

Product Information

Vicast® Flexible Orthophthalic Casting Resin

TYPICAL LIQUID RESIN PROPERTIES*

	Nominal
Viscosity @ 77°F/25°C, RVF Brookfield Spindle #3 @ 10 RPM, cps.	70
Thix Index	N/A
Specific Gravity @ 77°F/25°C	1.08
Color	Amber Clear
Styrene, %	48

TYPICAL CURING PROPERTIES* (1) see back page

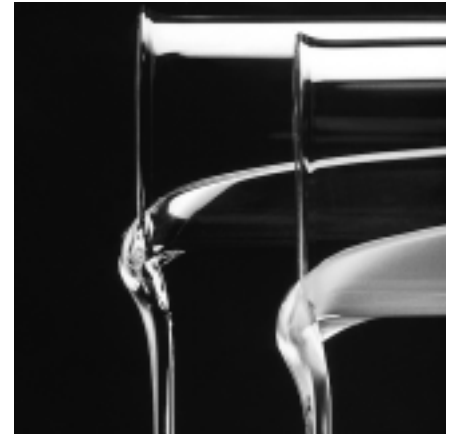
100 Gram Mass	
Catalyst, 1.0% Norac MEKP-9 ®	
Gel time @ 77°F/25°C, minutes	5.0
Gel to peak, minutes	13.5
Peak Exotherm, °F/°C	320/160

TYPICAL CAST MECHANICAL PROPERTIES* (2) see back page

		Test Method
Tensile Strength, psi/MPa	3,000/20.7	ASTM D 638
Tensile Elongation, %	64.6	ASTM D 638
Flexural Strength, psi/MPa	N/A	ASTM D 790
Flexural Modulus, psi/GPa	N/A	ASTM D 790
Heat Distortion Temperature, °F/°C @ 264 psi	N/A	ASTM D 648
Shore D Hardness	75	

*Typical properties are not to be construed as specifications.

**Data not available at time of printing.



DESCRIPTION

AOC's Vicast® A553-FKA-05 is a prepromoted, flexible, orthophthalic, polyester resin formulation.

FEATURES

AOC's® A553-FKA-05 acts as a binder resin for the production of simulated wood products using crushed pecan shells, wood flour, and similar materials.

APPLICATIONS

- Imitation wood castings
- Figurines
- Cast furniture parts

Vicast® A553-FKA-05 Polyester Resin

PERFORMANCE GUIDELINES

A. Keep full strength catalyst levels between 1.0% - 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

This product is stable for three months from the date of manufacture when stored in the original containers, away from direct sunlight or other UV light sources and at or below 25°C (77°F). Storage stability of two months or less should be anticipated if the storage temperature exceeds 30°C (86°F).

After extended storage, some drift may occur in the product viscosity and gel time.

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)

Based on tests of the unpromoted base resin used in the manufacture of 56-707 at 77°F/25°C. All tests performed on unreinforced cured resin castings. Thixotropic components, if applicable, are excluded from casting samples. Castings 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.

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.



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