

Product Information

Vicast Polyester Resin for Cultured Onyx and Marble

TYPICAL LIQUID RESIN PROPERTIES*

	Nominal
Viscosity @ 77°F/25°C RV Brookfield Spindle #3@20 rpm, cps.	1500
Specific Gravity @ 77°F/25°C	1.15
Color	light pink
Styrene Content, %	30

TYPICAL CURING PROPERTIES OF A540-DMB-12 (1) see back page

Gel time @ 77°F/25°C, 100grams 1% M50-a, minutes	12
Gel to peak, minutes	10
Peak exotherm, °F/°C	290/145

TYPICAL CAST MECHANICAL PROPERTIES* (2) see back page

		Test Method
Tensile Strength, psi	10,400	ASTM D 638
Tensile Modulus, psi	610,000	ASTM D 638
Tensile Elongation, %	2.1	ASTM D 638
Flexural Strength, psi	18,500	ASTM D 790
Flexural Modulus, psi	640,000	ASTM D 790
Heat Distortion Temperature, °F/°C @ 264 psi	150/65	ASTM D 648
Barcol Hardness	43-47	ASTM D 2583

*Typical properties are not to be construed as specifications.



DESCRIPTION

Vicast A540-DMB-12 is a prepromoted, non-thixotropic, polyester resin formulation made for use in cultured marble, granite and onyx applications. This product is specifically designed to give good demold times in marble applications while maintaining good color in onyx type castings, enabling the use of only one resin for both marble and onyx. It can be used for both flat and contoured molds.

FEATURES AND BENEFITS

The cure rate of Vicast A540-DMB-12 in marble applications is similar to that of a standard marble resin when used with the appropriate type and level of MEKP catalyst.

The color of Vicast A540-DMB-12 is superior in a marble matrix. A540-DMB-12 gives a bright, clean translucency in matrixes. Vicast A540-DMB-12 has excellent green strength for effective demold times in cultured marble and onyx.

While Vicast A540-DMB-12 is supplied at a high viscosity to facilitate maximum versatility in making small and large parts, it is also available at other viscosities and gel times.

Vicast® A540-DMB-12 Polyester Resin

PERFORMANCE GUIDELINES

A. Keep full strength catalyst levels between 1.25% - 2.0% of the total resin weight.

B. Maintaining shop temperatures between 65°F/ 18°C and 90°F/32°C and humidity between 40% and 90% will help the fabricator make a high quality part. Consistent shop conditions contribute to consistent gel times.

STORAGE STABILITY

Resins are stable for four months from date of production when stored in the original containers away from sunlight at no more than 70°F/21°C. After extended storage, some drift may occur in gel time.

During the hot summer months, no more than two months stability at 86°F/30°C should be anticipated.

SAFETY

See appropriate Material Safety Data Sheet for guidelines.

ISO 9001:2000 CERTIFIED

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2000 standards. This certification recognizes that each AOC facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

FOOTNOTES

(1)

The gel times shown are typical but may be affected by catalyst, promoter and inhibitor concentrations and resin, mold and shop temperature. Variations in gelling characteristics can be expected between different lots of catalysts and at extremely high humidities. Pigment and fillers can retard or accelerate gelation. It is recommended that the fabricator check the gelling characteristics of a small quantity of resin under actual operating conditions prior to use.



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