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 C=Corrosion
 A/B=Acrylic Bonding
 V/R=Infusion/RTM
 GP=General Purpose
 LH=Low HAP below 35%
 VE=Vinyl Ester
 MC= Marble/ Casting Resin
 FR=Fire Retardant

ORCACOMPOSITES.COM
 General Purpose Marine Laminating Resins
 ABS & Acrylic Bonding Resins
 Filled and Fillable resins
 ISO Corrosion Resins
 Fire Retardant Resins (Ortho, Iso and V/E)
 Marble/Casting Resins
 RTM/Infusion/Closed Mold Resins
 Vinyl Ester Corrosion resins

ORCA PRODUCT #	100	1500	200	252	254	283
Type *1	V/R O/D	GP UV Surfboard	O GP	O GP	O/D GP	LH D
Gel Time	variable	variable	variable	variable	variable	variable
Viscosity, 77°F	150-200cps	420-480cps	340-400cps	625	525cps	570cps
Elongation %	2.00%	1.60%	1.80%	2.00%	2.40%	2.00%
Tensile Strength (psi)	9,936	7,097	8,942	8,000	10,900	9,000
Flexural Strength (psi)	17,032	18,736	17,174	15,000	17,400	14,000
Flexural Modulus (psi)	1,107,099	567,743	638,292	510,000	620,000	590,000
Barcol Hardness, 934-1	55	40	41	37	45-50	45-50
Heat Distortion Temp	165°F	158°F	162°F	140°F	160°F	203°F

ORCA PRODUCT #	249	213	301	401	452	456
Type *1	LH FILLABLE GP	FR O	C ISO	V/R ORTHO	A/B O	MC O
Gel Time	variable	variable	variable	variable	variable	30
Viscosity, 77°F	625	450	500cps	450	625	550 cps
Elongation %	2.20%	2.20%	2.70%	2.20%	2.00%	2.6%
Tensile Strength (psi)	8,400	10,700	12,100	9,200	8,000	12,420
Flexural Strength (psi)	13,300	15,400	18,400	16,780	15,000	19,770
Flexural Modulus (psi)	540,000	590,000	610,130	570,000	510,000	660,000
Barcol Hardness, 934-1	42	45	43	41	37	45-50
Heat Distortion Temp	178°F	194°F	224°F	162°F	140°F	144°F

ORCA PRODUCT #	501	502	510	511	515	555
Type *1	VE	FR VE	LH VE	V/R VE	LH VE BLEND	VE
Gel Time	Variable	Variable	Variable	Variable	Variable	Variable
Viscosity, 77°F	500cps	500cps	550cps	120-150cps	450-500cps	450-500cps
Elongation %	6.20%	2.90%	4.30%	3.90%	1.60%	2.90%
Tensile Strength (psi)	12,800	12,000	13,300	12,206	7,381	12,206
Flexural Strength (psi)	22,200	20,700	21,300	19,445	17,884	19,445
Flexural Modulus (psi)	500,000	530,000	540,000	603,227	757.086	603,227
Barcol Hardness, 934-1	39	54	42	54	51	54
Heat Distortion Temp	248°F	237°F	255°F	239°F	177°F	239°F

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