



## Product Information Sheet

<b>Product:</b>	PRO-MOULD Filled Tooling Resin
<b>Product Code:</b>	351 – 55071 - PL
<b>Sizes:</b>	25kg
<b>Uses:</b>	PRO-MOULD filled tooling resin is specifically formulated pre-promoted unsaturated polyester resin designed to produce long-life, high-quality moulds for the fabrication of FRP parts. This single component filled resin is ready for use, cures at room temperature (minimum temperature is recommended at 18°C, ideally above 20°C) and with almost zero shrinkage thus eliminating fibre print through on the gelcoat surface. The low shrinkage properties allow for the exact dimensions of the plug to be retained with perfect surface reproduction. PRO-MOULD has a good cure as well as excellent handling properties, allowing moulds to be produced in two days.
<b>Application:</b>	<p>Spray layup</p> <p>The initial lay-up behind the gelcoat should comprise of 2 - 3 layers of 300 gm CSM or 600 - 900g/m<sup>2</sup> of chopped roving (chopper gun application) with vinyl ester resin. Following the cure of the VE layer PRO-MOULD tooling resin should be applied at a resin to glass ratio of 4:1 (2kg of PRO-MOULD resin to 500gm of chopped glass).</p> <p>PRO-MOULD tooling resin is a low viscosity resin, before use thoroughly mix to ensure the product is homogenous. Curox CATA 2000 catalyst must be used with this product at a level of 1.5 – 1.75% to ensure the optimum cure is achieved.</p> <p>Following the gelation of the PRO-MOULD resin the laminate temperature will rise to approximately 50 - 60°C and the colour will change from a mid-brown to a lighter white/brown in colour. Once the exothermic temperature subsides further layers can be applied up to a glass weight of 1800 – 2100g/m<sup>2</sup>, again waiting for the exotherm to subside before adding more matrix.</p>
<b>Features:</b>	Pre-promoted, contains filler (no messy mixing) Has colour change mechanism to show state of cure Almost zero shrinkage on cure Rapid cure rates
<b>Catalyst:</b>	It is recommended that you use 1.5% of the Curox CATA 2000 with PRO-MOULD filled tooling resin.

**Typical Properties:**

Appearance	Amber Opaque Liquid
Viscosity at 25°C	900 - 1200cP
Cone Plate viscosity @ 25°C	450 - 550cP
Gel time – 1.5% Curox CATA 2000	30 – 40mins
Density	1.45 g/m³
Flash Point	31°C
Heat Deflection Temp (HDT)	80°C

Gel times are from controlled testing completed in the laboratory, there will be a variance when the product is used in uncontrolled temperature of the work shop.

**Storage:**

Store in a locked secure dangerous goods area in a tightly closed container away from any heat source, ignition source and out of direct sunlight, store below 25°C.

**Stability:**

When stored correctly, a storage life of 3 months is expected.

**Hazards:**

Flammable

Health Hazard

Irritant

**Personal Protection:****Enquires:**

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**For further information check the full SDS for this product.**

**Disclaimer:** The information given in this data sheet is given in good faith and is believed to be valid and accurate at the time of publication. However, no responsibility is accepted for accident or injury which may occur from omissions or from information contained in the data sheet.