

050-X-851 / 050-X-852

DESCRIPTION

The 050-X-851 and 050-X-852 are pre-promoted, orthophthalic, neutral gel coat developed for the cultured marble industry.

FEATURES AND BENEFITS

- Fast cycle of curing.
- Regular resistance to sagging.
- Ready to pigment.

APPLICATIONS

- Designed for use with spray equipment for the manufacture of sinks (covers) in serial processes (automated).

TYPICAL LIQUID PROPERTIES

Property	Units	050-X-851	050-X-852	Test Method
Non volatile matter	%	67 - 73	—	TARQ - 500
Brookfield viscosity ²	Cps.	2300 - 3000		TARQ - 300
Thixotropic index ³	—	4.5 - 6	5 - 7	TARQ - 300
Gel time	Minutes	3 - 5 ¹	6 - 8 ⁴	TARQ - 400
Cure time	Minutes	10 - 15		TARQ - 400
Exotherm temperature	°C	180 max.	110-180	TARQ - 400

¹ 1.5% Butanox M-50 @25°C; ² LVDV-E, spindle # 4, 60 rpm @25°C; ³ LVDV-E, spindle # 4, 6 / 60 rpm @25°C.

⁴ 2% Luperox DDM-9 @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.- 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.

4.- Film should be sprayed in at least three passes, for a total film thickness of 18 to 22 mils (wet).

NOTE: Films less than 12 mils may not cure properly; films above 24 mils may pre-release, generate porosity or cracks.

5.- Brushing is not recommended, because it causes uneven thickness.

6.- Do not add any material different to the catalyst recommended for these products.

7.- 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.

8.- Any additional questions, please contact your Reacciones Químicas SA de CV sales representative.

STORAGE

Uncatalyzed 050-X-851 and 050-X-852, have a usage life of 20 days from invoice date, when stored at 25°C or below, in closed, opaque, factory sealed containers, and out of direct sunlight, heat sources or moisture. If ordered in IBC totes, shelf life is only 13 days when stored at 25°C or below, in closed, factory sealed 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 050-X-851 and 050-X-852, can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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