

## PRA-6620 / PRA-6630 / PRA-6631 / PRA-6632 / PRA-6634

### DESCRIPTION

The PRA-6620, PRA-6630, PRA-6631, PRA-6632 and PRA-6634 are pre-promoted, orthophthalic, low viscosity, unsaturated polyester resins.

### FEATURES AND BENEFITS

- Excellent wet out properties
- Quick removal of residual tack.
- Bleeding free.
- Excellent sandability properties.
- PRA-6631 and PRA-6634 show lower emissions of styrene monomer during the manufacture of the final product. PRA-6634 develops less hardness.

### APPLICATIONS

Body filler.

### TYPICAL LIQUID PROPERTIES

Property	Units	PRA-6620	PRA-6630	PRA-6631	PRA-6632	PRA-6634	Test Method
Acid number (Solution)	Mg KOH/g sample	25 max.	17 max	25 máx.	17 max	17 max	TARQ – 100
Non-volatile content	%	65-70	67-67		60-65	60-66	TARQ – 204
Brookfield viscosity	Cps.	500-700 <sup>2</sup>	200-350 <sup>3</sup>		200-300 <sup>4</sup>	200-350 <sup>3</sup>	TARQ – 300
Gel time <sup>1</sup>	Min.	4.5-5.5		3-5			TARQ – 400
Cure time	Min.	9-13		8-12			TARQ – 400
Exothermic Peak	°C	150 max.		110-155			TARQ – 400
Stability at 120°C	Hours	6 min.		5 min.			TARQ – 660
Density at 25°C	g / ml	-----		1.1-1.2			TARQ – 700
Gardner color	-----	18 max.		-----			TARQ – 600
Appearance	-----	Clear	Clear	Cloudy	Clear	Cloudy	Visual

<sup>1</sup> 4% BPO (50% paste) @25°C; <sup>2</sup> LVDV-E, spindle #2, 30 rpm @25°C; <sup>3</sup> RVT, spindle # 3, 50 rpm @25°C; <sup>4</sup> RVT, spindle # 1, 20 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.

## RECOMMENDATIONS

- 1.- The catalyst level should not exceed 2.8% or fall below 1% for proper cure.
- 2.- These products should not be used when temperature conditions are below 16°C, as curing and handling may be adversely affected.
- 3.- Do not add any material different to the catalyst recommended for these products.
- 4.- 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.
- 5.- Any additional questions, please contact your Reacciones Químicas SA de CV sales representative.

## STORAGE

Uncatalyzed PRA-6620, PRA-6630, PRA-6631, PRA-6632 and PRA-6634 resins, have a usage life of three months from invoice date, when stored at 25°C or below, in a closed, factory sealed opaque containers, and 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 for safe handling of PRA-6620, PRA-6630, PRA-6631, PRA-6632 and PRA-6634 resins, can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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