

# AMPRO™ BIO

## BIO-BASED EPOXY MULTIPURPOSE SYSTEM



AMPRO™ BIO is a simple to use, all-purpose epoxy which can be used for gluing, coating, laminating and filling. With its fast, low temperature curing hardener and easy 3:1 mix ratio by volume, AMPRO™ BIO provides a quick and convenient way of using one epoxy system for a very wide range of tasks.

AMPRO™ BIO has been built on the well-established SP 106 which has been the primary epoxy system for the manufacture and repair of wooden boats for over 20 years.

By using the Gurit range of filler powders, an AMPRO™ BIO resin and hardener mix can be turned into a very effective adhesive or filling compound. Details of this filler range, and how to use them, are contained in a separate information sheet (Filler Guide) and typical filling and fairing mixes (resin / hardener / filler) are shown in this data sheet.

AMPRO™ BIO is compatible with all types of foams, polystyrenes, polyurethanes, Gurit PVC, Gurit Kerdyn™ PET and Corecell™ products.

- For coating, bonding, laminating & filling wood & GRP
- Accredited 40-60% BIO-based system
- Engineered, with improved health & safety
- Available with Fast, Slow and Extra-Slow blendable hardeners
- No surface residue after cure
- Mix Ratio by Weight    100:30
- Mix Ratio by Volume     3:1



## INSTRUCTIONS FOR USE

### APPLICATION

The product is optimised for use at temperatures between 15 - 25°C (50 - 77°F). At lower temperatures the product thickens and may become unworkable. At higher temperatures working times will be significantly reduced. Maximum relative humidity for use is 70%.

### MIXING AND HANDLING

Accurate measurement and thorough mixing are essential when using this system, and any deviation from the prescribed mix ratios will seriously degrade the physical properties of the cured system. The resin and hardener must be stirred well for two minutes or more, with particular attention being paid to the sides and bottom of the container. As soon as the material is mixed the reaction begins. This reaction produces heat (exothermic), which will in turn accelerate the reaction. If this mixed material is left in a confined mixing vessel the heat cannot disperse and the reaction will become uncontrollable.

### COATING

If exposed to sunlight the product should be painted or coated with a varnish which includes UV filter or blockers.

Prior to this, two coats of AMPRO™ BIO will achieve a stable substrate. AMPRO™ Bio has a number of benefits, including:

- Subsequent coats of AMPRO™ BIO can be applied after just 5 hours at 20°C (68°F) without sanding
- AMPRO™ BIO is solvent-free and will be fully hardened overnight ready for over-coating or top-coating

The surface to be coated should be dry and clean, before sanding with 180 – 220 grit sandpaper to generate a key, the surface should then be wiped with solvent to remove the dust before the application of the AMPRO™.

For best results, an initial thin coat of AMPRO™ BIO should be applied to the substrate, using a rubber squeegee or brush to remove any excess. If the first coat of AMPRO™ is too thick, this can cause 'fisheyes' to form in the surface. Once the first coat has cured, subsequent coats of AMPRO™ BIO can be applied. Due to the 4 day overcoating window of AMPRO™ BIO (at 20°C (122°F) / 50% RH), the surface does not require sanding between coats to ensure adhesion. If left for more than 4 days, the surface should be sanded with 120 grit sandpaper followed by a solvent wipe down to remove the dust before applying additional coats.

Note: In order to achieve the optimum surface finish, multiple thin layers of AMPRO™ BIO should be applied.

AMPRO™ BIO should be sanded before the application of the final paint system or varnish, please refer to the paint or varnish manufacturer's recommendations regarding sandpaper and solvent type to be used for this operation

### LAMINATING

AMPRO™ BIO can be used to laminate all common fibre types. Due to its low viscosity it wets out fibres with ease. Standard hand laminating and vacuum bag processes can be used predominantly with the slower hardeners.

### ADHESIVE MIXES

AMPRO™ BIO can be mixed with standard Gurit fillers to make filling / fairing or adhesive compounds as required

All filler additions are approximate and can be adjusted by the user to achieve the desired consistency.

