

**RESINS
POLYESTER • EPOXY**

Helpful Hints For Resins

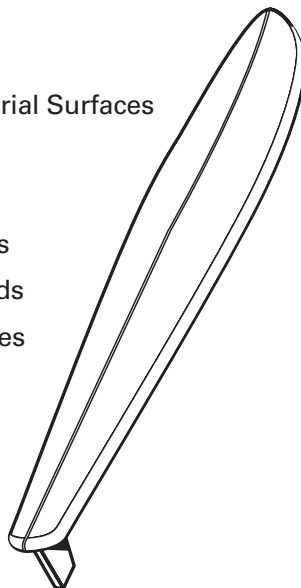
- To extend working time, pour mixed resin and catalyst directly onto the surface to be coated rather than holding the mixture in bulk.
- Select the appropriate epoxy system for your working temperature. Pot life is short above 80°F and a cure may be doubtful below 60°F.
- A test patch is recommended prior to *glassing* below 60°F.
- Temperature of the surface being coated is as critical as the surrounding air temperature.
- If chemical resistance is required, test before using on surface.
- Expect slower wet-out of fiberglass reinforcement when using epoxy. Epoxy is not recommended for use with fiberglass mat.
- Epoxy and polyester may be bulked-out, strengthened, or thickened to make a paste by the addition of TAP fillers. Dry and clean sand may be used to bulk-out epoxy for concrete floor repairs or for building leveling ramps.
- See Product Bulletin 14 for Gel Coat information.
- To minimize deterioration from weather elements and the sun, add pigment to the resin or paint the finished product. Adding too much pigment can cause an improper cure.
- Clean tools and equipment with acetone or Replacetone while resin is still in liquid stage.
- TAP Epoxy proportions are measured by volume not by weight.
- For more information: check our website www.tapplastics.com

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Why Fiberglass?

The term fiberglass means, for our purposes, to combine man-made fibers and liquid resins to form tough, durable parts. The fibers can be made from glass, carbon, or aramid, which are woven in various forms to allow you to select the right fiber for your project.

Polyesters and epoxies offer a variety of physical properties to select from as well. The key to success is selecting the right combination of resin and fiber.

RESIN SELECTION

Polyester Resins

The majority of fiberglass projects are done with polyester. There are two reasons for this. One is that polyester is considerably more economical than epoxy. Second, and more importantly, polyester resin cure time can be controlled to match temperature conditions and user speed. By adjusting the amount of catalyst, the user can accurately control the resin working time and rate of cure.

Another advantage of polyester is that it does not fully cure at the surface (except for the Surfacing Resin), which allows successive layers to be added over time without having to sand between layers. If your project is going to extend over a day or so, polyester will eliminate surface preparation between layers.

TAP carries six polyester resins. The proper resin for your project will depend on the final properties important to you. Below are brief descriptions. See our website, tapplastics.com or visit one of our stores for more technical information.

TAP Bond Coat B Laminating Resin

is a quality economical resin with a relatively long pot life (the length of time before the resin hardens in the cup). It is a good general-purpose resin that cures to a tacky finish for maximum adhesion between layers.



TAP Finish Coat A Surfacing Resin

is the same material as the Laminating Resin, but with the addition of wax to provide a smooth tack free surface. If the cured surface will be painted, the wax would need to be sanded off after cure so that the paint will stick.

TAP High Strength Isophthalic Resin

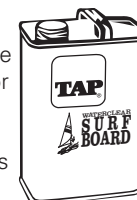
is a low viscosity, thixotropic (ideal for vertical surfaces) resin that offers high strength, and excellent corrosion and



chemical resistance. The low viscosity provides for maximum penetration into porous surfaces. It is the only resin available that is FDA approvable for food applications.

TAP Structural Lay-Up Resin is especially formulated for use in multilayered lay-ups. It has a relatively fast cure cycle and is thixotropic for vertical surfaces. It also has very low viscosity. It has excellent resistance to impact and to cracking or crazing when flexed.

TAP Waterclear Surfboard Resin is a low viscosity, fast curing resin, with UV inhibitors which protect its clear appearance over time in a marine environment. Ideal for any fiberglass application where maximum transparency is important. Surfboard resin also has good impact resistance and resists cracking or crazing when flexed, which is ideal for surfboards.



