

RESIN	HARDENER	MIXING RATIO
E 386 Component A	MEKP Component B	100:2

DESCRIPTION: Unsaturated orthophalic acid based polyester resin dissolved in styrene and pre-accelerated. This resin combines good mechanical characteristics and low shrinkage with excellent moistening of reinforcement fibers and mineral fillers.

APPLICATIONS The E 386 resin is recommended for the construction of bodywork, sanitary items, helmets, industrial machine parts, and other items that require good mechanical characteristics. Due to its rheological features, it is mainly used for the manual forming of flat items, for press moulding at low to medium temperatures, for the casting of ornamental or sanitary items, or for the production of synthetic marble and agglomerate marble.

PROCESSING: Manual forming. Its low polymerization shrinkage allows the creation of substantial thickness .

INSTRUCTIONS: Verify and, when necessary, homogenize the components before use. Add the proper quantity of the hardener to the resin, mix carefully. Avoid air trapping. For the surface preparation (mould or model) refer to the release agents data sheet.

STORAGE AND PRECAUTIONS: If the product is stored in the dark in its original container, perfectly sealed and at a maximum temperature of 20°C, it is stable for at least 6 months from the date of production. Longer periods of storage, or in conditions other than those defined above, may alter the product's characteristics and compromise its use.

TYPICAL SYSTEM CHARACTERISTICS

PROCESSING DATA	
Density at 20°C PK03	gr/cm ³ 1.1 ± 0.1
Solid content PK04	% 64 ± 2
Brookfield viscosity at 25 °C (19.6 sec-1) PK01	mPa·s 450 ± 50
Gel time* PK02	minutes 6.5 ± 1
Exothermic peak time* PK02	minutes 16 ± 2
Exothermic peak temperature * PK02	°C 165 ± 5

*Hardening at 25 °C with 2% MEKP

Note: All reasonable care was taken when drafting the above technical information and notes. The data provided is based on laboratory tests and trade experience.

Nevertheless, these notes do not represent any form of explicit or implied warranty for the use of products supplied, nor for the characteristics of finished goods due to the fact that these characteristics can be influenced by the conditions of application.