FILLER TYPE	DESCRIPTION	FILLER QUANTITY		SILICA ADDITION		APPROX. DENSITY	APPROX. VOLUME
		%	FOR 1KG	%	FOR 1KG		
Microballoons	Brown, Low Density	15 - 20	150 - 200 g	4 - 5	40 - 50 g	0.7 g/cm <sup>3</sup>	1.8 Ltrs
Glass Bubbles	White, Low Density	15 - 20	150 - 200 g	5 - 6	50 - 60 g	0.6 g/cm <sup>3</sup>	2.0 Ltr
Microfibres	Opaque, High Strength	7 - 10	70 - 100 g	3 - 4	30 - 40 g	0.9 g/cm <sup>3</sup>	1.0 Ltr

### FILLING AND FAIRING MIXES

All filler additions are approximate and can be adjusted by the user to achieve the desired consistency.

FILLER TYPE	DESCRIPTION	EASE OF SANDING	WATER RESISTANCE	FILLER QUANTITY		SILICA ADDITION		APPROX. DENSITY	APPROX. VOLUME
				%	FOR 1KG	%	FOR 1KG		
Microballoons	Brown, Low Density	Easy	Moderate	25 - 30	250 - 300 g	2 - 3	20 - 30	0.6 g/cm <sup>3</sup>	2.2 Ltrs
Glass Bubbles	White, Low Density	Moderate	High	35 - 40	350 - 400 g	3 - 5	30 - 50	0.5 g/cm <sup>3</sup>	3.0 Ltrs

## COVERAGE

THICKNESS (PER COAT)	AREA	COMMENT
Coating Coverage @ 0.25 mm	Approximately 3 m <sup>2</sup> /kg	Dependant on temperature, surface inclination, surface porosity and evenness
Adhesive Coverage @ 1mm	Approximately 1.1 – 1.7 m <sup>2</sup> /kg	Dependant on flier type, temperature, surface inclination, surface porosity and evenness

## TRANSPORT & STORAGE

The resin and hardener should be kept in securely closed containers during transport and storage. Any accidental spillage should be soaked up with sand, sawdust, cotton waste or any other absorbent material. The area should then be washed clean (see appropriate Safety Data Sheet). Adequate long term storage conditions will result in a shelf life, as per table, from the date of manufacture for both the resin and hardeners, see product container label for expiry date.

COMPONENT	UNITS	10 – 25°C (50 – 77°F)
Ampro™ BIO Resin	months	24
Ampro™ BIO Fast, Slow, Extra Slow Hardeners	months	24

Storage should be in a warm dry place out of direct sunlight and protected from frost. The storage temperature should be kept constant between 10 - 25°C (50 – 77°F), cyclic fluctuations in temperature can cause crystallization. Containers should be firmly closed. Hardener, in particular, will suffer serious degradation if left exposed to air. Hardeners may darken over time, however the physical properties are not affected. Be aware of a possible mixed system colour change if very old and new hardeners are used on the same project.

## AMPRO™ BIO & AMPRO™ BIO FAST HARDENER PROPERTIES

This product summary is intended for use in conjunction with further advice provided under the Instructions for Use section.

PROPERTY	UNITS	AMPRO™ BIO RESIN	FAST BIO HARDENER	MIXED SYSTEM
Colour	-	Brown Tint	Amber	Brown Tint
Mix Ratio by Volume	Parts by volume	3	1	-
Mix Ratio by Weight	Parts by weight	100	30	-
Density at 21°C (ISO 1183-1B)	g/cm <sup>3</sup>	1.10	0.99	1.07

## COMPONENT PROPERTIES

PROPERTY	UNITS	TEMPERATURE 15°C	TEMPERATURE 25°C	TEST METHOD
AMPRO™ BIO Resin Viscosity	cP	3028	979	CAP2000LT
AMPRO™ BIO Fast Hardener Viscosity	cP	1918	707	CAP2000LT

