

Product Technical Data PATPOL 23-01

01. Description

PATPOL 23-01 is ortho based resin is formulated with optimum thickening time and mechanical properties that help the SMC compounding and heat curing processes. It is advisable to consistent quality of MgO with the resin for consistent quality of compounding to achieve.

02. Application

For Sheet Moulding Compounding Process

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

Property	Unit	Limits	Test method
Appearance	--	Pale Yellow Clear Liquid	--
Specific Gravity	--	1.10±0.05	--
Viscosity at 25°C - Brookfield LVT (2/12)	Mpa.s (cPs)	1200±100	--
Acid Value	Mg KOH/g	24±2	--
Non-Volatiles Content	%	69±3	--
Gel Time *	Minutes	2±2	--
Peak Exotherm	°C	220±10	--
Thickening	hrs	2-5	
Moisture Content	%	0.1 max.	
Stability in the dark at 30°C	Months	2	--

* 100 Gms Resin + 1.3% TBPB at 140°C

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 23-01 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 23-01 remains stable for 2 months at 30°C in the dark. The stability deteriorates markedly at elevated temperatures, especially when exposed to direct sunlight

08. Packing

PATPOL 23-01 is packed in epoxy coated steel drums (225 kgs)

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