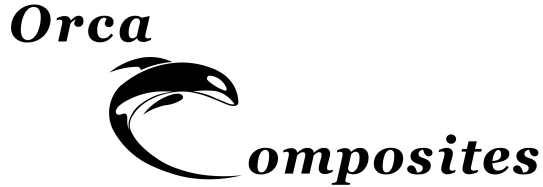


Orca 250 Surfboard/Greenhouse Resin



250

Description:

Orca 250 is an Ortho GP, thixotropic, polyester resin designed for fabrication of small to large FRP parts at an ambient temperature. Orca 250 is pre-promoted for curing at room temperature with the addition of methyl ethyl ketone peroxide (MEKP) initiator. Orca 250 is designed to be used for hand lay-up, spray-up and filament winding purposes.

Features:

- Extremely fast wet out and Roll out
- Low Exotherm
- Thixotropic
- Moderate trim time
- Early development of Barcol Hardness
- Translucent. (Semi-transparency)

Uses:

- Yacht/Boat Construction
- Surfboard
- Green House Applications
- Spray up process
- Hand Lay-up application

TYPICAL PROPERTIES *1

Uncured Resin

<u>Test</u>	<u>Value</u>
Viscosity, 77° F	400-600 cps
Specific Gravity, 77° F / 77° F	1.08-1.12
Curing Property, 77° F	1% MEKP 9% active ORCA 981
Gel Time 77° F	Varies
Time to Peak	Varies
Thix Index	2.3-2.8

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Cured Resin *2

<u>Test</u>	<u>Value</u>
Tensile Strength	7,252 psi
Tensile Modulus	449,617 psi
Flexural Strength	19,145 psi
Flexural Modulus	581,151 psi
Heat Distortion Temp	158° F
Barcol Hardness, 934-1	40
Water Absorption	.1%
Elongation	1.6%

* 1 Values are representative. Specification limits are available upon request.

* 2. Thickness: 3 mm

After Cure: 77°F x 6hrs, 176°F x 4hrs

Handling & Storage

As with all polyester resin, rate and degree of cure are a function of initiator concentration and of temperature. Resin and work area should be between 70°F and 95°F to ensure satisfactory results. Initiator levels should be within a range of 1.0-2.2% based on weight of resin. The use of initiator levels outside of this range may result in an inadequate cure, with laminates exhibiting moderate to severe post cure after demolding.

Orca 250 is available in 55-Gallon metal drums.

To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers at temperatures below 75°F and away from heat sources and sunlight. All storage areas and containers should conform to local fire and building codes. Drum stock should be stored away from all sources of flame or combustion. Inventory levels should be kept to a reasonable min with first-in, first-out stock rotation.

Safety

Read and understand the Safety Data Sheet before working with this product

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