

TECHNICAL DATA SHEET

RS6060LP – POLYESTER PREFILLED LP TOOLING RESIN

RS6060LP is an unsaturated polyester-based resin, loaded and pre-accelerated with a low styrene content and low profile additive to guarantee shrinkage close to 0.

It is designed for the rapid production of the laminate with excellent surface finish results and high dimensional stability of the moulds.

RS6060LP is particularly suitable for the layering of moulds intended for the production of articles by infusion; characterized by a linear shrinkage close to 0 and by excellent thermo-mechanical performances.

GENERAL INSTRUCTIONS FOR USE

Manual lamination

- Apply a thin layer of pure resin to the cured gelcoat/or a skincoat.
- Laminate the first 225g/m² MAT, well impregnated, carefully eliminating air bubbles.
- Immediately laminate 4 MATs of 300g/m².
- Allow the resin to harden until it becomes evenly whitened.
- Laminate the second layer with 4 MAT 450 g/ m²; wait for the resin to whiten again.
- Continue laminating with 4 MATs at a time until the design thickness is obtained.

Lamination Spray Lay-Up:

- Apply a thin layer of pure resin to the cured gelcoat/or a skincoat.
- Manually laminate the first 225 g/ m² MAT, well impregnated, carefully eliminating air bubbles.
- Immediately spray a 3mm cut-spray layer with crossed hands.
- Allow the resin to harden until it becomes evenly whitened.
- Continue laminating with 3mm of cut and spray until the design thickness is achieved.

Application notes:

Mix very well before use. The best results are obtained by working at temperatures above 25°C.

It is recommended to clean and sand the surfaces in case of long intervals (over 8-12 hours) of over lamination.

To obtain low impregnation ratios and increase the resistance of the laminates, the use of spiked rollers with orthogonal blades is required.

In its original packaging, the product can be used for 6 months if stored indoor away from direct sunlight, at temperatures not exceeding 20°C.

TYPICAL SPECIFICATIONS OF THE LIQUID PRODUCT

Tests made at 23°C	Value	Unit of measure	Method
Color	Beige	-	IMIA-01
Density	1,33 ± 0,05	Kg/l	IMIA-02
Solid content	75 ± 2	%	IMIA-03
Viscosity (Brookfield RV, T03, 20rpm)	1500 - 2500	cP	IMIA-10
Reactivity (100g product + 1,50g CT21/MEKP 50%)	35 ± 5	min	IMIA-15
Exothermic peak	135 ± 5	°C	IMIA-15

TYPICAL CHARACTERISTICS OF THE HARDENED PRODUCT (*)

Tests made at 23°C	Value	Unit of measure	Method
Color of the hardened product	White	-	IMIA-01
Superficial hardness	40 - 45	Barcol	IMIA-28
Thermo-mechanical resistance:			
HDT	90 - 95	°C	IMIA-50
TG	95 - 100		ASTM D3418
Linear shrinkage	< 0,2	%	IMIA-25
Elongation at break	1,3 - 1,6	%	ASTM D638 (**)
Tensile strength	115 - 125	MPa	ASTM D638 (**)
Tensile modulus	10 - 10,5	GPa	ASTM D638 (**)
Flexural strength	200 - 220	MPa	ASTM D790 (**)
Flexural modulus	9 - 10	GPa	ASTM D790 (**)

(*) on specimens hardened 24 hours at 23°C and post hardened 3 hours at 80°C

(**) resin reinforced with 20% by weight of glass fiber (MAT 450 g / mg)

The information and data contained in this technical sheet are based on the measurements and experience gained; in good faith, they are made available to the customer who is responsible for the application verification and the definition of suitability for the intended use. INTEC assumes no responsibility for the results obtained in the specific application made by the user.

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