TECHNICAL DATA SHEET

RESIN ORTHO CLEAR CASTING

PRODUCT IDENTIFIER

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

MAIN CHARACTERISTICS

Product Type Main Resin Characteristics

Unsaturated polyester resin in styrene, Light stabilized Orthophthalic Low reactivity

Appearance Low viscosity
Preaccelerated

NA - Light - Transparent

Mouldings Information

Main Applications Casting

Inclusion

Shelf Life & Storage

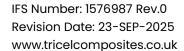
Store in the shade, out of direct sunlight. Keep storage temperature below 25°C. Unseal container just before use. Shelflife will be reduced reaching higher temperature.

Precautions for Handling

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

FEATURES OF THE LIQUID RESIN⁽¹⁾

PROPERTIES	TEST METHOD	UNIT	TYPICAL VALUES
Specific weight at 20°C		g/cm³	1,12
Brookfield viscosity at	MT-CU023V	mPa.s	310 - 390
23°C, sp 2 rpm 50			
Solid content	MT-CU001C	%	62,5 - 66,5
Reactivity	at 25°C + 0,5% CHeP		
Gel time ⁽²⁾	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	MT-CU002S	months	6
in the dark			





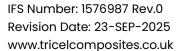
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- 1) Thoroughly test in your applications before full-scale use. Geltimes may vary due to the reactive nature of these materials and due to different brands of curing additives. Always test on small scale before formulating large quantities.
- 2) If 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(3)

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)	МРа	40
Tensile modulus	ISO 527 (2012)	МРа	3500
Elongation at break	ISO 527 (2012)	%	1,4
Flexural strength	ISO 178 (2011)	МРа	105
Flexural modulus	ISO 178 (2011)	МРа	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.





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