

TECHNICAL DATA SHEET



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1. PRODUCT NAME & DESCRIPTION

Allied Clear Polyester Casting Resin

2. BASE MATERIAL

No information available.

2. GENERAL DATA & PROPERTIES

Product Description

Allied Clear Polyester Casting Resin is a low peak exothermic unsaturated polyester resin of orthophthalic type for making decorative castings. It is non-waxed but can be waxed upon request.

Intended Uses

Allied Clear Polyester Casting Resin is clear and transparent. It possesses low shrinkage and is ideal for making a variety of casting objects such as imitation jewels, ornaments, panel, trays etc.

Specification

Appearance

Clear

Viscosity at 30°C

3 - 4 poise

Geltime at 30°C

30 - 50 mins

Cure time at 30°C

60 - 80 mins

Peak Exothermic

45 - 55°C

Shrinkage

+ - 5%

Stability in the Dark below 25°C

6 months

Above gelation characteristics determined using 1% v/w of MEKP catalyst (Butanox M-50) on 20g of resin.

2. GENERAL DATA & PROPERTIES (Continued)

Usage

Allied Clear Polyester Casting Resin performs best when it is completely cured. To do so, a proper combination of catalyst and accelerator must be used at room temperature for a sufficient period of time. Generally, 1 percent of catalyst (BUTONOX M-50 MEKP) together with 0.5 percent of accelerator (6% cobalt content) is used.

Adjustments for shorter or longer geltime can be achieved by ranging the quantities of catalyst and/or accelerator used. As a rule, however, the amount of catalyst used should not be more than 2% or less than 0.5% while that of accelerator should range between 0.4% and 1%. Be sure to measure accurately. When used with filler, depending on the percentage of filler being added the amount of catalyst will need to be adjusted accordingly for the desired geltime.

Ensure that the accelerator is completely mixed into the resin before the catalyst is added in order to avoid a direct blending which may result in a violent reaction or explosion.

Since the viscosity increases as the storage period of resin lengthens, Styrene Monomer can be added to lower it to a desired level.

Note that no warranty is expressed or implied and users are recommended to carry out their own tests to determine the applicability of the above information and the suitability of SHCP resin for their particular requirements.

Storage

Allied Clear Polyester Casting Resin will remain stable if stored in the dark and at temperatures below 25°C. Their stability however deteriorates markedly at higher temperatures, especially when they are directly exposed to sunlight. Hence they should be kept in a cool, dark place. It is advisable to use it within three months.

Packing

Allied Clear Polyester Casting Resin is packed in steel drums of standard size, containing 225 kilos in net weight.

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