

Product Information

Highly Reactive Polyethylene Terephthalate Polyester Resin

TYPICAL LIQUID RESIN PROPERTIES*

	Nominal
Viscosity @ 77°F/25°C, Brookfield RVT Spindle #2 @ 20 rpm, cps	950 cps
Specific Gravity	1,111
Acid Number, Solids Basis	23
Color	Yellow Clear
Styrene, %	40

TYPICAL CURING PROPERTIES* (1) see back page

	Nominal
180°F/82°C SPI Gel Time	
150°F - 190°F, min	4.5
150°F - Peak, min	6.0
Peak Exotherm, °F/°C	470°F/243°C

TYPICAL MECHANICAL PROPERTIES* (2) see back page

		Test Method
Tensile Strength, psi/MPa	9,900/68	ASTM D 638
Tensile Modulus, psi/GPa	513,000/3.5	ASTM D 638
Tensile Elongation, %	2.4	ASTM D 638
Flexural Strength, psi/MPa	18,500/128	ASTM D 790
Flexural Modulus, psi/GPa	541,000/3.7	ASTM D 790
Heat Distortion Temperature, °F/°C @ 264 psi	284/140	ASTM D 648

*Typical properties are not to be construed as specifications.



DESCRIPTION

S404-60G is an unpromoted, highly reactive Polyethylene Terephthalate polyester resin.

AOC's S404-50G may be used for cold press molding, RTM, SMC/BMC or other applications where higher heat distortion temperature and mechanical properties are required.

FEATURES

- Contains renewable and/or recycled content.
- High reactivity
- Good mechanical properties
- Polyethylene Terephthalate recycle content
- Adaptable to a variety of fabrication processes and methods

APPLICATIONS

- Cold press molding
- RTM
- SMC/BMC
- Pultrusion

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EcoTek™ S404-60G Polyester Resin



PERFORMANCE GUIDELINES

A. Keep full strength catalyst levels between 0.75% - 2.0% of the total resin weight.

B. Maintaining shop temperatures between 65°F/18°C and 90°F/32°C and humidity between 40% and 90% will help the fabricator make a high quality part. Consistent shop conditions contribute to consistent gel times.

STORAGE STABILITY

Resins are stable for three months from date of production when stored in the original containers away from sunlight at no more than 70°F/21°C. After extended storage, some drift may occur in gel time.

During the hot summer months, no more than two month's stability at 86°F/30°C should be anticipated.

SAFETY

See appropriate Material Safety Data Sheet for guidelines.

ISO 9001:2000 CERTIFIED

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2000 standards. This certification recognizes that each AOC facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

FOOTNOTES

(1)

The gel times shown are typical but may be affected by catalyst, promoter, and inhibitor concentrations and resin, mold, and shop temperature. Variations in gelling characteristics can be expected between different lots of catalysts and at extremely high humidities. Pigment and fillers can retard or accelerate gelation. It is recommended that the fabricator check the gelling characteristics of a small quantity of resin under actual operating conditions prior to use.

(2)

All tests at 77°F/25° and 50% relative humidity. Castings were post cured.

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Our recommendations should not be taken as inducements to infringe any patent or violate any law, safety code or insurance regulation.