

PRA-6620 / PRA-6630 / PRA-6631 / PRA-6632 / PRA-6634

DESCRIPTION

The PRA-6620, PRA-6630, PRA-6631, PRA-6632 and PRA-6634 are pre-promoted, orthophthalic, low viscosity, unsaturated polyester resins.

FEATURES AND BENEFITS

- Excellent wet out properties
- Quick removal of residual tack.
- Bleeding free.
- Excellent sandability properties.
- PRA-6631 and PRA-6634 show lower emissions of styrene monomer during the manufacture of the final product. PRA-6634 develops less hardness.

APLICACIONES

- Body filler.

TYPICAL LIQUID PROPERTIES

Property	Units	PRA-6620	PRA-6630	PRA-6631	PRA-6632	PRA-6634	Method
Acid Number (Solution)	Mg KOH / g sample	25 max	25 max	25 max	25 max	25 max	TARQ-100
Non-volatile content	%	65 – 70	61 – 67	61 – 67	60 – 65	60 – 66	TARQ-204
Brookfield Viscosity	Cps	500 – 700 ²	200 – 350 ³	200 – 350 ³	200 – 300 ⁴	200 – 350 ³	TARQ-300
Gel Time ¹	Min	4.5 – 5.5	3 – 5	3 – 5	3 – 5	3 – 5	TARQ-400
Cure Time	Min	9 – 13	8 – 12	8 – 12	8 – 12	8 – 12	TARQ-400
Exothermic Peak	°C	150 max	110 – 155	110 – 155	110 – 155	110 – 155	TARQ-400
Stability at 120°C	Hours	6 min	5 min	5 min	5 min	5 min	TARQ-660
Density at 25°C	g/ml	--	1.1 – 1.2	1.1 – 1.2	1.1 – 1.2	1.1 – 1.2	TARQ-700
Gardner Color	--	18 max	--	--	--	--	TARQ-600
Appearance	--	Clear	Clear	Cloudy	Clear	Cloudy	VISUAL

¹ 4% BPO (50% paste) @25°C; ² LVDV-E, spindle #2, 30 rpm @25°C; ³ RVT, spindle # 3, 50 rpm @25°C; ⁴ RVT, spindle # 1, 20 rpm @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.- Do not add any material different to the catalyst recommended for these products.
- 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 PRA-6620, PRA-6630, PRA-6631, PRA-6632 and PRA-6634 resins, have a usage life of three months from invoice date, when stored at 25°C or below, in a closed, factory sealed opaque 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 PRA-6620, PRA-6630, PRA-6631, PRA-6632 and PRA-6634 resins, can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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