

## Orca 430 Marble Casting Polyester Swing Resin



# 430

**Description:** 430 Marble resin is a medium reactivity pre-promoted casting resin. This resin has been specifically designed to be used to manufacturer marble vanities, tubs or custom crafts.

**Orca** 430 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. This product comes in both waxed and un-waxed versions

### Features:

- Excellent crack resistance
- Fast cure time allowing for fast de-molding
- High filler loading with mixing viscosity
- Good dimensional stability
- Good Transparency
- Good pigment dispersion

### Uses:

- Counter Tops
- Bath-tub Casting
- Custom Crafts

### TYPICAL PROPERTIES \*1

#### Uncured Resin

#### Test

#### Value

Viscosity, 77° F	800-1200 cps
Curing Property, 77° F	1% MEKP 9% active Orca 981
Gel Time 77° F	Varies
Time to Peak	Varies
Peak Exothermic Temp.	Varies

The information herein is general information designed to assist customers in determining whether Orca products are suitable to their applications. Orca products are intended for sale to industrial and commercial customers. We require customers to inspect and test our products before use and to satisfy themselves as to contents and suitability for their specific applications. **Nothing herein constitute any warranty express or implied, including any warranty of merchantability or fitness for a particular purpose**, nor is any protection from any law or patent to be inferred. The exclusive remedy for all proven claims is limited to replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.

# Orca 430 Marble Casting Polyester Swing Resin

## Cured Resin \*2

<u>Test</u>	<u>Value</u>
Tensile Strength	7,977 psi
Tensile Elongation %	2.0%
Flexural Strength	14,940 psi
Flexural Modulus	609,159 psi
HDT	147°F
Barcol Hardness, 934-1	43

\*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 430 is available in 55-Gallon metal drums, Totes, Tankers.

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**

The information herein is general information designed to assist customers in determining whether Orca products are suitable to their applications. Orca products are intended for sale to industrial and commercial customers. We require customers to inspect and test our products before use and to satisfy themselves as to contents and suitability for their specific applications. **Nothing herein constitute any warranty express or implied, including any warranty of merchantability or fitness for a particular purpose**, nor is any protection from any law or patent to be inferred. The exclusive remedy for all proven claims is limited to replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.