## WORKING TIME PROPERTIES

PROPERTY	UNITS	TEMPERATURE 20°C	TEST METHOD
Thin-Film Gel-time (0.5mm)	hrs:min	01:19	Gurit Internal Method
Pot-life (150 g, mixed in water)	hrs:min	00:23	Tecam Gel Time
Tack off Time	hrs:min	02:40	Gurit Internal Method
Earliest Sanding Time	hrs:min	12:00	Gurit Internal Method

*\*working time properties are highly subjective to ambient conditions and should be used as an approximate guideline for all AMPRO™ systems*

*\*\*it is not recommended to apply at low temperatures, but a cure temperatures as low as +5°C is possible*

## THERMAL PROPERTIES

PROPERTY PROGRESSION AT 21°C	UNITS	7 Days	14 Days	21 Days	28 Days	TEST METHOD
Glass Transition Temperature (Tg1)	°C	44	46	46	47	ISO 6721 (DMA)

## CURED RESIN PROPERTIES

PROPERTY	SYMBOL	UNITS	28 Days @ 21°C*	16 Hours @ 50°C*	TEST METHOD
Glass Transition Temperature	T <sub>g1</sub>	°C	47	55	ISO 6721 (DMA)
Ultimate Glass Transition Temp.	UT <sub>g2</sub>	°C	-	62	ISO 11357 (DSC)
Tensile Strength	σ <sub>T</sub>	MPa	40.7	42.0	ISO 527-2
Tensile Modulus	E <sub>T</sub>	GPa	1.9	2.0	ISO 527-2
Tensile Elongation	ε <sub>T</sub>	%	30.7	30.5	ISO 527-2
Flexural Strength	σ <sub>F</sub>	MPa	70.3	70.5	ISO 178
Flexural Modulus	E <sub>F</sub>	GPa	2.1	2.0	ISO 178
Flexural Elongation	ε <sub>F</sub>	%	>12.0	>12.0	ISO 178
28 Day Water Uptake (coupon size 60x60x1mm)	-	mg%	-	48 (0.6)	ISO 62
ILSS	X <sub>ILSS</sub>	MPa	-	34	ISO 14130

*\* initial cure of 24 hours at 21°C*

## ADHESIVE PERFORMANCE (AFTER 28 DAYS AT 21°C CURE)

PROPERTIES	SYMBOL	UNITS	PLYWOOD	TEAK	STEEL	TEST STANDARD
Lap shear Strength	τ	MPa	2.3 (failed in wood)	6.0 (failed in wood)	17.7	BS 5350 Part C5

## AMPRO™ BIO & AMPRO™ BIO SLOW HARDENER PROPERTIES

This product summary is intended for use in conjunction with further advice provided under the Instructions for Use section.

PROPERTY	UNITS	AMPRO™ BIO RESIN	SLOW BIO HARDENER	MIXED SYSTEM
Colour	-	Brown Tint	Amber	Brown Tint
Mix Ratio by Volume	Parts by volume	3	1	-
Mix Ratio by Weight	Parts by weight	100	30	-
Density at 21°C (ISO 1183-1B)	g/cm3	1.10	1.00	1.09

## COMPONENT PROPERTIES\*

PROPERTY	UNITS	TEMPERATURE 15°C	TEMPERATURE 25°C	TEST METHOD
AMPRO™ BIO Resin Viscosity	cP	3028	979	CAP2000LT
AMPRO™ BIO Slow Hardener Viscosity	cP	570	250	CAP2000LT

## WORKING TIME PROPERTIES\*

PROPERTY	UNITS	TEMPERATURE 20°C	TEST METHOD
Thin-Film Gel-time (0.5mm)	hrs:min	01:54	Gurit Internal Method
Pot-life (150 g, mixed in water)	hrs:min	00:43	Tecam Gel Time
Tack off Time	hrs:min	04:30	Gurit Internal Method
Earliest Sanding Time	hrs:min	20:00	Gurit Internal Method

