

# Product Data



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## ISOPHTHALIC RESIN GLUE

HK Research Corporation offers several Isophthalic Resin Glues designed for use in seaming and bonding of densified castings. Each of these products is formulated from a highly resilient, tough Isophthalic polyester resin and promoted for BPO-cure to ensure a strong durable bond even in very thin seaming films.

The HK Research products listed below differ only in their viscosities which cover a wide range of application techniques. All of these products have been formulated to give the same working time of about twelve minutes when catalyzed with 2.5% of BPO emulsion (40%) such as RCI Superox 46-744 or Cadox 40E.

### TYPICAL PROPERTIES OF LIQUID GLUE

Color	Light Amber
Viscosity	See Table Below
Weight Per Gallon	9.45 lbs.
Specific Gravity	1.14
Stability, Uncatalyzed, 77°F	3 months minimum

<u>PRODUCT CODE</u>	<u>VISCOSITY</u>	<u>CUP GEL TIME</u>
R-1248	40,000-55,000 cps	12-15'
R-1249	12,000-15,000 cps	12-15'
R-1250	Very Thick Putty	12-15'
R-1251	55,000-75,000 cps	12-15'
R-1252	14,000-18,000 cps	12-15'
R-1254	14,000-18,000 cps	10-12'
R-1255	14,000-18,000 cps	12-15' – NAI

There are a number of different Benzoyl Peroxide catalysts available in today's market and we are attempting to test a number of these. To date, we have tested the following Benzoyl Peroxide catalysts in our Isophthalic Resin Glues with very successful results:

AKZO Cadox 40E	40% BPO (pourable)
RCI Superox 46-744	40% BPO (pourable)
BENOX L40-LV	40% BPO (pourable)

As more BPO catalysts are evaluated with HK Research Corporation's Isophthalic Resin Glues, we will share this information. Meanwhile, we recommend that you consult your HK Research sales representative or our laboratories at 1-800-334-5975 for information on the feasibility of using a particular BPO catalyst with this resin.

### **SAFETY CONSIDERATIONS**

HK Isophthalic Resin Glues are based on a resin, which contains styrene monomer, which is a flammable liquid. Keep away from sparks, heat and open flame (including pilot lights). Electrical equipment should be vapor-proof and protected from breakage.

Styrene vapors are heavier than air and will tend to concentrate floor area. To keep vapors within a safe limit in all areas, adequate ventilation or suction fans should be used that will remove these styrene monomer vapors.

#### **All equipment must be grounded - including spray guns and molds.**

Both the polyester resin and the catalyst may cause burns to eyes and skin. Avoid contact with the eyes! Avoid breathing vapors! Gel coat applicators should wear a NIOSH approved respirator effective for vapors, spray mist and dust. In case of accidental contact, remove contaminated clothing and wash affected skin areas with soap and copious quantities of water. Contact a physician if persistent skin irritation occurs. For eyes, immediately flush with plenty of water for at least 15 minutes; call a physician immediately. Wash contaminated clothing before reusing.