



435

Description:

ORCA 435 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 435 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 post-curing time allowing for fast de-molding
- High filler loading with mixing viscosity
- Good dimensional ability
- Good Transparency
- Good pigment dispersion

Uses:

- Onyx Synthetic Marble
- Counter Tops
- Bath-tub Casting
- Custom Crafts
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TYPICAL PROPERTIES *1

Uncured Resin

Test

Viscosity, 77°F
 Curing Property, 77°F
 Gel Time 77°F
 Time to Peak
 Peak Exothermic Temp.
 Specific Gravity

Value

1000 - 1200 cps
 1% MEKP 9% active Orca 981
 varies
 varies
 varies
 1.1-1.14

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Orca 435 Marble Swing Resin

Cured Resin *2

<u>Test</u>	<u>Value</u>
Tensile Strength	10,298 psi
Tensile Modulus	449,617 psi
Flexural Strength	15,809 psi
Flexural Modulus	580,151 psi
Barcol Hardness, 934-1	45

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

*2 Thickness: 3mm; Post Cure: 77°F x 16hrs, 212°F x 2hrs

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 435 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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