

# 305

COMPRESSION  
MOLDING RESIN

# Technical Data Sheet

SUPER SAP® 305 System  
High Bio-Content, General Purpose Liquid Epoxy Resin

## Product Overview

SUPER SAP® 305 SYSTEM is an industrial epoxy system designed specifically for the compression molding processes of composite parts. It delivers on the same a high bio-content, excellent fiber wetting qualities, and thixotropic characteristics of our Super Sap® CPM Epoxy Resin but with increased temperature resistance for even faster cycle times. A high modulus combined with excellent elongation properties enable durable yet lightweight composites parts. Super Sap – Make Things Better.

CPF  
FAST

CPL  
SLOW

MECHANICAL DATA		
Tensile Modulus (ASTM D638)	495,800 psi (3.4 GPa)	461,225 psi (3.2 GPa)
Tensile Strength (ASTM D638)	10,600 psi (73.1 MPa)	10,000 psi (68.9 MPa)
Elongation (ASTM D638)	6.2%	7%
Flexural Modulus (ASTM D790)	438,520 psi (3. GPa)	416,280 psi (2.9 GPa)
Flexural Strength (ASTM D790)	15,870 psi (109.4 MPa)	14,800 psi (102. MPa)
Compression Strength (ASTM D695)	12,200 psi (84.1 MPa)	11,800 psi (81.4 MPa)
Tg Ultimate (DSC, midpoint)	177°F/66°C	180°F/68°C
Hardness (Shore D)	70-80	70-80
PROCESSING DATA		
Mix Ratio (by volume)	2:1	2:1
Mix Ratio (by weight)	100:44	100:38
Viscosity (A/B/Mixed @ 77 °F/25 °C)	4300/2200/1400	4300/450/950
Component Density (specific density @ 77°F/25°C)	1.13 (epoxy), 0.99 (hardener)	1.13 (epoxy), 0.96 (hardener)
Mixed Density (specific density @ 77°F/25°C)	1.09	1.08
Pot Life (@ 77°F/25°C)	20 min	50 min
Tack Free Time (@ 95°F/35°C)	N/A	N/A
Recommended Full Cure	15 minutes @ 180°F/82°C	20 minutes @ 180°F/82°C
ENVIRONMENT DATA		
VOC Content (ASTM D2369)	N/A	N/A
Biobased Carbon Content (ASTM D6866)	30%	30%

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AMERICAS

ENTROPY RESINS, INC.  
info@entropyresins.com  
877.882.2120

EU/AFRICA

FERRER-DALMAU  
info@entropyresins.eu  
+34.93.4874015  
entropyresin.eu

ASIA

COMPOSITE CREATIONS CO., LTD.  
info@entropyresins.com  
877.882.2120

30621 San Antonio St. Hayward, CA 94544  
www.entropyresins.com



24/7 Emergency Hotline: (760) 476-3962  
Global Response Access Code: 333178



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