

PIPD-51225

DESCRIPTION

The PIPD-51225 is a pre-promoted, thixotropic, isophthalic polyester resin.

FEATURES AND BENEFITS

- Good wet out properties
- Good mechanical properties.
- Raw materials used (resin manufacturing) comply with FDA regulation 21 CFR 177.2420.

APPLICATIONS

- Hand Lay Up or Spray Up Process.

TYPICAL LIQUID PROPERTIES

Property	Units	Value min.	Value max.	Test Method
Acid Number (Solution)	Mg KOH/g sample	—	35 max	TARQ-100
Non-volatile content	%	58	62	TARQ-204
Zahn cup viscosity ²	Seg	30	40	TARQ-300
Thixotropic Index ³	—	3 min	—	TARQ-300
Gel Time ¹	Minutes	16	20	TARQ-400
Cure Time	Minutes	24	30	TARQ-400
Exothermic Peak	°C	—	180 max	TARQ-400
Density @25°C	g/ml	1.08	1.12	TARQ-700
Stability at 120°C	Hours	2 min	—	TARQ-660

¹1.25% Norox-925 @25°C; ²Zahn cup #4 @ 25°C; ³RVT, spindle #3, 5 rpm / 50 rpm @25°C.

NOTE: Tests results compared with the reported in certificate can be affected due to: batch age, temperature, moisture, type and amount of catalyst, testing equipment and method.

PHYSICAL PROPERTIES

Physical properties are shown for fiberglass laminated. These are typical values and are provided for reference only.

Property	Units	Values	Test Method
Tensile Strength	Psi	15,000	ASTM D-638
Tensile Modulus	Psi	1.4×10^6	ASTM D-638
Elongation	%	0.50	ASTM D-638
Flexural Strength	Psi	26,000	ASTM D-790
Flexural Modulus	Psi	1.1×10^6	ASTM D-790
HDT	°C	77	ASTM D-648

1.- Laminate construction: 30% fiberglass to resin ratio.

2.- Laminate cured overnight at room temperature and post-cured at 65°C for 5 hours.

3.- HDT is evaluated at neat resin casting.

RECOMMENDATIONS

- The catalyst level should not exceed 2.8% or fall below 1% for proper cure.
- This product should not be used when temperature conditions are below 16°C, as curing and handling may be adversely affected.
- Before use:
 - Mix once a day for 10 minutes, starting from the edges towards the center of the drum with the least possible turbulence.
 - Avoid air assistance, this is not effective and may cause water or oil contamination.
 - Avoid over-mixing, due to potential filler separation and increased tendencies to sag.
- Do not add any material different to the catalyst recommended for this product.
- Do not mix organic peroxides with metallic soaps, amines or any type of accelerators or promoters, because it can result on violent decomposition with fire or explosion.
- Any additional questions, please contact your Reacciones Químicas SA de CV sales representative.

STORAGE

Uncatalyzed PIPD-51225 resin, have a usage life of three months from invoice date, when stored at 25°C or below, in a closed, opaque, factory sealed container, out of direct sunlight, heat sources or moisture. For every 7°C increase in storage temperature, the shelf life is reduced by one half.

SAFETY AND HANDLING

Detailed information on the safe handling of the PIPD-51225 can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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