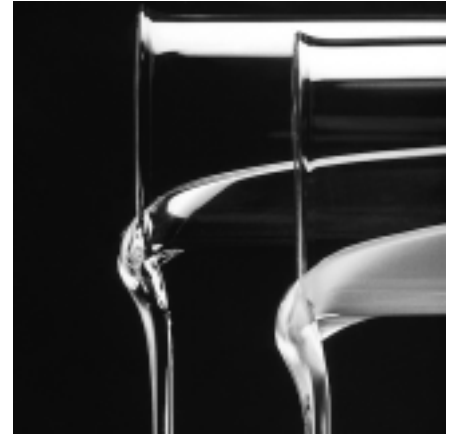


## Product Information

---

# Vicast® Polyester Resin for Casting Applications



### TYPICAL LIQUID RESIN PROPERTIES\*

	Nominal
Viscosity @ 77°F/25°C, LVSSA Brookfield Spindle #31 11.2g@ 60 RPM, cps.	475
Colour	Clear, Lt. Pink
Styrene Content, %	36
Specific Gravity @ 77°F/25°C	1.13

### TYPICAL CURING PROPERTIES OF A540-SCA-12-12\* (1) see back page

Gel time @ 77°F/25°C (1.0 % MEKP-9), minutes	12
Gel to peak, minutes	14
Peak Exotherm, °F/°C	320/160

### DESCRIPTION

AOC's Vicast® A540-SCA-12 is a pre-promoted, orthophthalic polyester resin formulation. This resin has been designed for use as a clear coating and surfboard laminating resin.

### FEATURES

- Low colour
- Fast gel time
- UV Stabilized

# Vicast® A540-SCA-12 Polyester Resin

## PERFORMANCE GUIDELINES

**A.** Keep full strength catalyst levels between 0.75% - 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.

### (2)

All tests at 77°F/25°C on unreinforced cured resin castings. Thixotropic components, if applicable, are excluded from casting samples. Castings were prepared using 1.25% MEKP, 0.125% Cobalt 12%, and post cured for 2 hours at 250°F/121°C using AOC test method X-12Ab.



950 HIGHWAY 57 EAST  
COLLIERVILLE, TN 38017

PHONE (901) 854-2800  
FAX (901) 854-7277

[www.aoc-resins.com](http://www.aoc-resins.com)

The information contained in this data sheet is based on laboratory data and field experience. We believe this information to be reliable, but do not guarantee its applicability to the user's process or assume any liability for occurrences arising out of its use. The user, by accepting the products described herein, agrees to be responsible for thoroughly testing each such product before committing to production.

Our recommendations should not be taken as inducements to infringe any patent or violate any law, safety code or insurance regulation.