

## NORSODYNE® M 28070

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### Product type

Unsaturated polyester resin in styrene, Orthophthalic

### Appearance

NA - Light - Transparent

### Main resin characteristics

Thickenable with MgO

### Main applications

BMC and SMC manufacture, electric parts

### Moulding informations

Hot press moulding,  
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

<i>Properties</i>	<i>Test Method</i>	<i>Unit</i>	<i>Typical values</i>
<b>Specific weight at 20°C</b>		g/cm <sup>3</sup>	<b>1,12</b>
<b>Brookfield viscosity at 23°C, sp 2 rpm 10</b>	MT-CU023V	mPa.s	<b>1100 - 1300</b>
<b>Solid content</b>	MT-CU001C	%	<b>64 - 67</b>
<b>Reactivity</b>	at 130°C + 1% TBPB		
<b>Gel time</b>	MT-CU003R	min:sec	<b>1:30 - 1:50</b>
	MT-CU003R	min:sec	<b>2:10 - 2:30</b>
<b>Exothermic peak</b>	MT-CU003R	°C	<b>260 - 280</b>
<b>Shelf life at 23°C in the dark</b>	MT-CU002S	months	<b>9</b>

## PROPERTIES OF THE CURED UNREINFORCED RESIN

<b>Curing cycle</b>	16 h at 80°C + 2 h at 140°C		
<b>Tensile strength</b>	ISO 527 (2012)	MPa	<b>36</b>
<b>Tensile modulus</b>	ISO 527 (2012)	MPa	<b>3720</b>
<b>Elongation at break</b>	ISO 527 (2012)	%	<b>1,09</b>
<b>Flexural strength</b>	ISO 178 (2011)	MPa	<b>70</b>
<b>Flexural modulus</b>	ISO 178 (2011)	MPa	<b>3680</b>
<b>HDT</b>	ISO 75 -2A (2013)	°C	<b>122</b>

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