

**Processing Guide
Secondary Insulation**

**PG-122 –
Trickle X Unsaturated Polyester Resin**

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PG-119 – Trickle X Unsaturated Polyester Resin

Application of this product does not require the use of complicated expensive meter-mix dispensing equipment. The catalyst can be easily hand mixed into the resin. This mixture can be readily dispensed for trickle applications by a variety of simple pumping methods.

Pedigree® X Unsaturated Polyester Resin will not cure without the addition of catalyst. ELAN-Plus™ C 8 Catalyst (t-Butyl Perbenzoate) in the amount of 1% by resin weight is recommended. ELAN-Plus™ C 8 Catalyst (TBP) is a liquid catalyst and may be added either by weight or by volume.

Note:

Pedigree® X Unsaturated Polyester Resin should be stirred before catalyzing to insure a homogenous mixture and occasionally after addition of ELAN-Plus™ C 8 Catalyst (TBP) for best results. Use a non-metallic stirrer to avoid scraping metal particles from the shipping container, and an explosion proof or air driven motor.

Mix 100 parts Pedigree® X Unsaturated Polyester Resin to 1 part ELAN-Plus™ C 8 Catalyst (TBP) by weight. The ELAN-Plus™ C 8 Catalyst (TBP) should be stirred into the resin thoroughly to assure complete distribution.

Catalyzed resin at an ambient temperature between 23.9 – 26.7°C (75 - 80°F) has a typical pot life of >30 days. Continued replenishment and keeping the resin mixed in the dip tank at 15 – 20°C (59 – 68°F) will help extend life.

- Preheat units to 105 -120°C(220-250°F)
- Trickle resin on to units while under rotation(Note:Unit temperature should be 105°C(220°F) minimum
- Bake parts while under rotation. Unit temperature must reach 163 - 177°C (325 - 350°F) for 20 minutes.

This method produces parts ready for assembly or additional processing.

Please contact ELANTAS PDG, Inc. Technical Service if you have any questions.
Phone number 1.314.621.5700 Extension 717 or 1.800.325.7492 Extension 717

The above properties are typical values and are not intended for specification use.

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