

RESIN	HARDENER	MIXING RATIO
R 601 Component A	MEKP Component B	100:2

**DESCRIPTION:** Styrene-dissolved, thixotropic, pre-accelerated, orthoophthalic acid based polyester resin. Excellent impregnation features and mechanical characteristics.

**APPLICATIONS** It is designed for the most critical applications for a thermosetting resin. Resin R 601 is suitable for the production of car parts, shipbuilding, helmets, industrial parts and all other products requiring high resistance.

**PROCESSING:** Based on its rheologic characteristics, resin R 601 is suitable for hand lay-up and spray-up, when a complete and quick reinforcement impregnation is required. Resin R 601 has been certified by the Italian Naval Register as a component of composite materials to be used for hull building (homologation certificate number DIP/216/98/3).

**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:** The resin can be used for at least four months from the date shown in the analysis certificate of its production batch, if properly stored (at less than 25°C and protected from light in closed containers).

**TYPICAL SYSTEM CHARACTERISTICS**

PROCESSING DATA	
Density at 20°C PK03	g/cm <sup>3</sup> 1.1 ± 0.1
Solid content PK04	% 59 ± 2
Brookfield viscosity at 25 °C (0.98 sec-1) PK01	mPa·s 2100 ± 600
Brookfield viscosity at 25 °C (9.8 sec-1) PK01	mPa·s 550 ± 150
Gel time* PK02	minutes 11 ± 3
Exothermic peak time* PK02	minutes 20 ± 4
Exothermic peak temperature* PK02	°C 160 ± 10

\*Hardening at 25 °C with 2% MEKP 50%

**TYPICAL CURED SYSTEM PROPERTIES**

PROCESSING DATA	
Density at 23°C ASTM-D 792	g/cm <sup>3</sup> 1.2 ± 0.1
Barcol hardness ASTM-D 2583	38 ± 3
Linear shrinkage PK06	% 2.6 ± 0.3
Elongation at break UNI EN 61	% 2.5 ± 0.2
HDT ISO 75-2 1993	°C 75 ± 5

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.