

VINALKYD 620 PE-A



Orthophthalic Unsaturated Polyester Resin

- Description:** It is an orthophthalic, medium reactive, with low viscosity, preliminary accelerated unsaturated polyester resin
- Use:** Applied for production of sanitary articles and baths from reinforcing media in combination with glass fibres or roving, suitable for acrylic sheet application. The hardening is carried by addition of 2 % MEKP-50 (Butanox M-50).
- Properties:**
- Has good PMMA adhesion (acrylic base)
 - Can be pigmented with inorganic pigments and tixotroped
 - Can be filled up to 60% with fillers – type carbonates
 - Very good fibreglass wetting properties
 - Applied by spray gun
 - Ready mixture no flow down, when applied on vertical surface
- Classification:** Meets the requirement of the EU legislation.

Characteristics

Properties	NORM
Appearance : (visually)	Pink colored liquid
Viscosity at Brookfield 25°C(sp.2/50rpm): (ISO 2555)	180-320 mPa.s
Acid number: (BNS EN ISO 3682)	max 30 mgKOH/g
Non-volatile content 125°C/1h: (BNS EN ISO 3251)	60 ± 1,5 %
Reactivity at 25°C: (+ 2 % MEKP-50)	
- gel time	4 – 7 min
- hardening time	7 – 10 min
- temperature maximum	160- 185°C
(Test method)	

Other details

Density at 20°C: 1,1 g/cm³
(BNS ISO 2811-1)

Flash point: 32°C
(BNS ISO 2719)

PHYSICAL-MECHANICAL PROPERTIES

Hardening system: 2 % MEKP
Hardening condition: 24h at room temperature
Post-curing 16 h at 40°C

Index	Value
Tensile strength: (BNS EN ISO 527-1,2)	min. 70 MPa
Flexural strength: (BNS EN ISO 178)	min. 120 MPa
Flexural modulus: (BNS EN ISO 178)	min. 3400 MPa
Elongation at break: (BNS EN ISO 527-1,2)	min. 3,0 %
HDT: (BNS EN ISO 75-1,2)	min. 79°C
Hardness at 25°C (Barcol): (ASTM D 2583)	min.40
Water absorption (24 hours): (ISO 62)	max 0,2%

Solubility: It is dissolves in styrene, n-butyl acetate and acetone

Application: Unsaturated polyester resin Vinalkyd 620 PE-A is curing with following hardening system.
Add to 1000g resin 20 g MEKP-50 (Butanox M-50). The mixture must be well homogenized and then used for preparation of the details. The viability of the mixture is from 4 to 7 minutes and depends on the temperature of the resin, as the process of gelling accelerates additionally at temperature higher than 25°C, however low temperature decelerates the time of gelling.
Recommended post-curing of resin : 2h at 35-40 °C

- Packaging:** In metal conic boxes 22 L; metal barrels; plastic containers; cisterns from stainless steel
- Storage:** The packed unsaturated polyester resin is stored in closed, dry and fire prevented storage areas, protected from direct sunlight at temperature up to 25 °C.
Storage shelf life- 3 months from the production date.
Prolonged storage or storage outside of recommended conditions can influence on liquid resin properties like viscosity and gel time. An addition of 0.5-1.0% Co-1% may be necessary to restore the original potlife.
- Hygiene, safety work and ecology:** Refer to the Material Safety Data Sheet for further information on the safe storage, use and handling of Vinalkyd 620 PE-A. The Material Safety Data Sheet (MSDS) should always be read and understood thoroughly before handling the product, and adequate safety procedures should be followed.

The present technical description has the purpose to inform the clients on the quality of our product. The data herein is based on our present best knowledge. We invite our clients before work to check the quality of the product or its adaptation to the base and to make an experimental application. Our clients must be sure, that the present technical description hasn't been changed or replaced by a newer edition.

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