

RESIN	HARDENER	MIXING RATIO
R 302 Component A	MEKP Component B	100:2

**DESCRIPTION:** Unsaturated isophthalic acid based polyester resin, dissolved in styrene, thixotropic and pre-accelerated. This resin combines excellent mechanical and chemical resistance with good temperature resistance.  
Good application characteristics and excellent capacity for impregnating reinforcement.

**APPLICATIONS** This product is suitable for the construction of boats, storage tanks, ducts for the chemical and sanitary industries, and other applications requiring special mechanical or chemical resistance.

R.302 resin is also suitable for making containers and other items for the wine and food industries, and for any element that comes into contact with products destined for human consumption.

**PROCESSING:** Due to its rheologic characteristics, this product is suitable for hand-lay-up or spray-up. PR version is also available, with longer gel time and lower exothermic properties. R.302 isophthalic resin has been certified by the Italian Naval Register as a component of composite materials for use in hull construction, with approval certificate number DIP/216/98/1.

**INSTRUCTIONS:** Verify and, when necessary, homogenize the components before use. Add the proper quantity of the hardener to the resin, mix carefully. Avoid air trapping. For the surface preparation (mould or model) refer to the release agents data sheet.

**STORAGE AND PRECAUTIONS:** If the product is stored in the dark in its original container, perfectly sealed and at a maximum temperature of 20°C, it is stable for at least 6 months from the date of production.  
Longer periods of storage, or in conditions other than those defined above, may alter the product's characteristics and compromise its use.

**TYPICAL SYSTEM CHARACTERISTICS**

PROCESSING DATA	
Density at 20°C PK03	g/cm <sup>3</sup> 1.1 ± 0.1
Solid content PK04	% 52 ± 2
Brookfield viscosity at 25 °C (0.98 sec <sup>-1</sup> ) PK01 Brookfield viscosity at 25 °C (9.8 sec <sup>-1</sup> ) PK01	mPa.s 1800 ± 400 mPa.s 500 ± 100
Gel time* PK02	minutes 11 ± 3
Exothermic peak time* PK02	minutes 21 ± 3
Peak temperature* PK02	°C 205 ± 10

\*Hardening at 25 °C with 2% MEKP 50%

**TYPICAL CURED SYSTEM PROPERTIES**

PROCESSING DATA	
Density at 23°C ASTM-D 792	g/cm <sup>3</sup> 1.2 ± 0.1
Barcol hardness ASTM-D 2583	42 ± 2
Volumetric shrinkage leda06	% 3.2 ± 0.3
Elongation at break UNI EN 61	% 3.8 ± 0.2
Heat distortion temperature ISO 75-2 1993	°C 82 ± 3

Note: All reasonable care was taken when drafting the above technical information and notes. The data provided is based on laboratory tests and trade experience.

Nevertheless, these notes do not represent any form of explicit or implied warranty for the use of products supplied, nor for the characteristics of finished goods due to the fact that these characteristics can be influenced by the conditions of application.