

# Clear Laminating Epoxy

## Product Description

PIONEER CLEAR LAMINATING EPOXY is a two-part water clear liquid epoxy system specifically designed for wet lay-up and ambient temperature cure of wood, fiber-reinforced composites such as aramid (kevlar), carbon, glass fibers, as well as other inorganic particulates.

## Key Features

- Dries clear
- Easy to apply
- Self-levelling
- Good water and chemical resistance
- Good encapsulation for protection and reinforcement
- For table tops, bars, wood finishes, and see-through encapsulations
- For strengthening of beams, columns and slabs in buildings



## Product Specifications / Typical Properties / Physical Characteristics

Table 1. Wet Properties\*

Parameters	Component A (RESIN)	Component B (HARDENER)
1. Appearance	Clear, flowy	Very light yellow, flowy
2. Specific Gravity	1.15	1.02
3. Viscosity @ 25°C	1698 cps	200-400 cps
4. Solids Content	100%	42%

Table 2: Mixed State Properties\*

Parameters	Results
1. Mixing Ratio	2 parts A: 1 part B
2. Appearance	Clear, colorless, flowy
3. Potlife @ 25°C	30-40 minutes
4. Setting Time @ 25°C	5-8 hours

## Applications

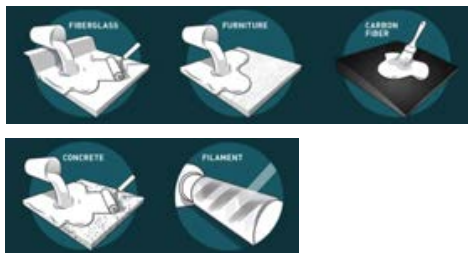


Table 3. Cured State Properties\*

Parameters	Results
1. Full cure time	72 hours
2. Hardness (after 24 hours), shore D	75 minimum
3. Water resistance	Excellent
4. Weathering Resistance	Slight color will fade through time (clear epoxy-based products are typically not UV-resistant)
5. Tensile Strength (as composite with fiberglass) ASTM D638	5800 psi
6. Tensile Strength ASTM D638	4900 psi
7. Flexural Strength ASTM D790	7300 psi
8. Compressive Strength ASTM D695	6600 psi

\*Typical Values and characteristics only.

## Application Procedure

### A. Surface Preparation

Surface contaminants such as dirt, grease, oil or wax must be removed from areas to be joined. Clean surfaces by sanding,

sandblasting or brushing for stronger bonds. Surfaces should be clean and ready for application before the adhesive is mixed.

**B. Mixing**

Mix 2 parts of A to 1 part of B by volume. Better to use separate spatulas (or spoon) to avoid contamination. Blend thoroughly until color streaks disappear and a uniform color is obtained. To avoid waste, prepare a quantity just enough to be consumed within 30 minutes.

**C. Method**

Apply mixed compound with a putty knife or spatula.

**Three field repair methods commonly used are:**

1. Filament winding
2. Dry Installation
3. Wet Installation

**D. Cleaning**

Clean all tools or equipment used while adhesive is still in its uncured state. Use Pioneer Epoxy Reducer or solvents to clean tools and spills.

**Packaging**

Size	Weight	Quantity per box
Can Set	3.00 Kg	4 sets

**Certification and Compliance:** Lead-free

Type	Component A	Component B	Limits
Lead (Pb) content, ppm	<5	<5	<ul style="list-style-type: none"> <li>• Maximum concentration value (MCV) allowed is &lt;1000 ppm</li> </ul>

**Storage**

Store in a dry place at ambient temperature. Keep containers tightly closed, when not in use.

**Shelf Life**

12 months from manufacturing date when kept in a sealed, unopened container following the required storage condition.

**Health and Safety Precautions**

For Component A

For Component B



**PREVENTION**

- Wash skin thoroughly after handling.
- Wear protective gloves/clothing/eye and face protection.
- Avoid breathing fumes.
- Contaminated work clothing should not be allowed out of the workplace.
- Avoid release to the environment.

**RESPONSE**

**If on skin or hair:** Wash with plenty of soap and water. Take off contaminated clothing and wash before re-use. If skin irritation or rash occurs, get medical attention.  
**If in eyes:** Rinse cautiously with water for several minutes. Remove contact lenses, if present and easy to do. Continue rinsing. If eye irritation persists, get medical advice/attention. Collect spillage.

**KEEP OUT OF REACH OF CHILDREN.**

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