

# BUP 665

Thermoset Polyester  
Bonyan Kala Chemie Company

Message:

- Characteristics:
- Very Low color
  - Excellent adhesion to glass fibers
  - Medium viscosity
  - Excellent physical and mechanical and chemical properties after curing
  - Limited water absorption
  - Resistant to hydrolysis
- Applications:
- GRP Pipes & joints
  - Manufacturing of composite parts and profiles
  - Structural hygienic fittings
  - Gel coat
  - Reservoirs

| General Information            |                            |          |
|--------------------------------|----------------------------|----------|
| Features                       | Good Adhesion              |          |
|                                | Hydrolysis Resistant       |          |
|                                | Low to No Water Absorption |          |
|                                | Medium Viscosity           |          |
| Uses                           | Coating Applications       |          |
|                                | Hygiene                    |          |
|                                | Piping                     |          |
|                                | Profiles                   |          |
| Appearance                     | Clear/Transparent          |          |
| Physical                       | Nominal Value              | Unit     |
| Molding Shrinkage - Flow       | < 1.1                      | %        |
| Water Absorption (Equilibrium) | < 0.28                     | %        |
| Acid Value                     | < 24.00                    | mg KOH/g |
| Gardner Color                  | < 1.00                     |          |
| Heat Deflection Temperature    | > 90                       | °C       |
| Hardness                       | Nominal Value              | Unit     |
| Barcol Hardness                | > 45                       |          |
| Mechanical                     | Nominal Value              | Unit     |
| Tensile Strength               | > 75.0                     | MPa      |
| Tensile Elongation (Break)     | > 2.0                      | %        |
| Flexural Strength              | > 140                      | MPa      |
| Thermal                        | Nominal Value              | Unit     |
| Peak Melting Temperature       | < 210                      | °C       |

| Uncured Properties    | Nominal Value | Unit |
|-----------------------|---------------|------|
| Solids Content        | 64 to 68      | %    |
| Viscosity (25°C)      | 0.80 to 1.2   | Pa·s |
| Curing Time           | 0.083 to 0.17 | hr   |
| Gel Time <sup>1</sup> | 7.0 to 12     | min  |

#### NOTE

1. Curing condition with 1% Co (1%)  
and 3% MEKP (50%)

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