Technical Datasheet

INEOS Composites

AROPOL™ LP 67400 Series Low Profile Resin

AROPOL LP 67400 series resins deliver Class A automotive surface profiles in closed molding applications.

AROPOL LP 67400 resin offers room temperature processing, outstanding mechanical properties, lower exotherms, and superior storage stability as compared to traditional low profile resins. This resin also has exceptional shrinkage control and dimensional stability over a wide variety of part thicknesses.

Applications and Use

AROPOL LP 67400 resin is recommended for applications where "glass-like" surface profiles are desired using room temperature, closed molding applications such as infusion, RTM-Light, and press-molding.

INEOS Composites low profile technology enables manufacturers to create class-A surfaces once only possible with high temperature, automotive type processes. The vastly smoother surface created with AROPOL LP 67400 resin creates a far better reflection than that created with a traditional low profile resin.

The automotive industry considers an surface profile reading of less than 70 to be "Class A Automotive Finish." Fully post-cured test panels made with AROPOL LP 67400 resin score a reading of less than 40. Traditional low profile systems will yield scores of 90 and higher following post-cure.

Typical Liquid Resin Properties

Property[1] at 25°C (77°F)	Aropol LP 67400 INF-12	Aropol LP 67400 INF-18	Unit
Non-Volatiles Content	60	56	%
Viscosity, LVT #2 @ 60 rpm	130	90	mPas (cps)
Specific Gravity	1.04	1.06	gm/cc
Gel Time	13	18	min
Gel to Peak Time	6	6	min
Peak Exotherm Temperature	350	360	°F

(1) Properties are typical values and should not be considered an analysis of any specific lot.

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Gel Time Response to Different Catalysts

Typical gel times for AROPOL LP 67400 INF resin at 25°C (77°F), using various catalysts. When using blended catalysts with extended gel times, longer cycle times to demold are suggested to allow for ample cure. (1)

	Aropol LP 67400 INF-12	Aropol LP 67400 INF-18	Unit
DDM-9 @ 2% Geltime	11	16.5	min
DDM-9 @ 2% Gel to Peak	6	6	min
Azox @ 2% Geltime	10	NR	min
Azox @ 2% Gel to Peak	5	NR	min
NR = Not Recommended			

Typical Mechanical Properties

Property(1) of 0.125 inch laminate at 50% glass.	Value (US)	Method
Tensile Strength	31,000 psi	ASTM D638
Tensile Modulus	1,930 ksi	ASTM D638
Tensile Elongation	2.2%	ASTM D638
Flexural Strength	47,300 psi	ASTM D790
Flexural Modulus	1,810 ksi	ASTM D790
Heat Deflection Temperature	185°F	ASTM D648

Each end user should evaluate the performance of the resin in conjunction with their respective system, under conditions which simulate laminate design, production procedure and anticipated field exposure before use.

Standard Package

Steel Drum with Net Weight of 205 Kg (450 Lb)

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Commercial Warranty	Two months from date of manufacture, when stored in accordance with the storage conditions stated below.
Storage	Store at temperatures below 25°C (77°F). Storage life decreases with increasing storage temperature. Avoid exposure to heat such as direct sunlight or steam pipes. To avoid contamination of the product with water, do not store outdoors. Keep drums sealed to prevent moisture pick-up and monomer loss. Mild mixing is recommended after prolonged storage. Rotate stock. Bulk storage and handling best practices available upon request.
Notice	All information presented herein is believed to be accurate and reliable, and is solely for the user's consideration, investigation and verification. The information is not to be taken as an express or implied representation or warranty for which INEOS Composites assumes legal responsibility. Any warranties, including warranties of merchantability, fitness for use or non-infringement of intellectual property rights of third parties, are herewith expressly excluded. Since the user's product formulations, specific use applications and conditions of use are beyond the control of INEOS Composites, INEOS Composites makes no warranty or representation regarding the results which may be obtained by the user. It shall be the sole responsibility of the user to determine the suitability of any of the products mentioned for the user's specific application. INEOS Composites requests that the user reads, understands and complies with the information contained herein and the current Material Safety Data Sheet.

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