

polimal[®]

unsaturated polyester resin

877

Application.

The resin **Polimal 877** is recommended for processing under RTM and infusion.

Resin characteristics.

Polimal 877 is constructional, orthophthalic, non-accelerated, non-thixotropic resin.

It has very good processing parameters:

- low viscosity,
- low thermal peak,

Typical parameters of Polimal-877.

Tested parameter/standard	Unit	Value
Viscosity (at 25°C) acc. to DIN 53015	mPa s	100 - 200
Gel time (25°C) acc. to ISO 2535	min.	25
Tensile strength acc. to ISO 178	MPa	100
Elongation at tension acc. to ISO 527.	%	1,0
Impact resistance, min. acc. to ISO 179	kJ/m ²	10
Heat deflection temperature acc. to ISO 75	°C	52
Barcol hardness acc. to ASTM D 2583	°B	35
Guarantee period	months	6

*gel time: with : 1 % Cobalt accelerator 1%Co
and 2% medium-active MEKP [Luperox[®] K-1]

Storage conditions

The resin should be stored in closed original containers, in dry, well ventilated and shaded storage rooms adapted for storing inflammable materials at the temperature below 25°C.

Processing conditions.

The resin required to be used for processing should have the temperature above 18°C. Good curing requires the ambient temperature above 18°C and low air humidity. The best curing conditions are achieved while using; per 1 kg of resin: Cobalt accelerator 10% Co in the amount of 1 - 2 ml [alternatively Cobalt accelerator e.g. 6 % Co in the amount of 2 - 4 ml] and 20 ml of MEKP hardener.

The gel time control is achieved by changing the amount of accelerator (within the range as above). By reducing the amount of hardener [the best within 10-20 ml/kg of resin], you can lower the temperature peak.

The standard hardener is Luperox[®] K-1.

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Note:

The information does not substitute Material Safety Data Sheet, Company Standard or Technical Specification, which are superior documents and available on request.