



PMC-9000

DESCRIPTION:

High viscosity unpromoted unsaturated polyester resin, designed for a variety of closed mold applications, where high gloss and surface smoothness are important.

USES:

Formulated for use in producing bulk molding compound (BMC), sheet molding compound (SMC) or wet molding pastes that will be press molded into a wide variety of parts.

TYPICAL LIQUID PROPERTIES:

Next values are for a reference guide only. Certain batches will not conform exactly to these numbers due to: storage conditions, temperature changes, batch age, test equipment and procedures; these

variables may affect deeply the evaluation results. Products with values outside of these numbers can perform acceptably. Final suitability of product is in the end use performance.

Test	Minimum Value	Maximun Value	Test Method
Non-Volatile Content (%)	68	74	TARQ-200
Brookfield Viscosity (cps) ²	4,100	4,800	TARQ-300
APHA Color	--	150	TARQ-610
Acid Number (solution)	--	30	TARQ-100
Gel Time, SPI (minutes) ¹	5	7	TARQ-800
Gel to Cure Time, SPI (minutes) ¹	2	5	TARQ-800
Exothermic Peak (°C) ¹	180	240	TARQ-800
Stability @ 120°C (hours)	1.5	--	TARQ-660
Appearance	Clear	Clear	Visual

¹ 2% BPO (paste at 50%) @ 82°C

² LVDV-E, spindle # 2, 6 rpm @ 25°C

CURE:

It is recommended that gel time be tested in the customer's plant, due to age, temperature, humidity and catalyst type / amount, will produce varied gel times.

This product will have use difficulty when temperature fall bellow 16°C, due to curing may be adversely affected. If any doubt, please contact our Technical Service Department.



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PHYSICAL PROPERTIES:

Polyester resin do not develop ultimate physicals, i.e. "cure" right away. Time and / or heat are needed. Heat may come from internal exotherm or external sources. The amount of catalyst will affect the cure. With time and / or heat, a "moderate cure" will develop into "ultimate physicals".

When the part reaches ultimate cure depends upon time, temperature and satisfactory catalyization. Too

much or too little catalyst can result in permanent under-cure, wich cannot be overcome.

Practically speaking, serviceable cure time will range from overnight to a week, and occasionally longer due to circumstances. Small and thickness laminates, properly catalyzed without exotherm or external heat can be delay months or years to get their last physical properties. Sufficient external heat can reduce the cure time to less than one day.

CAUTIONS:

Do not use air to mix, because it is not effective and moreover can produce contamination with water and oil. Do not add any material than the recommended fillers and catalyst for this product. If any doubt, please contact our Technical Service Department.

Warning: Avoid direct mixing of organic peroxide with metallic soaps, amines or any type of accelerator or promotor, because it can result on violent decomposition with fire or explosion.

STORAGE LIMITATIONS:

Uncatalyzed unsaturated polyester have a usage life of six months from date of manufacture when stored at 25°C or below, in a closed, factory-sealed,

opaque container and out of direct sunlight, heat sources or moisture. By each 7°C increment on temperature, usage life decrease to half.

SHIPPING:

Metallic, closed and sealed drums of 230 Kg or tank-wagons.

Last Revision: Apr/04/2013



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