

CASTING

Resin Characteristics

Orthophthalic unsaturated polyester resin
Medium reactivity – Medium viscosity

Versions

Preaccelerated (P)

Molding Technique

Filled casting

End Products

Kitchen counters, sinks, bathtubs

Remarks

General purpose casting resin
Fast curing

Liquid Properties

Viscosity ¹	700-900	cp
Solid Content	62-67	%
Acid Value	max. 30	mgKOH/g
Gel Time ²	10-20	minutes
Peak Exotherm	140-160	°C

¹ 20°C, sp4 50rpm

² 20°C, 1ml Co (1% soln.), 1ml Curox M300 per 100g resin

Mechanical Properties of Non Reinforced Clear Casting³

Tensile Strength	70	Mpa	ISO 527
Elongation at Break	2.7	%	ISO 527
Tensile Modulus	3700	Mpa	ISO 527
Flexural Strength	110	Mpa	ISO 178
Flexural Modulus	3600	Mpa	ISO 178
HDT	63	°C	ISO 75A
Hardness	42	Barcol	934-1

³ 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

Important Note

Different types and amounts of fillers might affect the color, gel time or curing properties of the resin. So, we would recommend you to test a sample in small portions before getting to the actual process.

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