



Crestamould[®] VE 679PA

DCPD - Modified vinyl ester resin for skin coats

Product Overview

Introduction

Crestamould[®] VE 679PA is a pre-accelerated, thixotropic, DCPD modified, vinyl ester resin.

Applications

Crestamould[®] VE 679PA was developed for use as a skin coat in marine and tooling applications when used with a minimum of one layer of 300gm/450gm CSM glass.

Features and Benefits

Crestamould[®] VE 679PA has excellent blister resistance and significantly reduces the occurrence of print through, to produce durable mouldings with an enhanced surface finish.

Approvals

Crestamould[®] VE 679PA is approved by Lloyd's Register of Shipping for use in the construction of craft under their survey.

Product Characteristics

Formulation

Crestamould[®] VE 679PA must be thoroughly stirred and allowed to attain workshop temperature (18° - 20°C) before use. It needs only the addition of a catalyst to start the curing reaction. Either Butanox LPT or Butanox M50 catalyst can be used, which should be added at 2% into the resin. The geltime of Crestamould[®] VE 679PA can be approximately determined from the table below.

Pot Life

Temperature	Pot Life in Minutes Using 2% Butanox LPT	Pot Life in Minutes Using 2% Butanox M50
15°C	50 minutes	50 minutes
20°C	28 minutes	34 minutes
25°C	18 minutes	23 minutes

Additives

The addition of pigment, fillers or other additives may adversely affect the resin properties. Users should consult Scott Bader's Technical Service Department before making any such additions.

Typical Properties

The following tables give typical properties of Crestamould® VE 679PA when tested in accordance with the appropriate BS or BS EN ISO test method.

Property	Unit	Liquid Resin
Colour		Red / Brown
Viscosity at 25°C 37.35sec ⁻¹	Poise	3.5
Viscosity at 25°C 4500sec ⁻¹	Poise	2.3
Specific Gravity @ 25°C	gcm ⁻³	1.065
Stability in the dark at 25°C	Months	6
Geltime at 25°C using 2% Butanox LPT	Minutes	18
Geltime at 25°C using 2% Butanox M50	Minutes	23

Property	Unit	Fully Cured Resin (unfilled casting)	
		*	**
Barcol Hardness (GYZJ 934 - 1)		23	35
Deflection Temperature under load (1.80 MPa)	°C	60	94†
Water Absorption 24hrs @23°C	mg	10	15
Tensile Strength	MPa	60	52
Tensile Modulus	GPa	2.7	3.0
Elongation at Break	%	4.3	2.1
Specific Gravity @ 25°C	gcm ⁻³	1.161	1.158

* Curing Schedule - 24hrs @ 20°C, 16hrs @ 40°C.

** Curing Schedule - 24hrs @ 20°C, 3hrs @ 80°C .

† Curing Schedule - 24hrs @ 20°C, 5 hrs @ 80°C, 3 hrs @ 120°C.

Additional Information

Storage

Crestamould® VE 679PA should be stored in the dark in suitable closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

Packaging

Crestamould® VE 679PA is supplied in 25kg and 200kg steel containers.

Health & Safety

Please see separate Materials Safety Data Sheet.



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