

PUG-800 / PUG-732 / PUG-7321

DESCRIPTION

The PUG-800, PUG-732 and PUG-7321 are un-promoted, high viscosity, unsaturated polyester resins.

FEATURES AND BENEFITS

- Good wet out/roll out properties
- Acceptance of styrene monomer not more than 30-40% by weight.
- Good Mechanical properties.
- Moderate hardness development.
- Low color.

APPLICATIONS

- GP laminating, FRP parts, Hand lay-up, Spray-up.
- Decorative figures.

TYPICAL LIQUID PROPERTIES

Property	Units	PUG-800	PUG-732	PUG-7321	Test Method
Acid Number (Solution)	Mg KOH/g sample	40 max	37 max	37 max	TARQ-100
Non-volatile content	%	78 – 82	74 – 76	70 – 74	TARQ-204
Gardner Viscosity	--	Z4 – Z6	Z1 – Z4	Z – Z2	TARQ-310
Gel Time	Minutes	7 – 11 ²	6 – 10 ¹	15 – 20 ²	TARQ-400
Cure Time	Minutes	24 – 32 ²	20 – 30 ¹	27 – 38 ²	TARQ-400
Exothermic Peak	°C	160 max ²	145 – 170 ¹	160 max ²	TARQ-400
Gardner Color	--	--	--	1.5 max	TARQ-600
Apha Color	--	80 max	90 max	--	TARQ-610
Stability at 120°C	Hours	1	1.5 min	1.5 min	TARQ-660
Appearance	Clear	Clear	Clear	Clear	VISUAL

¹ Dilute at 60% solids, 0.25% Co (at 12%), 1% RR catalyst @25°C; ² Dilute at 60% solids, 0.25% Co (at 12%), 1% Butanox M-50 catalyst @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 laminate: These are typical values and are provided for reference only.

Property	Units	PUG-800	PUG-732	PUG-7321	Method
Tensile Strangth	Psi	16,753	16,753	16,753	ASTM D-638
Tensile Modulus	Psi	1.9 x 10 ⁶	1.9 x 10 ⁶	1.9 x 10 ⁶	ASTM D-638
Elongation	%	1.5	1.5	1.5	ASTM D-638
Flexural Strength	Psi	24,232	24,232	24,232	ASTM D-790
Flexural Modulus	Psi	1.16 x 10 ⁶	1.16 x 10 ⁶	1.16 x 10 ⁶	ASTM D-790
HDT @ 1.82 MPa	°C	54	54	54	ASTM D-648
Barcol Hardness	--	40	40	40	ASTM D-2583

- 1-. Laminate construction: 30% fiberglass to resin ratio.
- 2-. Laminate cured overnight at room temperatura and post-cured at 65°C for 5 hours.
- 3-. HDT is evaluated at neat resin casting.

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 PUG-800, PUG-732 and PUG-7321 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 PUG-800, PUG-732 and PUG-7321 resins, can be found on its SDS. For more information, please contact your Reacciones Químicas SA de CV sales representative.

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