

ICOM MC RESIN GR 9000-27 XTA

CHARACTERISTICS

ICOM Resin GR 9000-27 XTA is a medium reactivity, low viscosity, pre-accelerated, promoted, thixotropic orthophthalic polyester resin based on orthophthalic acid and standard glykols containing fading dye indicator and LSE additive.

ICOM Resin GR 9000-27 XTA is designed to have:

- Reduced styrene emission
- Excellent surface finish
- Easier Vertical surface applications
- Minimal Sagging
- Fading dye indicator for catalyst addition

ICOM Resin GR 9000-27 XTA contains additives which form a barrier film during the lamination process to reduce emission of styrene without loss of secondary bond strength. As a precaution, it is recommended to sand the base laminate before over-laminating it.

USE

ICOM Resin GR 9000-27 XTA is ideally suited for spray-up application. A suitable laminate thickness of 2 – 6 mm at a time is recommended to achieve the desired results.

Component made from **ICOM Resin GR 9000-27 XTA** exhibit excellent surface finish along with very good hydrolytic stability and resistant to neutral and acidic salts as well as weak oxidizing acids.

LIQUID RESIN PROPERTIES

Property	Nominal Values	Test Method*
Appearance	Hazy Blue Color Viscous Liquid	AM-113
Relative Density @25 °C	1.08 ± 0.01	AM-103
Viscosity ¹ @ 25 °C, cP	900 ± 100	AM-101
Thixotropic Index (2/20)rpm	3.5 - 4.5	AM-101
Acid Value, mg KOH/g	< 20	AM-102
Volatile Content, (w/w) %	44 ± 2	AM-106

CURING RESIN CHARACTERISTICS

Standard Gel Time Test² @ 25 °C

Property	Nominal Values	Test Method*
Gel Time, minute	15 - 20	AM-110
Peak Exotherm Temp., °C	> 150	AM-110
Total Time to Peak Temp., minute	25 - 35	AM-110

Note:

* Internal Test Method, available on request

1: By Brookfield Viscometer, Sp. No 2, 20 rpm

2: Determined with 100 g resin mass using 1.0 % v/w Butanox M-50

3: Unfilled Cast is prepared by Catalysing resin with 1.0 % v/w Butanox M 50 and curing at room temperature for 24 hours followed by post curing for 4 hours at 65 °C

Butanox M-50: Methyl Ethyl Ketone Peroxide, from Akzo Nobel

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PROPERTIES OF CURED RESIN (UNFILLED CAST)³

Property	Nominal Values	Test Method*
Specific Gravity	1.20	IS 6746:1994
Tensile Strength, MPa	60	ISO 527-2
Tensile Modulus, MPa	3550	ISO 527-2
Elongation at Break, %	2.0	ISO 527-2
Flexural Strength, MPa	110	ISO 178
Flexural Modulus, MPa	3000	ISO 178
Heat Deflection Temperature, °C Fully cured	85	ISO 75-2
Barcol Hardness	45	ASTM 2583

PACKAGING

ICOM Resin GR 9000-27 XTA is supplied in nonreturnable M.S. drums containing 220 kg or returnable IBCs containing 1.0 MT

STORAGE AND HANDLING

ICOM Resin GR 9000-27 XTA should be stored in a cool and dry place away from sunlight, preferably below 25 °C. Under these conditions, the shelf life is 6 months. The storage stability could be further improved by aerating the resin stored in barrels at an interval of about a fortnight.

ICOM Resin GR 9000-27 XTA has a flash point of 32 °C and is classified as flammable. Containers should be kept in a cool and ventilated place away from sunlight and sources of ignition. "No Smoking" rules should be strictly enforced. In case of fire, use dry chemical, foam, carbon dioxide or water spray to extinguish the flame. Spillages may be absorbed onto sand or earth and shoveled off and disposed according to local disposal regulations.

Skin contact and vapor inhalation should be avoided during moulding because of the presence of styrene monomer. In case of irritation in the eye or skin, wash with copious amount of water. In extreme case, seek immediate medical advice. The moulding area should be sufficiently ventilated for reducing the vapour levels in the air while compounding and moulding.

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All information is given, based upon our best knowledge, but without liability to us. Data has been obtained by laboratory experiments made by our supplier. Since the condition under which the product is consumed is outside of our control, the product should be tested before use.