\*working time properties are highly subjective to ambient conditions and should be used as an approximate guideline for all AMPRO™ systems

\*\*it is not recommended to apply at low temperatures, but a cure temperatures as low as +5°C is possible in the time stated

## THERMAL PROPERTIES

PROPERTY PROGRESSION AT 21°C	UNITS	7 Days	14 Days	21 Days	28 Days	TEST METHOD
Glass Transition Temperature (Tg1)	°C	40	43	44	45	ISO 6721 (DMA)

## CURED RESIN PROPERTIES

PROPERTY	SYMBOL	UNITS	28 Days @ 21°C*	16 Hours @ 50°C*	TEST METHOD
Glass Transition Temperature	Tg1	°C	45	49	ISO 6721 (DMA)
Ultimate Glass Transition Temp.	UTg2	°C	53	-	ISO 11357 (DSC)
Tensile Strength	$\sigma_T$	MPa	36.3	42.4	ISO 527-2
Tensile Modulus	$E_T$	GPa	1.9	2.0	ISO 527-2
Tensile Elongation	$\epsilon_T$	%	49.6	31.2	ISO 527-2
Flexural Strength	$\sigma_F$	MPa	61.8	67.0	ISO 178
Flexural Modulus	$E_F$	GPa	1.8	1.9	ISO 178
Flexural Elongation	$\epsilon_F$	%	>12.0	>12.0	ISO 178
7 Day Water Uptake @ 50°C (coupon size 60x60x1mm)	-	%	-	28.4 (0.6)	ISO 62
ILSS	$X_{ILSS}$	MPa	-	32.3	ISO 14130

\* initial cure of 24 hours at 21°C

## ADHESIVE PERFORMANCE (AFTER 28 DAYS AT 21°C CURE)

PROPERTIES	SYMBOL	UNITS	PLYWOOD	TEAK	STEEL	TEST STANDARD
Lapshear Strength	$\tau$	MPa	2.1 (Failed in wood)	-	14.9	BS 5350 Part C5

\*\*\*initial cure of 24 hours at 21°C

## AMPRO™ & AMPRO™ EXTRA-SLOW HARDENER PROPERTIES

This product summary is intended for use in conjunction with further advice provided under the Instructions for Use section.

PROPERTY	UNITS	AMPRO™ BIO RESIN	EXTRA-SLOW BIO HARDENER	MIXED SYSTEM
Colour	-	Brown Tint	Amber	Brown Tint
Mix Ratio by Volume	Parts by volume	3	1	-
Mix Ratio by Weight	Parts by weight	100	30	-
Density at 21°C (ISO 1183-1B)	g/cm3	1.10	1.00	1.08

## COMPONENT PROPERTIES

PROPERTY	UNITS	TEMPERATURE 15°C	TEMPERATURE 25°C	TEST METHOD
AMPRO™ BIO Resin Viscosity	cP	3028	979	CAP2000LT
AMPRO™ BIO Extra-Slow Hardener Viscosity	cP	385	198	CAP2000LT

## WORKING TIME PROPERTIES

PROPERTY	UNITS	TEMPERATURE 20°C	TEST METHOD
Thin-Film Gel-time (0.5mm)	hrs:min	02:14	Gurit Internal Method
Pot-life (150 g, mixed in water)	hrs:min	01:04	Tecam Gel Time
Tack off Time	hrs:min	06:00	Gurit Internal Method
Earliest Sanding Time	hrs:min	20:00	Gurit Internal Method

*\*working time properties are highly subjective to ambient conditions and should be used as an approximate guideline for all AMPRO™ systems*

*\*\*it is not recommended to apply at low temperatures, but a cure temperatures as low as +5°C is possible*

## THERMAL PROPERTIES

PROPERTY PROGRESSION AT 21°C	UNITS	7 Days	14 Days	21 Days	28 Days	TEST METHOD
Glass Transition Temperature (Tg1)	°C	42	44	46	47	ISO 6721 (DMA)

