



Specialty Composites

Technical data sheet

RESICHIM 606 TAE

Resichim™ – Resins

Low shrink resin system specifically developed for the manufacture of molds with superior surface quality and dimensional stability.

ADVANTAGES:

- Very fast mold manufacture
- Excellent wetting of the glass fiber
- Low viscosity
- Promoted system
- Compensated shrinkage resin
- Excellent dimensional stability
- High lay-up mechanical properties
- Improved service life

TECHNICAL SPECIFICATIONS:

Properties of the liquid resin:

	RESCHIM 606 TAE
Density	1.3
Solid content (%)	65 - 68
Static viscosity (at 5rpm, 20°C cps)	1800 - 2500
Thixotropy	≥ 1.5
Reactivity	200 gr mass 1.5% MEKP50 20°C
Geltime (minutes)	15 – 20
Pic time (minutes)	25 – 30
Pic temperature (°C)	180 ± 10

Properties of the polymerized pure resin:

Properties	Value	Norm
Tensile strength	64 MPa	ISO 527 – 1/2 - 1993
Flexural strength	105 MPa	ISO 178 - 1993
Flexural modulus	3100 MPa	ISO 178 - 1993
Tensile elongation	2.3 %	ISO 527 – 1/2 - 1993
Heat Distortion Temperature	105°C	ASTM D 2583-87

APPLICATION:

This product must be used at workshop temperature between 20 and 30°C.

It is strongly recommended to control gel time before actually using the product. The nature of this system is such that each thickness of the lay-up should achieve a minimum exotherm of 50°C for the required final properties.

Catalyze: between 1.25% and 2% of BUTANOX M50, LUPEROX K1, (or equivalent organic peroxides), according to the requested production cycle.

Application of the RESICHIM 606 TAE system must start 1h30 to 3h after curing of the skin coat. This time will depend on temperature, humidity and draughts within the workshop.

First apply a layer of resin containing filler and catalyst having a thickness of 0.2 mm. Immediately after apply a layer of 5 mm minimum with 25% glass fiber in 1 passes.

Eliminate bubbles from each layer using adequate roller.

Check gelling of the system, the change in colour and the exotherm of the laminate.

Continue manufacturing the mold adding successive layers until the desired thickness is obtained.

Warning: Always allow each layer (one layer is 5 mm) to cool before spraying a further layer.

Complete curing of the mold may vary between 24 hours and a week depending upon operating conditions, thickness of the mold, etc.

STORAGE CONDITIONS:

Product should be kept away from direct sunshine and at temperature below 20°C. Under these conditions, the product will keep its properties 3 months from production date.

The information contained in this technical data sheet reflects our current knowledge. It aims at providing information about the application possibilities.

As we cannot control the applications' conditions, we cannot be held as responsible beyond the providing of material in accordance with our specifications.

Consult the material safety datasheet.