

NORSODYNE® M 18326

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Product type

Unsaturated polyester resin in styrene, Orthophthalic

Appearance

Yellow - Light - Transparent

Main resin characteristics

High reactivity

Main applications

BMC and SMC manufacture, very good mechanical properties

Moulding informations

Injection moulding, RTM

Shelf life and storage

Store in the shade, out of direct sunlight. Keep storage temperature below 25°C. Unseal container just before use. Shelf-life will be reduced reaching higher temperature.

Precaution for handling

Read carefully the Safety Data Sheet

Note

FEATURES OF THE LIQUID RESIN

Properties	Test Method	Unit	Typical values
Specific weight at 20°C		g/cm ³	1,10
Brookfield viscosity at 23°C, sp 2 rpm 50	MT-CU023V	mPa.s	140 -180
Solid content	MT-CU001C	%	52 - 56
Reactivity	at 40°C + 1,2% Co 1% + 2% Trx 524		
Gel time	MT-CU165R	min:sec	5:30 - 7:30
	MT-CU165R	minutes	6 - 10
Exothermic peak	MT-CU165R	°C	220 - 240
Shelf life at 23°C in the dark	MT-CU002S	months	9

PROPERTIES OF THE CURED UNREINFORCED RESIN

Curing cycle	16 h at 80°C + 2 h at 140°C		
Tensile strength	ISO 527 (2012)	MPa	40
Tensile modulus	ISO 527 (2012)	MPa	3900
Elongation at break	ISO 527 (2012)	%	1,15
Flexural strength	ISO 178 (2011)	MPa	100
Flexural modulus	ISO 178 (2011)	MPa	3900
HDT	ISO 75 -2A (2013)	°C	110

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