

## Product Information

# Vicast® Polyester Resin for Marble Applications

### TYPICAL LIQUID RESIN PROPERTIES\*

|   | Nominal   |
|---|-----------|
| Viscosity @ 77°F/25°C LV SSA Brookfield |           |
| Spindle #4 @ 60 rpm, cps.               | 1,100     |
| Specific Gravity @ 77°F/25°C            | 1.13      |
| Uncatalyzed Stability                   |           |
| @ 77°F/25°C, months                     | 4         |
| Color                                   | Pale Gray |
| Styrene Content, %                      | 32        |

### TYPICAL CURING PROPERTIES OF A560-MGO-13\* (1) see back page

|                            |         |
|----------------------------|---------|
| Gel time @ 77°F/25°C       |         |
| (1.0%, M-50 MEKP), minutes | 13      |
| Gel to peak, minutes       | 12      |
| Peak exotherm, °F/°C       | 320/160 |

### TYPICAL CAST MECHANICAL PROPERTIES\* (2) see back page

|                              |              | Test Method |
|------------------------------|--------------|-------------|
| Tensile Strength, psi/MPa    | 10,350/71.4  | ASTM D 638  |
| Tensile Modulus, psi/GPa     | 625/4.31     | ASTM D 638  |
| Tensile Elongation, %        | 2            | ASTM D 638  |
| Flexural Strength, psi/MPa   | 17,075/117.7 | ASTM D 790  |
| Flexural Modulus, psi/GPa    | 640/4.41     | ASTM D 790  |
| Heat Distortion Temperature, |              |             |
| °F/°C @ 264 psi              | 159/71       | ASTM D 648  |
| Barcol Hardness              | 43-45        | ASTM D 2583 |

\*Typical properties are not to be construed as specifications.



### DESCRIPTION

Vicast® A560-MGO-13 is a prepromoted, non-thixotropic, polyester resin formulation made from a base resin specifically designed for general filled casting resin applications.

### FEATURES AND BENEFITS

- Fast gel time and good cure rate allow for high mold turnover resulting in greater productivity.
- Vicast® A560-MGO-13 has a low neutral color which can give a bright, clean, translucent look in the filled matrix.
- The high filler compatibility results in lower part costs
- Fast cure rates
- High filler acceptance
- Low color

# Vicast® A560-MGO-13 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 post cured.



North America  
northamerica@aoc-resins.com  
Toll Free: +1 (866) 319-8827  
[www.aoc-resins.com](http://www.aoc-resins.com)

### Global Contacts

|   |  |
|---|--|
| <b>Australia</b><br>australia@aoc-resins.com        | <b>Africa</b><br>africa@aoc-resins.com       |
| <b>Middle East</b><br>middleeast@aoc-resins.com     | <b>Asia/Australia</b><br>asia@aoc-resins.com |
| <b>Latin America</b><br>latinamerica@aoc-resins.com | <b>Europe</b><br>europe@aoc-resins.com       |

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