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Technical Data

General Purpose Epoxy • One-to-One

Description of Resin • General Purpose Epoxy is designed for a fast cure and an easy one-to-one mix ratio. Excellent for laminating and adhesive applications. Not designed to be a chemical barrier (such as tank liner). Excellent combination of impact-resistance and rigidity. A more rigid epoxy resin based on Bis-A. Low toxicity and odor. Viscosity is intermediate between Four to One Epoxy Resin and Work Horse Epoxy Resin. This resin offers faster building of thickness combined with efficient wetting of reinforcement materials. 100% solids, good clarity.

Properties of Resin:

Viscosity @ 77 °F	1,900 - 2,600 cps
EEW (Epoxide Equivalent Weight)	185 - 205
Color (Gardener)	3 (max)
Weight/Gal	9.3 lbs

Description of Hardener • Quick curing hardening agent designed for impact and high strength flexibility. Very versatile material. Easy to use one to one mix ratio by volume. 100% solids.

Properties of Hardener:

Viscosity @ 77 °F	1,000 - 1,250
Weight per Active H	180
Color (Gardener)	3
Weight/Gal	8.0 - 8.1 lbs
Mix Ratio	1:1 by volume

Cured Properties of General Purpose One to One: (Cure Schedule: Gel @ ambient + 2 hours at 212 °F or 7 days at 77 °F)

Pot Life (150 grams)	10 - 15 minutes
Thin Film Set Time, hours	3 - 4
Full Cure Time, hours	24
HDT (ASTM D648-264) F	115
Shore D Hardness	79
Flexural Strength, psi	11,500
Tensile Strength, psi	7,500
Elongation %	5.0

Mixing • Thorough and complete mixing is critical! Carefully proportion the resin and hardener one part to one part by volume. Mix for 1 to 2 minutes using an up and down motion and make certain to scrape sides and bottom. Mix no more material than may be applied in 5 to 10 minutes. Surface must be free from contaminants such as dust, oil, dirt, or water and must be above 55 °F.

Curing • Keep application at or above 55 °F for a period of 3 days after material is placed. Full properties are developed in seven days at ambient temperatures.

Uses • Adhesives, laminating.

How Supplied • TAP supplies General Purpose Epoxy Resin in Pint, Quart, ½ Gallon, 2 Gallon and 100 Gallon kits.

Important • Work only in well-ventilated areas. Wear protective chemical splash goggles and rubber gloves. Avoid contact with skin. Wash hands with soap and warm water after use.

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