

# TECHNICAL DATA SHEET

## RESIN ORTHO CLEAR CASTING

### PRODUCT IDENTIFIER

<b>Product Name:</b>	<b>Resin ORTHO Clear Casting</b> <b>1576987 Rev.0</b>
<b>Revision Date:</b>	<b>23-SEP-2025</b>

### MAIN CHARACTERISTICS

#### Product Type

Unsaturated polyester resin in styrene,  
Orthophthalic

#### Appearance

NA - Light - Transparent

#### Main Applications

Inclusion

#### Main Resin Characteristics

Light stabilized  
Low reactivity  
Low viscosity  
Preaccelerated

#### Mouldings Information

Casting

#### Shelf Life & Storage

Store in the shade, out of direct sunlight. Keep storage temperature below 25°C.  
Unseal container just before use. Shelflife will be reduced reaching higher temperature.

#### Precautions for Handling

Read carefully the Safety Data Sheet  
Stir the resin before use, without introducing air

### FEATURES OF THE LIQUID RESIN<sup>(1)</sup>

PROPERTIES	TEST METHOD	UNIT	TYPICAL VALUES
Specific weight at 20°C		g/cm³	1,12
Brookfield viscosity at 23°C, sp 2 rpm 50	MT-CU023V	mPa.s	310 - 390
Solid content	MT-CU001C	%	62,5 - 66,5
Reactivity	at 25°C + 0,5% CH <sub>3</sub> Ph		
Gel time <sup>(2)</sup>	MT-CU019R	minutes	18 - 22
23°C - Peak	MT-CU019R	minutes	55 - 80
Exothermic peak	MT-CU019R	°C	145 - 165
Storage stability at 23°C in the dark	MT-CU002S	months	6

# TECHNICAL DATA SHEET

1) Thoroughly test in your applications before full-scale use. Geltimes may vary due to the reactive nature of these materials and due to different brands of curing additives. Always test on small scale before formulating large quantities.

2) If present, Cobalt is herewith intended as octoate. Use of different Cobalt salts could result in different geltimes. Always test on small scale before formulating large quantities

## PROPERTIES OF THE CURED UNREINFORCED RESIN<sup>(3)</sup>

PROPERTIES	TEST METHOD	UNIT	TYPICAL VALUES
Curing cycle	16 h at 40°C (+ 2 h at 120°C for HDT)		
Tensile strength	ISO 527 (2012)	MPa	40
Tensile modulus	ISO 527 (2012)	MPa	3500
Elongation at break	ISO 527 (2012)	%	1,4
Flexural strength	ISO 178 (2011)	MPa	105
Flexural modulus	ISO 178 (2011)	MPa	3150
HDT	ISO 75-2A (2013)	°C	50

3) Properties are typical values, based on material tested in our laboratories, but varies from sample to sample. Typical values should not be construed as a guaranteed analysis of any specific lot or as specification items.

# TECHNICAL DATA SHEET

## DISCLAIMER

The information contained in this document (which is to be intended only for explanatory purposes) is correct and accurate and is based on our technical and scientific knowledge and on literature at the date of publication. Such information relates only to use of the products in the pure state and for the purposes stated herein. Nothing in the information contained in this document shall be deemed to be a warranty or a representation (explicit or implicit) by the manufacturer, and/or taken or construed as infringing of any existing patents. The manufacturer shall not be under any liability or responsibility for any of the information provided under this document or for any errors, omissions or misstatements, even with regard to results to be obtained through the use of the aforesaid information.

This information is provided in good faith and every reasonable effort is made to ensure that it is accurate and up-to-date. Tricel Composites (GB) Ltd. shall not be liable for any damage arising, directly or indirectly, from the use of the information contained herein. It is issued on the condition that the user will determine the safety and suitability of this product for their purposes before use. Regulations are country-specific and local information should be sought before placing your product on the market.

### **Tricel Composites (GB) Limited**

Unit A, Foxway,  
Off Atkinson Street,  
Leeds, West Yorkshire,  
LS10 1PS.

**Tel:** +44 (0)113 270 3133

**Email:** [sales@tricelcomposites.co.uk](mailto:sales@tricelcomposites.co.uk)

### **Tricel Composites (NI) Limited**

Unit 4, Milltown Ind. Estate, Greenan Road.  
Warrenpoint, Newry  
Co. Down,  
BT34 3FN.

**Tel:** +44 (0)284 175 3738

**Email:** [sales@tricelcomposites.co.uk](mailto:sales@tricelcomposites.co.uk)