

ORCA 456 Clear Casting Polyester Resin



456

Description:

Orca 456 is a pre-promoted, orthophthalic polyester resin. This resin has been designed for use as a clear casting resin. The clarity of this resin is exceptional and has been designed for thick castings.

Features:

- Good transparency and colorless
- Low Shrinkage
- Good dispersing of pigment and dimensional stability
- Excellent crack resistance

Uses:

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

TYPICAL PROPERTIES *1

Uncured Resin

Test

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

Value

450-550 cps
1% MEKP 9% active Orca 981
40 – 50min
57 – 67min
110°F

Cured Resin *2

Test

Tensile Strength
Tensile Modulus
Tensile Elongation
Flexural Strength
Flexural Modulus
HDT
Barcol Hardness, 934-1

Value

7,252 psi
478,625 psi
2.2%
13,053 psi
522,136 psi
144°F
40

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*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 456 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

Orca



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