

**Orca**



**omposites**

**425**

**Description:**

Orca 425 Marble resin is a medium reactivity pre-promoted dual-purpose casting resin. This resin has been specifically designed to be used to manufacturer both marble and onyx vanities. Orca 425 Marble resin is designed to provide extreme versatility in selecting the combination of gel time and viscosity that suits the specific manufacturing process, working conditions and raw materials.

**Features:**

- Low Color
- Low exotherm
- Good filler loading
- Fast cure

**Uses:**

- Casting
- Counter Tops
- Jewelry/Art
- Custom Crafts

**TYPICAL PROPERTIES\*1**

**Uncured Resin**

<b><u>Test</u></b>	<b><u>Value</u></b>
Viscosity, 77°F	550 - 650 cps
Curing Property, 77°F	1% MEKP 9% active ORCA 981
Gel Time 77°F	varies
Time to Peak	varies
Peak Exothermic Temp.	varies

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## Orca 425 Marble Casting Polyester Resin

### Liquid Resin\*2

<u>Test</u>	<u>Value</u>
Tensile Strength	12,600 psi
Tensile Modulus	630,000 psi
Tensile Elongation %	3.2%
Flexural Strength	21,400 psi
Flexural Modulus	630,000 psi
HDT	144°F
Barcol Hardness, 934-1	45-50

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

\*2 Variations in gelling characteristics can be expected between different lots of catalysts and at extremely high humidities.

### 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 425 is available in 55-Gallon metal drums and Totes.

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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