

Product Data



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R-0976

ISOPHTHALIC TOOLING RESIN

R-0976 Low Exotherm Tooling Resin represents a major advance in tooling products. R-0976 has the excellent strength and chemical resistance characteristic of isophthalic polyesters. The R-0976 Tooling Resin gives the user the option of building tooling in a more rapid manner with a faster build-up of the laminate possible due to its very low exotherm in a laminate.

R-0976 permits the build-up of several laminate layers in one step, thus reducing the time necessary to build an FRP mold. The Barcol hardness development is not influenced by the reduced exotherm and a rapid cure is obtained.

TYPICAL PROPERTIES OF R-0976 @ 77°F

Weight/Gallon:	8.80 Pounds
Specific Gravity:	1.06
Viscosity, Brookfield,	
@ 6 rpm:	1100-1500 cPs
@ 60 rpm:	400-500 cPs
Gel Time, 1% MEKP,	
100 gram mass:	15-20 minutes
1/8" Laminate gel time:	20-30 minutes
Typical Barcol hardness development	
in 1/8" Laminate, 35% glass,	
1.25% MEKP*,	
2 Hours	10-20
3 Hours	20-25
4 Hours	25-30
24 Hours	45+
Shelf Life, Uncatalyzed:	3 months minimum

*RCI 46-702 or Equivalent

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CLEAR 1/8" THICK CASTING

		<u>TEST METHOD</u>
Barcol Hardness:	45	----
Flexural Strength:	18,500 psi	ASTM D-790
Flexural Modulus:	5.65 x 10 psi	ASTM D-790
Tensile Strength:	8,200 psi	ASTM D-638
Elongation in Tension:	1.5%	ASTM D-638
Heat Distortion Temp (264 psi):	108°C.	ASTM D-648

APPENDIX I

This Low Exotherm Isophthalic Tooling Resin is available in several gel times to fit the needs of various fabricators. The following table lists these products and their corresponding cup gel times.

<u>PRODUCT</u>	<u>CUP GEL TIME (1.0% MEKP @ 77°F)</u>
R-0976	15-20 minutes
R-0985	20-25 minutes
R-0986	25-30 minutes