

GENERAL PURPOSE**Resin Characteristics**

Orthophthalic unsaturated polyester resin
Medium reactivity – Medium viscosity

Versions

Thixotropic (T)
Preaccelerated (P)
Blue Indicator (B)
Low Styrene Emission (L)

Molding Technique

Hand Lay-Up
Spray-Up

End Products

Industrial parts
Boats, marine parts

Remarks

Good wet out
Fast curing
Lloyd's Registered

Liquid Properties

Viscosity ¹	400-600	cp
Thix Index ²	min. 2.5	
Solid Content	60-65	%
Acid Value	max. 30	mgKOH/g
Gel Time ³	10-20	minutes
Peak Exotherm	150-170	°C

¹ 25°C, sp4 50

² Only for thixotropic version

³ 25°C, 1ml Co (1%soln.), 2ml Curox M300 per 100g resin

Mechanical Properties of Non Reinforced Clear Castings⁴

Tensile Strength	60	Mpa	ISO 527
Elongation at Break	1.5	%	ISO 527
Tensile Modulus	3800	Mpa	ISO 527
Flexural Strength	100	Mpa	ISO 178
Flexural Modulus	3600	Mpa	ISO 178
HDT	68	°C	ISO 75A
Hardness	40	Barcol	934-1

⁴ Samples post cured 3 hours at 80°C and 1 hour at 100°C.

Stability

The resin is stable for at least 6 months if stored in original packaging in a dry, well ventilated area away from direct sunlight. The storage temperature must not exceed 25°C.

Packaging

Available in
Bulk
1000kg IBC
230kg Drums
18kg Cans

(11/2004E-R01)



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