TAP Marine Vinyl Ester Resin is the top of the line polyester with outstanding chemical, corrosion, water, and heat resistance. Besides being a low viscosity thixotropic resin, it offers many of the superior properties found in epoxy resins.

Epoxy Resins

Epoxy resins have better mechanical strength, better adhesion, and generally better water resistance than most polyester resins. For repair work epoxy is recommended because of its ability to 'stick to stuff'. Epoxy has virtually no odor or flammability.

Unlike polyester, the ratio between resin and hardener must be carefully measured and not varied from in order to produce good results. Therefore, working time is dependent on the resin, not the mixing ratio as in polyester. Because of its adhesive properties, it is always recommended when bonding or glassing redwood, oak, teak, and mahogany. Epoxy fully surface cures without wax (unlike polyester), so sanding must be done if more than 24 hours transpires between layers.

TAP carries five resin/hardener combinations.

TAP General Purpose One-to-One Epoxy is a medium viscosity system with good adhesion and

(See back)

Because we have no control over working conditions or methods, products should be tested to establish suitability for your individual application. Our liability is limited to the price of product.

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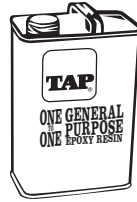
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mechanical properties for general repair. The one-to-one mix ratio makes it ideal for around the house repairs, or where multiple batches need to be mixed with minimum time spent on measuring. Use where high strength and flexibility are needed.

TAP Super Hard Epoxy is a medium viscosity system with excellent chemical and water resistance. It is relatively fast curing with a four-to-one mix ratio, and superior surface hardness.



TAP Premium Marine Epoxy consists of Resin 314 and your choice of three hardeners: Fast 102, Medium 109, and Slow 143. This two-component system contains 100% solids, no solvents, or VOC's. It has excellent wet out and high strength, provides a superior moisture barrier, and has easy mix ratios. It has virtually no odor, is DOT noncorrosive, and can be used in cold weather (102, and 143). See product bulletin #12 for more details.

FABRIC SELECTION

Fiberglass fabrics are measured by their weight per square yard (cloth and roving) or square foot (mat). The heavier the glass weight, the stronger the product. Proper fabric selection is a balance between the required strength and the least possible weight.



For example, a radio controlled model airplane needs to be as light as possible, so one might use 1.4 oz. cloth. However, a wheel chair ramp has no weight restrictions, but needs maximum strength, so one might use 18-oz. roving. The builder must decide what properties are most important when making a fabric selection.

TAP carries many fabric types and weaves, including E-glass, S-glass, Graphite, and Kevlar. More information on these fabrics is available in a TAP store or on our website: www.tapplastics.com.

How to Fiberglass

Fiberglassing is done either in a mold (to create a 100% fiberglass product), or over a substrate like wood or foam. The description below will describe fiberglassing over a substrate. See a TAP sales person for information on lay-up in a mold. Whether you are fiberglassing a boat, a surfboard, or your deck, the process is pretty much the same. The instructions below are intentionally general. For specific issues on your project, speak to a TAP sales person.

Beginning the Project

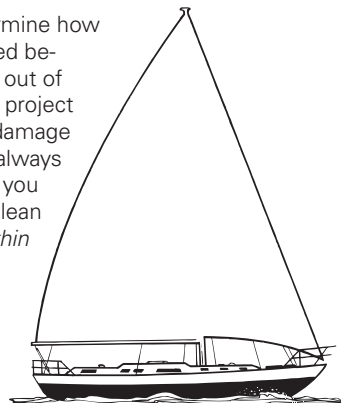
- Wear gloves, safety glasses, coveralls, respirator (if there is not adequate ventilation.)
- Vacuum the surface to be glassed. All wax, oils, grease, etc. must be removed by sanding and acetone wipe in order for resin to stick.
- Lay fiberglass fabric on the surface to be glassed and trim to size. If the area is wider than your fabric, overlap the fabric seams at least 2". Never 'butt joint' the edges of fabric. This will produce a weak seam.
- To help hold the fabric in place while trimming, push pins through the fabric into the substrate (if it is soft like wood or foam).
- If the surface is curved, you may need to cut v-shaped notches so that the fabric can lie flat.
- If more than one layer of fabric is to be used, repeat the process with the next layers trying not to allow seams to stack on top of each other. This would create a bulge due to the double layers of fabric at the seams.
- Once the fabric is cut and trimmed, you are ready for the lay-up.



