



Crestamould® VE 690PA

Modified vinyl ester resin for tooling skin coats and manufactured parts

Product Overview

Introduction

Crestamould® VE 690PA is a pre-accelerated, thixotropic, modified vinyl ester resin for tooling applications and manufactured parts.

Applications

Crestamould® VE 690PA was developed for use as a skin coat in tooling and marine applications where surface finish is critical.

Features and Benefits

Crestamould® VE 690PA has excellent blister resistance and significantly reduces the occurrence of print through, to produce durable mouldings with an enhanced surface finish.

Approvals

Crestamould® VE 690PA is approved by Lloyd's Register of Shipping for use in the construction of craft under their survey.

Product Characteristics

Formulation

Crestamould® VE 690PA must be thoroughly stirred and allowed to attain workshop temperature (18°C - 20°C) before use. It needs only the addition of a catalyst to start the curing reaction. Butanox M50, Butanox LA-IN and Trigonox 249VR catalyst can be used, which should be added into the resin. The geltime of Crestamould® VE 690PA can be approximately determined from the table on page 2.

Additives

The addition of pigment, fillers or other additives may adversely affect the resin properties. Users should consult Scott Bader's Technical Service Department before making any such additions.

Typical Properties

The following tables give typical properties of Crestamould® VE 690PA when tested in accordance with the appropriate BS or BS EN ISO test method.

Liquid Properties	Unit	Liquid Resin	
Colour		Red / Brown	
Viscosity at 25°C 37.35sec ⁻¹	Poise	5.0	
Viscosity at 25°C 4500sec ⁻¹	Poise	2.3	
Specific Gravity @ 25°C	gcm ⁻³	1.065	
Stability in the dark at 25°C	Months	6	
Geltime at 20°C using 2% Butanox M50	Minutes	15	
Geltime at 20°C using 2% LA-IN	Minutes	24	
Geltime at 20°C using 2% Triganox 249VR	Minutes	21	
Mechanical Properties	Unit	Fully Cured Resin (unfilled casting)	
		*	**
Barcol Hardness (GYZJ 934 - 1)		23	35
Deflection Temperature under load (1.80 MPa)	°C	60	94†
Water Absorption 24hrs @23°C	mg	10	15
Tensile Strength	MPa	60	52
Tensile Modulus	GPa	2.7	3.0
Elongation at Break	%	4.3	2.1
Specific Gravity @ 25°C	gcm ⁻³	1.161	1.158

* Curing Schedule - 24hrs @ 20°C, 16hrs @ 40°C.

** Curing Schedule - 24hrs @ 20°C, 3hrs @ 80°C .

† Curing Schedule - 24hrs @ 20°C, 5 hrs @ 80°C, 3 hrs @ 120°C.

Additional Information

Storage

Crestamould® VE 690PA should be stored in the dark in suitable closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

Packaging

Crestamould® VE 690PA is supplied in 25kg and 200kg steel containers.

Health & Safety

Please see separate Materials Safety Data Sheet.



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