PRODUCT BULLETIN

June 2019

733-8650 Series

Unsaturated Polyester Laminating Resins

DESCRIPTION

733-8650 Series resins are general purpose laminating resins that are thixed and promoted for room temperature cure with methyl ethyl ketone peroxide (MEKP) initiator. This product complies with SCAQMD Rule 1162 and offers low styrene emission values using EPA's MACT "Unified Emission Factors" for a low HAPs or low VOC content resin system. Suggested applications include small to large job parts, difficult to process parts, mannequins and furniture, marine, and car and truck parts.

BENEFITS & FEATURES

- Low viscosity
- Non-draining
- Extended trim window
- Good wet-out and air release
- Good mechanical properties
- Monomer content less than 35%

PROPERTIES – LIQUID

Property[1]	Unit	733-8650-15	733-8650-18	733-8650-22	733-8650-25
Appearance	-	Brown	Brown	Brown	Brown
NVM	%	65	65	65	65
Viscosity[2]	cps	500	500	500	500
Thix Index[3]	-	3.5	3.5	3.5	3.5
Gel Time[4]	minutes	15	18	22	25
Gel to Peak	minutes	13	13	14	14
Peak Exotherm	°C/°F	138/280	138/280	135/275	135/275
Weight per Gallon	lbs/gal	9.1	9.1	9.1	9.1
Styrene Content	%	33	33	33	33

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer LVT Spindle #3 at 60 RPM
3) Brookfield Viscometer LVT Spindle #3 at 6/60 RPM
4) 1.25% MEKP-925

PROPERTIES – LIQUID (continued)

Property[1]	Unit	733-8650-28	733-8650-30	733-8650-32	733-8650-42
Appearance	-	Brown	Brown	Brown	-
NVM	%	65	65	65	-
Viscosity[2]	cps	500	500	500	500
Thix Index[3]	-	3.5	3.5	3.5	3.5
Gel Time[4]	minutes	28	30	32	42
Gel to Peak	minutes	14	14	14	-
Peak Exotherm	°C/°F	135/275	135/275	135/275	-
Weight per Gallon	lbs/gal	9.1	9.1	9.1	9.1
Styrene Content	%	33	33	33	33

5) All properties at 25°C/77°F unless otherwise noted
6) Brookfield Viscometer LVT Spindle #3 at 60 RPM
7) Brookfield Viscometer LVT Spindle #3 at 6/60 RPM
8) 1.25% MEKP-925

PROPERTIES – PHYSICAL

Property[1]	Unit	0.125" Clear Casting	Test Method
Tensile Strength	psi	9,000	ASTM D 638
Tensile Modulus	psi	549,000	ASTM D 638
Tensile Elongation	%	2.1	ASTM D 638
Flexure Strength	psi	16,000	ASTM D 790
Flexure Modulus	psi	556,000	ASTM D 790
Heat Deflection Temperature	°C/°F	92/198	ASTM D 648
Hardness, Barcol Model 934-1	HB	44	ASTM D 2583

1) Physical properties were determined using internal Polynt test methods that are similar to those listed above.

APPLICATION

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-Reichhold products available for commercial use.

SHELF LIFE & STORAGE

The shelf life of 733-8650 Series resins 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.