PRODUCT BULLETIN

July 2023

POLYLITE® 33338 Series

Polyester Laminating Resins

DESCRIPTION

POLYLITE® 33338 Series are promoted, thixotropic, unsaturated polyester laminating resins. POLYLITE® 33338 Series are formulated for ambient curing with methyl ethyl ketone peroxide (MEKP) initiators for general purpose hand lay-up or spray-up applications.

BENEFITS & FEATURES

- Batch-to-batch consistency and uniformity from production utilizing Statistical Process Control (S.P.C) & Statistical Quality Control (S.Q.C) techniques
- Resistance to draining and sagging due to high thix index
- Ease of handling due to rapid wetting of reinforcements and low air entrapment
- Versatile and suitable for hand lay-up or spray-up applications

PROPERTIES – LIQUID

Property[1]	Unit	33338-00	33338-15	33338-50
Appearance	-	Grayish Pink/Opaque	Grayish Pink/Opaque	Grayish Pink/Opaque
NVM	%	62	63	59
Viscosity[2]	cps	600	600	500
Thix Index	-	2.75	3.0	3.0
Gel Time	minutes	39[3]	18[4]	25[5]
Gel to Peak	minutes	20	13	15
Peak Exotherm	°C/°F	129/265	157/315	150/302
Specific Gravity	-	1.11	1.13	1.11
Flash Point (Seta Closed Cup)	°C/°F	32/89	32/89	32/89

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer LVF #3 @ 60 rpm for versions 00, 15, and 50
3) 1.75 g of Arkema Luperox® DDM-30 per 100 g of resin for version 00
4) 1.25 g of United Initiators Norox® MEKP-9H per 100 g of resin for version 15
5) 1.5 g of United Initiators Norox® MEKP-9 per 100 g of resin for version 5

PROPERTIES – PHYSICAL

Property[1]	Unit	Neat Resin Casting[2]	Test Method
Tensile Strength	psi	7,000	ASTM D 638
Tensile Modulus	psi	540,000	ASTM D 638
Tensile Elongation	%	1.4	ASTM D 638
Flexure Strength	psi	14,000	ASTM D 790
Flexure Modulus	psi	590,000	ASTM D 790
Heat Deflection Temperature	°C/°F	57/134	ASTM D 648
Hardness, Barcol Model 934-1	HB	44	ASTM D 2583
Water Absorption - 2 hours at 212°F - 24 hours at 73°F	 % gain % gain	 1.07 0.17	ASTM D 570

1) Physical properties were determined using internal Polynt test methods that are similar to those listed above.
2) Initiator type and ratio: 1.75 g of Arkema Luperox® DDM-30 per 100 g resin; Cure conditions: 16 hrs. @ 73°F; Post-cure conditions: 2 hrs. @ 150°F, 2 hrs. @ 250°F

APPLICATION

Refer to Polynt's Composites Applications Guide ("Cookbook") for equipment and application recommendations. Each user must determine the suitability of this product to his/her particular mode of operation and intended end-use application. A Polynt representative will be available to assist in the proper selection of all Polynt products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of POLYLITE® 33338 Series is 120 days from the date of manufacture from Polynt. To maximize usage life and maintain optimum properties, resins and gel coats should be stored in the original closed container at temperatures below 23°C/73°F and away from ignition sources and sunlight. Keep containers sealed to prevent moisture pick-up and monomer loss.

SAFETY & WARRANTY

To receive a copy of our safety and warranty information, please email safetyandwarranty@polynt.com.