

## 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:

- Extremely clear
- Low exotherm
- Very low tack surface
- Low VOC below 34%

### Uses:

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

### TYPICAL PROPERTIES \*1

#### Uncured Resin

<u>Test</u>	<u>Value</u>
Viscosity, 77° F	550 cps
Curing Property, 77° F	1% MEKP 9% active
Gel Time 77° F	30 min
Time to Peak	30 min
Peak Exothermic Temp.	155 C

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

#### Cured Resin \*2

<u>Test</u>	<u>Value</u>
Tensile Strength	12,420 psi
Tensile Modulus	630,000 psi
Tensile Elongation %	2.6%

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Flexural Strength	19,770 psi
Flexural Modulus	660,000 psi
HDT	144 F/62 C
Barcol Hardness, 934-1	45-50

### 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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