

NORSODYNE® M 28077

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Product type

Unsaturated polyester resin in styrene, Orthophthalic

Appearance

NA - Light - Transparent

Main resin characteristics

Thickenable with MgO

Main applications

General purpose,
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>
Specific weight at 20°C		g/cm ³	1,12
Brookfield viscosity at 23°C, sp 3 rpm 50	MT-CU023V	mPa.s	1500 - 1700
Solid content	MT-CU001C	%	65 - 68
Reactivity	at 130°C + 1% TBPB		
Gel time	MT-CU003R	seconds	55 - 75
	MT-CU003R	min:sec	1:20 - 2:00
Exothermic peak	MT-CU003R	°C	260 - 280
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	43,1
Tensile modulus	ISO 527 (2012)	MPa	3710
Elongation at break	ISO 527 (2012)	%	1,4
Flexural strength	ISO 178 (2011)	MPa	113
Flexural modulus	ISO 178 (2011)	MPa	3385
HDT	ISO 75 -2A (2013)	°C	127

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