



254

Description:

Orca 254 is a Low Styrene, Low VOC Ortho/DCPD Marine GP, thixotropic, polyester resin designed for fabrication of small to large FRP parts at an ambient temperature. Orca 254 is pre-promoted for curing at room temperature with the addition of methyl ethyl ketone peroxide (MEKP) initiator. Orca 254 is designed to be used with both the spray-up and hand lay application technique.

Features:

- Extremely fast wet out and Roll out
- Low Styrene Ortho/DCPD
- Low VOC Ortho/DCPD (below 35% VOC)
- Thixotropic
- Moderate trim time
- Early development of Barcol Hardness
- Little or no pattern transfer through gel-coat surfaces

Uses:

- Yacht/Boat Construction
- Manufactured parts
- Spray up process
- Hand Lay-up application

TYPICAL PROPERTIES *1

Uncured Resin

<u>Test</u>	<u>Value</u>
Viscosity, 77° F	525 cps
Specific Gravity, 77° F / 77° F	1.11
Curing Property, 77° F	1% MEKP 9% active
Gel Time 77° F	Variable
Time to Peak	Variable
Peak Exothermic Temp.	

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

Cured Resin *2

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051254D_Orca 254 Low Styrene/Low VOC ORTHO/DCPD MARINE Polyester Resin

<u>Test</u>	<u>Value</u>
Tensile Strength	10,900 psi
Flexural Strength	17,400 psi
Flexural Modulus	620,000 psi
Elongation (%)	2.4%
Barcol Hardness, 934-1	45-50

Laminated Physical Properties *3

<u>Test</u>	<u>Value</u>
Tensile Strength	Pending
Flexural Strength	Pending
Flexural Modulus	Pending

* 2. Thickness : 3 mm
After Cure: 158° F × 6hrs

* 3. #450 Chopped Strand Mat 2 plies
#570 Roving Cloth 2 plies
Glass Content: 40 %
After Cure : 158° F × 6hrs

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 254 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 Material Safety Data Sheet before working with this product

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