

Green Room Epoxy System has been developed specifically to meet the needs of the surfboard/SUP manufacturing community. The system is a 2 part, 100% solids, no VOC epoxy resin/hardener combination. It features a convenient 2:1 mix ratio by volume (100:44 parts by weight). It has been designed for wet hand lay-up laminations and has an excellent balance of low viscosity for rapid wet out and good air release; quick thin film set time to eliminate drain out; non-blushing, no shrinkage cure even in low temperature and high humidity; self leveling with high gloss; excellent UV stability; and high strength. In addition, it has been engineered to have a lower peak exotherm temperature than most fast setting epoxies, which aids in fin box installations without foam core melting. The System offers the choice of 3 resin and 5 hardener formulations to the surf/SUP market. Combinations of any of the resin and hardeners will give bright, clear laminations and smooth easy to sand to hot coats with unsurpassed long-term resistance to yellowing and chalking.

Resin options

Old #7 is our original, breakthrough formula that entered the market in 2006. It features state of the art UV stabilization additives and a light blue optical brightener. It accepts tints and pigments very well and is the first choice for laminations over dark colors or with carbon cloth.

Blanco DH is our revolutionary new formula for super, bright white laminations that was introduced in 2013. It combines the outstanding UV stability of *Old #7* with our proprietary optical brightener that gives unmatched bright, white laminations. Using *Blanco DH* over black, dark blue, similar dark colors or carbon cloth may result in an undesirable change in the appearance of these dark colors. Evaluation on test specimens is recommended before use over dark colors or wood.

BioCarbonEpoxy is the newest resin member of our line-up. It utilizes renewable, bio-based carbon materials derived from waste streams of biodiesel, vegetable and nut oil processes to replace 28% of the normal, petroleum based raw materials. It has been certified as a USDA bio-based product as well as a certified material for the Sustainable Surf Ecoboard project. It matches the performance in terms of cosmetics, processing and physical properties of our other resins with an eco-friendly option. It is available with either *Old #7* or *Blanco* optical brighteners.

Hardener options (set speeds are determined at 75°F)

All of our hardeners are fully interchangeable and can be mixed to give intermediate set speeds.

Ultra-fast (aka West Coast fast) is our fastest hardener option. It features a pot life of 10-15 minutes and a thin film set time of 1.5-2.0 hours.

Original fast is our most popular hardener for all around use. It features a pot life of 20-25 minutes and a thin film set time of 2.5-3.0 hours.

Slow hardener is useful for large lamination projects and for adjusting the set time of either of the faster hardeners. It features a pot life of 45-50 minutes and a thin film set time of 8-12 hours.

Fast NC and *Medium NC* are our newest hardener options. Both are DOT non-corrosive and ship without any hazmat concerns. Although the NC hardeners give slightly high mixed viscosities, their non-corrosive nature gives an extra margin of safety and minimizes the potential skin irritation of other hardeners. *Fast NC* features a pot life of 15-20 minutes and thin film set of 1.5-2.0 hours while *Medium NC* has a pot life of 25-30 minutes and a thin film set of 2.5-3.0 hours.

PHYSICAL PROPERTIES with Fast Hardener

	Old #7/Blanco DH	BioCarbonEpoxy
Density (mixed)	1.11 g/ml	1.09 g/ml
Form and Color	Clear Liquid	Clear Liquid
Viscosity (mixed)	700-800 cPs@77°F	500-600 cPs@77°F
Mix Ratio by volume	100 parts A/50 parts B	100 parts A/50 parts B
Mix Ratio by weight	100 parts A/44 parts B	100 parts A/44 parts B
Pot Life (100 gm)	15-25 Minutes @ 77°F	20-30 Minutes @ 77°F
Peak Exotherm	160°C (100 gram mass)	150°C (100 gram mass)
Thin Film Set Time	2.5 Hours @ 77°F	3.5 Hours @ 77°F
Full Cure Time	72-96 Hrs @ 77°F or 8 hrs @ room temperature + 4 hrs at 212°F	

MECHANICAL PROPERTIES with Fast Hardener

	Old #7/Blanco DH	BioCarbonEpoxy
Hardness, Shore D	85	80
Heat Deflection Temperature	126°F	124°F
Flex Strength, psi	14,850	13,900
Flex Modulus, psi×10 ⁵	4.84	4.96
Tensile Strength, psi	9,420	8,950
Tensile Modulus, psi×10 ⁵	4.62	4.89
Percent Elongation at Break	4.2	5.1
Compressive Strength, psi	12,890	11,990
Compressive Modulus, psi×10 ⁵	3.4	3.2
Izod impact ft. lb/in notch	0.58	0.64

PACKAGING AND STORAGE

Green Room Epoxy System A/B is available in quart, gallon, 5 gallon and 55 gallon kits. All materials should be stored in a cool, dry place in tightly sealed containers. DO NOT store above 100°F for prolonged periods. DO NOT leave hardener exposed to air for prolonged periods. Under these conditions, shelf life is at least 12 months.

SAFETY NOTE

This product is for industrial use only. Please review all precautions before using this product. As with all products of the same nature, avoid prolonged inhalation and repeated skin contact. Always wear safety goggles and impervious rubber gloves when handling this material. Refer to the MSDS for complete handling precautions.

IMPORTANT NOTICE

The information cited herein is based on data available to us and believed to be accurate at the time of publication. Data and parameters cited by GRBC were obtained using materials under controlled conditions. This type of data should not be used for specification for fabrication and design. It is the user's responsibility to determine this product's fitness for use. GRBC warrants only that this product will only meet the cited parameters within the established conditions. There is no warranty of merchantability, fitness of use, nor any other express implied warranty. The user's exclusive remedy and the manufacturer's liability are limited to refund of the purchase price or replacement of the product. GRBC will not be liable for incidental or consequential damages or injuries of any kind. The user should thoroughly test any proposed use of this product and independently conclude satisfactory performance in the application. Determination of the suitability of any kind of information or product for the use contemplated by the user, the manner of use and whether there is any infringement of patent is the sole responsibility of the user.