105 Epoxy Resin / 207 Special Clear Hardener

**General description**

105/207 Epoxy is used for coating and fiberglass cloth application where an exceptionally clear, moisture-resistant, natural wood finish is desired. 105/207 is blush free and will not turn cloudy in humid conditions. Thin film applications roll out and tip off smoothly, requiring less sanding in preparation for finish coatings. Three coats or more can be applied in one day without additional surface preparation. Fewer coats are required to fill fiberglass weave and in most cases the final coating can be sanded the following day.

105/207 forms a high-strength, moisture-resistant solid with excellent bonding and barrier coating properties and is used as a structural adhesive for gluing and laminating. It has excellent compatibility with paints and varnishes. An ultraviolet inhibitor in 207 helps provide a beautiful, long lasting finish when used with quality UV-filtering varnish. It is formulated without volatile solvents. It has a relatively high flash point, no strong solvent odor and does not shrink after curing.

**Handling characteristics**

Mix ratio by volume (300 Mini Pump ratio) 3 parts resin : 1 part hardener

Mix viscosity (at 72°F) ASTM D-2393 760 cps

Pot life (100g at 72°F) 22 to 27 minutes

Working time, thin film* 110 to 130 minutes

Cure to a solid, thin film* 12 to 18 hours

Cure to working strength 1 to 4 days

Minimum recommended temperature 60°F (16°C)

*Epoxy cures faster at higher temperatures and in thicker applications.

**Physical properties of cured epoxy**

Specific gravity 1.15

Hardness (Shore D) ASTM D-2240 84.4

Compression yield ASTM D-695 11,000 psi

Tensile strength ASTM D-638 6,748 psi

Tensile elongation ASTM D-638 3.8%

Tensile modulus ASTM D-638 4.40E+05

Flexural strength ASTM D-790 11,300 psi

Flexural modulus ASTM D-790 4.12E+05

Heat deflection temperature ASTM D-648 117°F

Onset of Tg by DSC 116°F

Ultimate Tg 116°F

Annular shear fatigue @ 100,000 cycles 9,600 lb

**Storage/Shelf life**

Store at room temperature. Keep containers closed to prevent contamination. With proper storage, resin and hardeners should remain usable for many years. After a long storage, verify the metering accuracy of the pumps. Mix a small test batch to assure proper curing.

Over time, 105 Resin will thicken slightly and will therefore require extra care when mixing. Repeated freeze/thaw cycles during storage may cause crystallization of 105 Resin. Warm resin to 125°F and stir to dissolve crystals.

Hardener may darken with age, but physical properties are not affected by color. If clear finishing, be aware of a possible color shift if very old and new hardener are used on the same project.