

POLYLITE 2035 PASLSE

PDS107/114

refer to MSDS 2035PASLSE

FAST WET-OUT, LOW STYRENE EMISSION GENERAL- PURPOSE, POLYESTER RESIN

DESCRIPTION

POLYLITE 2035 PASLSE is a rigid, medium reactivity, thixotropic, low styrene emission orthophthalic unsaturated polyester resin with a blue catalyst colour change indicator. **POLYLITE 2035 PASLSE** is preaccelerated and of medium cure rate. The resin has a built in accelerator system that gives medium long geltime and good reactivity in medium thick laminates (3-8mm) layed wet in wet without creating too high laminate peak exotherm.

POLYLITE 2035 PASLSE contains special additives which improve the Working environment during and after application due to substantially reduced styrene evaporation.

POLYLITE 2035 PASLSE is designed for application by hand lay-up and spray-up and is suitable for all general purpose composite applications.

FEATURES	BENEFITS
Low styrene emission	Improves safety by reducing styrene levels in the work place
Excellent interlaminar adhesion	Delays of up to 7 days between consecutive layers
Excellent wet out of glass fibres	Easy to roll out
Thixotropic	Minimal drainage
Non air-inhibited – contains wax	Cures to a tack-free finish
Specially promoted	Predictable geltime and cure rate
Blue colour change mechanism	Confirms catalyst addition
Heat Distortion Temperature above 80°C	Good heat resistance

OTHER VERSIONS

POLYLITE 2035 PAWLSE	Shorter geltime version for winter conditions
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TYPICAL LIQUID PROPERTIES

PROPERTY	SPECIFICATION
Relative density 25°/25°C	1,09 - 1,11
Viscosity at 25°C, cps	2000 - 3000
Viscosity at 25°C, cps (Cone and Plate)	220 - 260
Acid value, mg KOH/g	19.5 – 26
Volatile content, %	39 - 43
Geltime at 25°C, using 1 phr* BUTANOX M50, minutes	30 - 37
Styrene Emission after 60 min @ 22°C g/m ²	13
Liquid appearance	Opaque blue
Stability in the dark at 25°C, months	6 minimum
*phr = parts per hundred resin, by weight	

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CURING CHARACTERISTICS

POLYLITE 2035 PASLSE needs only the addition of catalyst to start the curing reaction. The resin must be allowed to attain workshop temperature (23°C) before being formulated for use. The correct amount of catalyst is therefore added and thoroughly stirred into the resin shortly before use. Low styrene emission resin **POLYLITE 2035 PASLSE** is designed to reduce the emissions of styrene monomer during the period following completion of lamination of GRP products, and during the curing of laminates on their moulds. The emissions of styrene monomer will not be reduced during spraying of the resin, or during mixing of resins, or rolling of laminates. The ambient temperature and the amount of catalyst control the geltime of the resin formulation. This can be approximately determined from the table below which shows the geltime of 100 parts by mass of **POLYLITE 2035 PASLSE**, containing 1, 1.5 and 2 phr BUTANOX M50.

GELTIME CHART

Catalyst level (phr)	Geltime on 100g casting at the given temperature.				
	15°C	20°C	25°C	30°C	35°C
1 phr Butanox M50	75	45	33	20	14
1.5 phr Butanox M50	41	26	18	14	10
2 phr Butanox M50	36	21	13	11	8

Curing should not be carried out at temperatures below 15°C. Ideally, the catalyst level should range between 1 and 2 phr.

INTER-LAMINAR ADHESION

POLYLITE 2035 PASLSE has been tested and found to have good inter-laminar adhesion. When a laminate is built up in stages with intervals that allow intermediate curing, each layer should be finished with the correct resin to glass ratio. Any surface having an excess of resin must be abraded and thoroughly cleaned before further laminating is commenced. During construction, using a normal resin/glass fibre ratio, it has been found that an interval of 7 days is acceptable between laminate layers, provided that suitable control of the environmental conditions as per *Lloyds Register are applied. Beyond this period it is essential to abrade the laminate surface to form a mechanical key prior to continuing. (* "Rules and Regulations for Special Service Craft", July 2002, Part 8.)

POST-CURING

Many satisfactory laminates can be made from **POLYLITE 2035 PASLSE** by curing at ambient temperature (but not less than 15°C). When optimum properties and long-term performance are required however, the laminate should be post-cured.

After release from the mould, laminates should be allowed to mature for 24 hours at workshop temperature (23°C). They should then be post-cured for 3 hours at 80°C, although a longer period at a lower temperature will give almost the same result. The post-cure is most effective if it is carried out immediately after the 24 hour maturing period.

FILLERS

The addition of fillers to **POLYLITE 2035 PASLSE** could affect the low styrene emission performance of the resin. Fillers should be accurately checked for moisture content and effect on geltime and cure rate before use.

**TYPICAL
PHYSICAL
PROPERTIES**

Typical Properties of POLYLITE 2035 PASLSE (unfilled castings) Post-cured 24 hours at ambient , 2 hours at 55°C and 2 hours at 80 °C	
Temperature of deflection - under load (1,80 MPa), °C	90
Water absorption:	
a) Increase in mass after 28 days immersion, mg	100
b) Loss in mass after drying, mg	45
Barcol (GYZJ 934-1) hardness	45
Tensile strength, MPa	76
Flexural strength, MPa	84
Flexural modulus, MPa	3 930
Compressive strength, MPa	152

**STORAGE
AND
HANDLING**

To ensure maximum stability and maintain optimum properties, polyester resin should be stored in closed containers, maintained below 25°C and away from heat sources and sunlight. All storage should conform to local fire and building codes. Drum stock should be kept to a reasonable minimum with first-in, first-out stock rotation.

Where bung-in-head containers are stored outside, it is recommended that these be stored in a horizontal position to avoid the ingress of water.

**STANDARD
PACKAGE**

Non-returnable metal drums.
1000 litre IBC's
Bulk supplies can be delivered by road tanker.

**MATERIAL
SAFETY
DATA SHEET**

A Material Safety Data Sheet is available from your NCS Resins' representative. Make certain that you obtain a copy of this guide to the safe handling of unsaturated polyester resins and resin systems.

PLEASE READ AND UNDERSTAND THE MATERIAL SAFETY DATA SHEET BEFORE WORKING WITH THIS PRODUCT

WARNING: CARE MUST BE TAKEN TO AVOID DIRECT MIXING OF ANY ORGANIC PEROXIDE (CATALYST) WITH METAL SOAPS, AMINE OR ANY OTHER POLYMERISATION ACCELERATOR OR PROMOTER, AS VIOLENT DECOMPOSITION WILL RESULT!

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