

NORSODYNE® 6397.111
Unsaturated Polyester Resin

APPEARANCE

Opaque blue-purple liquid resin

MAIN RESIN CHARACTERISTICS

Isophthalic unsaturated polyester
Thixotropic – Preaccelerated
Medium reactivity
Medium heat resistance
Medium chemical resistance
LLOYD's Register of Shipping approved
Water Byelaws Scheme approved (in
conjunction with suitable gel coat)

MOULDING INFORMATION

Hand lay up
Spray up

MAIN APPLICATION

General moulding
Marine

LIQUID RESIN PROPERTIES

(Typical values)

Specific gravity at 25°C:	1.10
Rotothinner viscosity at 25°C:	3.3 – 3.7 dPa.s
Volatile content:	43 – 47%
Reactivity at 20°C , 2% MEKP 50	
Gel time:	16 – 20 minutes
Reactivity at 23°C , 1% MEKP 50	
Gel time:	30 – 40 minutes

CURED RESIN PROPERTIES

NON REINFORCED

(Typical values)

Tensile ISO 527	
- strength:	75 MPa
- modulus:	3800 MPa
- elongation at break:	4%
Flexural ISO 178	
- strength:	90 MPa
- modulus:	3300 MPa
HDT ISO 75-2 A:	72°C
Barcol Hardness:	35 - 40 (Barcol 934-1)

SHELF LIFE

6 months

GUIDELINES BEFORE USE

Materials should be conditioned to a reasonable temperature (15°C minimum) prior to use. Resin should be agitated before use.

For further information please consult our Application Guide.

SAFETY PRECAUTIONS FOR HANDLING AND STORAGE

FOR FULL DETAILS PLEASE REFER TO SDS,

Polyester resins contain styrene monomer, classified as **HARMFUL** by inhalation and **IRRITATING** to eyes and skin. With a flash point **below 32°C**, polyester resins are classified with the proper shipping name 'resin solution, flammable' as determined by ADR Marginal 2301 Item 54. The current UK EH40 styrene occupational exposure limit is a MEL of 100ppm (8 hr TWA). And there is an industry, voluntary code of practice to work below 50 ppm. The Environmental Protection Act (1990,1995) must also be complied with. Resins should be stored cool, away from direct sunlight in closed containers. When stored in bulk, adequate venting of tanks is recommended together with a storage temperature not exceeding 20°C.