

PIS-65

DESCRIPTION

PIS-65 is an unpromoted, no thixotropic, Isophthalic unsaturated polyester resin.

FEATURES AND BENEFITS

- Good wet out properties.
- Low color in the final part.
- Good mechanical properties.

APPLICATIONS

- GP Laminating, FRP parts, Hand lay-up, Spray-up.

TYPICAL LIQUID PROPERTIES

Property	Units	Min	Max	Test Method
Acid Number (Solution)	Mg KOH/g sample	0	25	TARQ-100
Non-volatile content	%	64	69	TARQ-204
Gardner Viscosity	--	V	Y	TARQ-310
Gel Time ¹	Minutes	10	15	TARQ-400
Cure Time ¹	Minutes	20	30	TARQ-400
Exothermic Peak ¹	°C	0	180	TARQ-400
Gardner Color	--	0	2	TARQ-600
Appearance	--	Clear	Clear	VISUAL
Stability at 120°C	Hours	1.5	--	TARQ-660

¹ 0.25% de Co (at 12%), 1% Butanox M-50 @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.

PHYSICAL

Physical properties are shown for fiberglass laminated. These are typical values and are provided for reference only.

Property	Units	Values	Test Method
Tensile Strength	Psi	7.155	ASTM D-638
Tensile Modulus	Psi	0.867 x 10 ⁶	ASTM D-638
Elongation	%	0-38	ASTM D-638
Flexural Strength	Psi	12,700	ASTM D-790
Flexural Modulus	Psi	0.531 x 10 ⁶	ASTM D-790
HDT @ 1.82 MPa	°C	68.2	ASTM D-648

Laminate cured overnight at room temperature and post-cured at 65°C for 5 hours.

RECOMMENDATIONS

- 1-. The catalyst level should not exceed 2.8% or fall below 1% for proper cure.
- 2-. This product 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 this product.
- 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 PIS-65 resin, have a usage life of three months from invoice date, when stored at 25°C or below, in a closed, opaque, factory sealed container, 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 on the safe handling of the PIS-65 can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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