietary release properties integrated for improved performance during Pultrusion.

**Handling Properties:**
- **RESIN VISCOSITY, cP:** 7,500 (ASTM D 2196)
- **RESIN DENSITY, lb./gal:** 9.70 (ASTM D 792)
- **HARDENER VISCOSITY, cP:** 150 (ASTM D 2196)
- **HARDENER DENSITY, lb./gal:** 9.80 (ASTM D 792)
- **COLOR:** Green
- **DENSITY, lb./gal:** 9.75 (ASTM D 792)
- **MIX RATIO, pbv (pbw):** 1/1 (1/1)
- **MIXED VISCOSITY, cP:** 860 (ASTM D 2196)
- **GEL TIME (30g @320°F), min:** 7 (ASTM D 2471)
- **WORKING TIME*, hours:** 24+

*The working time varies according to the temperature of the air, the epoxy and the surface to which it is applied.

**Physical Properties:**
- **TENSILE STRENGTH, psi:** 5,700 (ASTM D 638)
- **TENSILE MODULUS, psi:** 119,000 (ASTM D 638)
- **ELONGATION @ BREAK, %:** 1.00 (ASTM D 638)
- **COMPRESSIVE STRENGTH, psi:** 14,300 (ASTM D 695)
- **COMPRESSIVE MODULUS, psi:** 245,000 (ASTM D 695)
- **FLEXURAL STRENGTH, psi:** 14,400 (ASTM D 790)
- **HARDNESS, Shore D:** 90 (ASTM D 2240)

Cure Cycle: 2 hours @ 185°F + 3 hours @300°F. Test specimens for above were neat epoxy (without fiber reinforcement).

**Thermal Properties:**
- **Heat Deflection Temperature, °F (°C):** 258 (125.8) (ASTM D 648)
- **Tg DSC Ultimate, °F (°C):** 272 (133.2) (ASTM D 3418)

Cure Cycle: 2 hours @ 185°F + 3 hours @ 300°F.
Mixing: The storage temperature of High Tg Pultrusion Epoxy will greatly affect the ease of mixing, application and curing time. For best results, High Tg Pultrusion Epoxy should be stored at 60-80 °F (16-27 °C) for at least 24 hours before use. The resin and hardener need to be thoroughly blended to ensure complete dispersion. High Tg Pultrusion Epoxy can be measured by volume or weight using the mix ratios listed under the “Handling Properties” section. REMEMBER - you will have less working time at higher temperatures.

SAFETY PRECAUTIONS

Avoid breathing of vapors. Forced local exhaust is recommended to effectively minimize exposure. NIOSH approved, organic vapor respirators and forced exhaust are recommended in confined areas, or when conditions (such as heated polymers, sanding) may cause high vapor concentrations. **DO NOT WELD ON, BURN OR TORCH ON OR NEAR, ANY EPOXY MATERIAL. HAZARDOUS VAPOR IS RELEASED WHEN AN EPOXY IS BURNED.**

WARRANTY AND DISCLAIMER

Copps Industries, Inc. gives no warranty, express or implied, and all products are sold upon condition that purchasers will make their own tests to determine the quality and suitability of the product. Copps Industries, Inc. shall be in no way responsible for the proper use and service of the product. The information given in this publication is considered to be accurate and reliable and is provided as a service only. Physical properties shown are typical. Actual properties are dependent on curing conditions and degree of cure. Any information or suggestions given are without warranty of any kind and purchasers are solely responsible for any loss arising from the use of such information or suggestions. No information or suggestions given by us shall be deemed to be a recommendation to use any product in conflict with any existing patent rights.