## CURED RESIN PROPERTIES

PROPERTY	SYMBOL	UNITS	28 Days @ 21°C*	16 Hours @ 50°C*	TEST METHOD
Glass Transition Temperature	Tg1	°C	47	49	ISO 6721 (DMA)
Ultimate Glass Transition Temp.	UTg1	°C	49	TBC	ISO 6721 (DMA)
Tensile Strength	$\sigma_T$	MPa	36.0	32.0	ISO 527-2
Tensile Modulus	$E_T$	GPa	1.8	1.6	ISO 527-2
Tensile Elongation	$\epsilon_T$	%	47.9	49.2	ISO 527-2
Flexural Strength	$\sigma_F$	MPa	60.1	62.1	ISO 178
Flexural Modulus	$E_F$	GPa	1.8	1.8	ISO 178
Flexural Elongation	$\epsilon_F$	%	>12.0	>12.0	ISO 178
7 Day Water Uptake @ 50°C (coupon size 60x60x1mm)	-	%	-	45.3 (0.7)	ISO 62
ILSS	$X_{ILSS}$	MPa	-	29.5	ISO 14130

*\* initial cure of 24 hours at 21°C*

## ADHESIVE PERFORMANCE (AFTER 28 DAYS AT 21°C CURE)

PROPERTIES	SYMBOL	UNITS	PLYWOOD	TEAK	STEEL	TEST STANDARD
Lapshear Strength	$\tau$	MPa	2.2 (failed in wood)	9.5 (failed in wood)	15.6	BS 5350 Part C5

## HEALTH AND SAFETY

The following points must be considered:

1. Skin contact must be avoided by wearing protective gloves. Gurit recommends the use of disposable nitrile gloves for most applications. The use of barrier creams is not recommended, but to preserve skin condition a moisturising cream should be used after washing.
2. Protective clothing should be worn when mixing, laminating or sanding. Contaminated work clothes should be thoroughly cleaned before re-use.
3. Eye protection should be worn if there is a risk of resin, hardener, solvent or dust entering the eyes. If this occurs flush the eye with water for 15 minutes, holding the eyelid open, and seek medical attention.
4. Ensure adequate ventilation in work areas. Respiratory protection should be worn if there is insufficient ventilation. Solvent vapours should not be inhaled as they can cause dizziness, headaches, loss of consciousness and can have long term health effects.
5. If the skin becomes contaminated, then the area must be immediately cleansed. The use of resin-removing cleansers is recommended. To finish, wash with soap and warm water. The use of solvents on the skin to remove resins etc must be avoided.

Washing should be part of routine practice:

- before eating or drinking
- before smoking & vaping
- before using the lavatory
- after finishing work

6. The inhalation of sanding dust should be avoided and if it settles on the skin then it should be washed off. After more extensive sanding operations a shower/bath and hair wash is advised.

Gurit produces a separate full Safety Data Sheet for all hazardous products. Please ensure that you have the correct SDS to hand for the materials you are using before commencing work.

## NOTICE

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The Company strongly recommends that Customers make test panels in the final process conditions and conduct appropriate testing of any goods or materials supplied by the Company prior to final use to ensure that they are suitable for the Customer's planned application. Such testing should include testing under conditions as close as possible to those to which the final component may be subjected. The Company specifically excludes any warranty of fitness for purpose of the goods other than as set out in writing by the Company. Due to the varied nature of end-use applications, the Company does, in particular, not warrant that the test panels in the final process conditions and/or the final component pass any fire standards.

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Gurit is continuously reviewing and updating literature. Please ensure that you have the current version by contacting your sales contact and quoting the revision number in the bottom left-hand corner of this page.

## CONTACT INFORMATION

Please see local contact information at [www.gurit.com](http://www.gurit.com)

## 24-HOUR CHEMICAL EMERGENCY NUMBER

For advice on chemical emergencies, spillages, fires or exposures:

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