PRODUCT BULLETIN

November 2018

POLYLITE® PROFILE 33540-00

Shrink Controlled Tooling System

DESCRIPTION

POLYLITE® PROFILE 33540-00 is a shrink-controlled resin system with over 20-years of revolutionary mold making history; offering fast build times, lower cost and higher performance when building FRP tools. POLYLITE® PROFILE 33540-00 is a non-promoted, unsaturated polyester laminating resin system, that when properly formulated, will yield a MACT compliant tooling system, with minimal shrinkage; while perfectly reproducing master plugs.

BENEFITS & FEATURES

- Shrink-controlled materials that when properly formulated , allow for minimal shrinkage of less than 0.3% linear shrinkage per ASTM D-2556 (typically > 0.10% shrinkage is required for proper demold), while allowing for minimal surface distortion and fiber print through
- When formulated with 50% alumina trihydrate (A208 ATH from R.J. Marshal) filler will meet MACT compliance requirements for both marine and non-marine tooling applications
- Dramatically reduced mold build times and labor input in manufacturing molds, while also reducing post-finishing, sanding and buffing time with reduced labor costs as well
- Prototype and production molds can be built with less expense, and placed into production more quickly, documented to be up to 80% in less time and effort
- Color change indicator from cream to white color as mold cures, allows for ease of QC
- Fillable to 50% with ATH, results in lower mold costs and increased mold stiffness

PROPERTIES – LIQUID

Property(1)	Unit	33540-00
NVM	%	52
Viscosity(2)	cps	110
Gel Time(3)	minutes	20.5
Total Time to Peak	minutes	25.5
Peak Exotherm	°C/°F	217/422
Specific Gravity	g/cm^3	1.06
Flash Point (Seta Closed Cup)	°C/°F	32/89

1) All properties at 25°C/77°F unless otherwise noted
2) Brookfield Viscometer LVF Spindle #1 at 30 RPM
3) Gel Test: To 100 g resin, add 0.5 g promoter solution 46559-00, mix thoroughly then adjust to 25°C. Initiate with 1.25 g Norox® 750/100 g resin. Note this is for resin QC only. Refer to POLYLITE® PROFILE Application Guide for application details.

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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. A thorough formulating and application guide is available upon request.

SHELF LIFE & STORAGE

The shelf life of POLYLITE® PROFILE 33540-00 is 180 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.

RELATED PRODUCTS

OptiPLUS® 040-8089 and 040-8094 are pre-promoted, non-filled, shrink-controlled tooling resins.

SAFETY & WARRANTY

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