Lay-up over a Substrate

There are a couple of lay-up methods you can follow. First we will describe the 'dry method', which works well for small projects with lightweight cloth. Then we will describe the 'wet method'.

- For small projects with light fabric and not too many layers, leave the dry trimmed fabric in place, ready for the resin.
- It is best to try to determine how much resin you will need before you start. Running out of resin in the middle of a project is frustrating, and can damage the end result. So it is always best to buy extra since you can return unopened, clean containers of resin (*within 30 days*). For ballpark calculations, use the following numbers *per layer of fabric*:
- One gallon of resin will cover about:



- 18 square feet of 29 oz. Knytex
- 30 square feet of 1.5 oz. mat
- 60 square feet of 9 oz. 'A' cloth
- 140 square feet of Deck Cloth

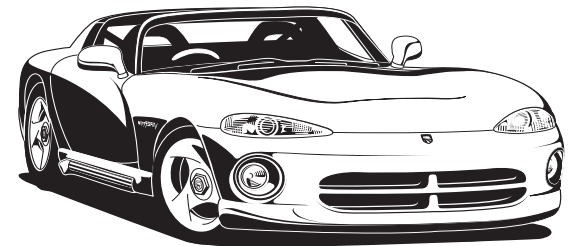
- Coverage on wood depends on the porosity of the wood. The sides of plywood absorb a lot more resin than the surface. Remember, do not use polyester resin on redwood, oak, teak or mahogany.
- Mix the amount of resin you can use within the cure time available. Experiment with small batches first. *Thorough mixing is essential!*
- To maximize your working time, immediately pour the mixed resin onto the fabric surface. Use a brush (disposable) or squeegee to move the resin around the fabric and to make sure the resin saturates the cloth all the way to the substrate.
- Use a squeegee to remove excess resin, taking care not to create dry spots in the fabric. Dry spots will appear white, rather than transparent. Excess resin adds weight and is subject to cracking. Use of the squeegee will also help press the fabric tightly onto the substrate for a good bond.
- When using fiberglass mat, use resin rollers at this stage. These specially designed tools have grooves and ridges which push mat down into the resin and remove air bubbles.
- Once the fabric is saturated, pressed down tight, and excess resin is removed, allow it to gel. This will take anywhere from 30 minutes to 6 or 7 hours depending on the resin, the thickness, and working conditions.
- Once the resin has gelled, a final top coat of resin can be added to cover the weave of the fabric and create a smooth surface. If you have been using polyester; this would be the layer to use the Surfacing Coat A resin.
- Once the surface coat has cured you can sand and paint to create the finish you desire.
- If you have a larger project, or several layers of fabric, the 'wet method' would be more appropriate.
- Once the pieces of fabric are trimmed, mark each one as you remove it and set it aside. Crumpled fabric looks all alike, so some marking system as to direction and location is essential.



- Mix a small amount of resin and immediately apply to the dry surface to be glassed. *Thorough mixing is essential!*
- Lay the first piece of fabric on the wet resin and saturate it with more resin.
- Continue to add layers of fabric and resin, forcing each layer down tight to the prior layer with a squeegee or roller (described above). The key is to get the fabric tight against the substrate and the resin on top where the excess can be squeegeed away.
- **Watch your working time!** Once the resin gels, it is no longer workable. If this happens in the middle of a lay-up and you have excess resin or a wrinkle in the fabric, you will have to stop, let it fully cure, and grind back down to the surface you desire. Never try to squeegee or roll gelled resin. It will just create a bigger mess.
- One of the advantages of polyester is that when one layer is completed, the next layer can be done at any time, even days later, without sanding between layers. When working with epoxy, each layer must be added before the prior layer cures (usually within 24 hours) in order to avoid sanding between layers.
- Once all the fabric is applied and the resin has gelled, add a final layer of resin to fill up the fabric weave. If you are working with polyester resin, using Surfacing A Resin at this point to provide a fully cured surface.
- Once that layer cures, sand and paint with the appropriate finish.

Each project, resin, and fabric has its own idiosyncrasies. Experiment to become an expert on your specific situation. TAP also has numerous books describing most fiberglassing operations.

Read CAUTIONS on all product labels before beginning your glassing project.



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