

## Product Information

# EcoTek® General Purpose Polyester Laminating Resin

### TYPICAL CAST MECHANICAL PROPERTIES\* see back page (1)

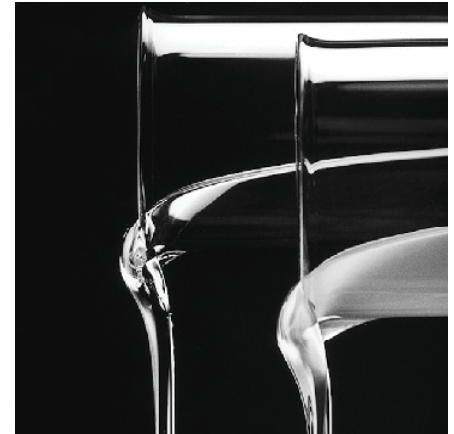
Test	Units of Measure	Nominal	Test Method
Tensile Strength	MPa	79	ISO 527-1
Tensile Modulus	GPa	4.1	ISO 527-1
Tensile Elongation	%	2.5	ISO 527-1
Flexural Strength	MPa	105	ISO 178
Flexural Modulus	GPa	4.2	ISO 178
Heat Distortion Temperature	°C	74	ISO 75-A

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

### TYPICAL LIQUID PROPERTIES at 25°C\* see back page (2)

Test	Units of Measure	Nominal
Viscosity, Brookfield LV #3 @ 60 rpm	cps	500
Thix Index, 6/60	-	3
Styrene Content	%	36
Gel Time, 100g, 1.25% KP-9	minutes	14
Peak Exotherm	°C	110

Note: H432-W Series is not intended for marine applications.



#### DESCRIPTION

AOC's EcoTek H432-AOAG-15 is a pre-promoted, thixotropic, general purpose medium reactive polyester resin.

#### APPLICATION

AOC's EcoTek H432-AOAG-15 is designed for use in the manufacturing of composite parts using hand lay-up application methods.

#### BENEFITS

##### Fast Cure

The medium reactivity of AOC's EcoTek H432-AOAG-15 resin allows for complete rapid cure of the composite even in relatively thin composites when used with the recommended peroxide levels and application temperature.

##### Superior mechanical properties

When used with the proper glass reinforcement content, AOC's EcoTek H432-AOAG-15 produces a composite with superior toughness properties that can assist in the reduction of composite cracking.

##### Contains Catalyst Indicator

##### Pigmented White

##### Styrene Suppressed



# EcoTek® H432-WZCG-14 Polyester Resin



## PERFORMANCE GUIDELINES

**A.** Keep full strength catalyst levels between 1.0% - 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 six months from date of production when stored in the original containers away from sunlight at no more than 21°C. After extended storage, some drift may occur in gel time.

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

## SAFETY

See appropriate Material Safety Data Sheet for guidelines.

## APPLICATION GUIDELINES

AOC's EcoTek H432-WZCG-14 provides good secondary bonding under normal conditions. However, exposing the laminate to direct sunlight, high temperatures, or dusty conditions can greatly reduce secondary bonding. The non air inhibited versions of EcoTek H432-WZCG-14 are designed to provide a good fast surface cure. Secondary bonding with these resins can be reduced over an extended period of time even under normal conditions. After an extended period of time it may be necessary to abrade the laminate to insure the maximum secondary bonding.

To assure adequate bonding to gel coats, fabricators should pre-wet the gel coat surface with a thin pass of catalyzed resin prior to lamination.

Chemical resistance studies indicate that resins like EcoTek H432-WZCG-14 have very poor resistance to certain hydrophobic liquids, such as hydrocarbons. Fuel storage tanks should not be produced with the EcoTek H432-WZCG-14 resin.

If your manufacturing needs require a more corrosion resistant resin, please contact your AOC representative for information or technical assistance on AOC's line of isophthalic or vinyl ester resins.

## 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)

Based on tests run at 77°F/25°C and 50% relative humidity. All tests performed on unreinforced cured resin castings. Thixotropic components, if applicable, are excluded from casting samples. Castings were post cured for 5 hours at 212°F/100°C using AOC test method X-12Ab.



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The information contained in this data sheet is based on laboratory data and field experience. We believe this information to be reliable, but do not guarantee its applicability to the user's process or assume any liability for occurrences arising out of its use. The user, by accepting the products described herein, agrees to be responsible for thoroughly testing each such product before committing to production.

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