

# PALAPREG® H 860-01

## CHEMICAL/PHYSICAL NATURE

Palapreg® H 860-01 is a solution of modified saturated polyesters, dissolved in styrene.

## MAJOR APPLICATIONS

The combination of Palapreg® H 860-01 with Palapreg® P18-03 is intended for the production of low profile SMC and BMC. Palapreg® P18-03 and Palapreg® H 860-01 together with either Palapreg® H 814-01 or Palapreg® H 8223-01 is used for class A applications with improved flow behavior. Especially combined with Palapreg® H 814-01 this system offers the possibility of homogeneous pigmentation in line with class A surface quality. The formulation can readily be thickened with magnesium oxide.

## PRODUCT SPECIFICATIONS UPON DELIVERY

Property	Range	Unit	TM
Viscosity, 23°C	300-500	mPa.s	2013
Solids content, IR	37-40	%	2033
Appearance	clear-sl. hazy	-	2265
Water content	0.0 - 0.09	%	2350
Acid value, as such	3-6	mg KOH/g	2401

## PROPERTIES OF THE LIQUID RESIN (TYPICAL VALUES)

Property	Value	Unit	TM
Density, 20°C	appr. 1100	kg/m <sup>3</sup>	2160
Flash point	appr. 33	°C	2800
Stability, no init., dark, 25°C	6	months	-

## PROPERTIES OF SMC-MOULDINGS (TYPICAL VALUES)

Property	Value	Unit	TM
Glass content	28	%	-
Flexural strength	165	MPa	ISO 178
Flexural modulus	10	GPa	ISO 178
Outer fiber strain	2.7	%	ISO 178
Impact res. - unnotched sp.	110	kJ/m <sup>2</sup>	ISO 179
Moulding shrinkage	-0.08% =expansion	%	DIN 53464

## TYPICAL STARTING FORMULATION FOR SMC-PASTE

Component	Weight
Palapreg® P18-03	50
Palapreg® H860-01	40
Palapreg® H 8223-01	10
TBpB	1.5
Styrene	3
Calcium carbonate	210
Zinc stearate	4
Byk W996, Byk Chemie	2
MgO-paste (35% MgO)	2.5

## PROCESSING

The combination of Palapreg® P18-03 and Palapreg® H 860-01 together with either Palapreg® H 814-01 or Palapreg® H 8223-01 is processed into class A -SMC / BMC. As a rule the ratio of the components is 50:40:10. Depending on the size of the molded part it is recommended to add 300 to 600 ppm p-benzoquinone to the system (calculated on UP-resin plus thermoplastic solution)

## STORAGE GUIDELINES

The resin should be stored indoors in the original, unopened and undamaged packaging, in a dry place at temperatures between 5°C and 30°C and the properties might change during storage. Shelf life is reduced at higher temperatures and the properties of the resin might change during storage. The shelf life of styrene containing unsaturated polyesters will be significantly reduced when exposed to light. Store in dark and in 100%light tight containers only.

## MATERIAL SAFETY

A Material Safety Data Sheet of this product is available on request.

## TEST METHODS

Test methods (TM) referred to in the table(s) are available on request.

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PRODUCT INQUIRY? PLEASE CLICK HERE

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