

## Product Information

# Polyester Resin for Closed Mold Processing and Pultrusion



### NEAT RESIN PROPERTIES\*

	Nominal
Viscosity @ 77°F/25°C, Brookfield RVT Spindle #2 @ 20 rpm, cps	950 cps
Weight Per Gallon @ 77°F/25°C	9.3/lb
Acid Number, Solids Basis	18 mg/g KOH
Non-Volatiles, %	65.0%

### TYPICAL CURING PROPERTIES\* (1) see back page

	Nominal
180°F/82°C SPI Gel Exotherm Test, 1% BPO	
150°F - 190°F/65.6 - 87.8°C, min	5.0
150°F/65.6°C - Peak, min	6.0
Peak Exotherm, °F/°C	475°F/246°C

### TYPICAL MECHANICAL PROPERTIES\* (2) see back page

		Test Method
Tensile Strength, psi/MPa	9,800/68	ASTM D 638
Tensile Modulus, psi/GPa	566,000/3.9	ASTM D 638
Tensile Elongation, %	1.5	ASTM D 638
Flexural Strength, psi/MPa	18,800/129	ASTM D 790
Flexural Modulus, psi/GPa	595,000/4.0	ASTM D 790
Heat Distortion Temperature, °F/°C @ 264 psi	289/143	ASTM D 648

\*Typical properties are not to be construed as specifications.

### DESCRIPTION

T341-68G is a high reactivity propylene maleate polyester resin for closed mold processing. Molecular weight distribution is tightly controlled to yield consistent results during processing and in final part performance. T341-68G can be combined with a wide variety of low profile additives to yield excellent surface aesthetics.

### FEATURES

- Contains renewable and/or recycled content.
- High reactivity
- Precise molecular weight distribution
- Proven performance in SMC, BMC and pultrusion applications
- Low color
- High gloss and excellent surface smoothness

### BENEFITS

Designed for demanding cure and surface requirements such as short press cycle times and thin pultrusion laminates.

Allows high filler loadings at workable mix viscosities.



# EcoTek® T341-68G 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 9001:2008 CERTIFIED

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2008 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.



955 Highway 57 East  
Collierville, TN 38017  
Toll Free: (866) 319-8827  
[www.aoc-resins.com](http://www.aoc-resins.com)

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