

**Product Technical Data PATPOL 16-02**

**01. Description**

PATPOL 16-02 is resin for making buttons through centrifugal casting process. Resin is designed to give good surface finish and gloss to the final product and friendly to the process of button making.

**02. Application**

For centrifugal casting application.

**03. Physical data in the liquid state (conforms to IS 6746 –1994)**

<i>Property</i>	<i>Unit</i>	<i>Limits</i>	<i>Test method</i>
Appearance	--	Pale Yellow Clear Liquid	--
Specific Gravity	--	1.14±0.05	--
Viscosity at 25°C - Brookfield LVT (2/12)	Mpa.s (cPs)	1200±50	--
Acid Value	Mg KOH/g	28±2	--
Non-Volatiles Content	%	72±2	--
Gel Time @ 30°C*	Minutes	7±2	--
Peak Exotherm	°C	190±10	--
Stability in the dark at 30°C	Months	2	--

\*Using 1.5%Co (3%), 1.5% MEKP (50%)

**04. Properties of cast resin laminate-AVAILABLE ON REQUEST**

**05. Post curing**

Mature the laminate for 24 hours @ room temperature, followed by post curing @ 60°C for 16 hours or @ 80°C for 3 hours

**06. Usage**

PATPOL 16-02 performs best if the laminate is completely post cured. The quantity of catalyst and accelerator may be adjusted to get the optimum gel time. Since viscosity increases on the storage, styrene may be added to lower viscosity

**07. Storage**

PATPOL 16-02 remains stable for 3 months at 30°C in the dark. The stability deteriorates markedly at elevated temperatures, especially when exposed to direct sunlight

**08. Packing**

PATPOL 16-02 is packed in HDPE carboys (35 kg) & epoxy coated steel drums (225 kgs)

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