

Technical Datasheet



AROPOL™ M 604 TCR Low Styrene Content Resin / Vapour Suppressed

AROPOL M 604 TCR is a vapour suppressed, low styrene content DCPD based polyester resin. The resin is pre-accelerated and thixotropic.

Low styrene emission, good glass fiber wet out, low shrinkage and good surface cosmetics are characteristic for AROPOL M 604 TCR resin.

Typical liquid resin properties

Property at 23 °C	Value	Unit	Method
Viscosity, Brookfield RV2, 10 rpm	1200	mPas	ISO 2555
Viscosity, cone&plate	180	mPas	ISO 2884
Styrene content	37	%	SFS 4864
Geltime, 1% MEKP-50	60	min	D006
Peak exotherm	70	°C	D006

Typical cured resin properties

Property (postcured 16h at 40 °C)	Value	Unit	Method
Tensile strength	49	MPa	ISO 527
Tensile modulus	2900	MPa	ISO 527
Elongation at break	2,3	%	ISO 527
Heat deflection temperature (ultimate)	85	°C	ISO 75/2 (A)
Hardness	40	Barcol	ASTM D2583
Water absorption 28 days	76	mg/sample*	ISO 62-80

* sample 50x50x4 mm

Application and use

AROPOL M 604 TCR resin is developed for spray-up and hand lay-up applications and suitable for manufacturing of products for the marine, transportation and building and construction markets.

Due to the low peak exotherm and low heat development during the curing process, AROPOL M 604 TCR can be used for thick laminates wet on wet.

Certificates and approvals

AROPOL M 604 TCR resin is approved by Lloyd's Register, Germanischer Lloyd's and Det Norske Veritas for construction of small crafts.

The manufacturing, quality control and distribution of products, by Ashland Performance Materials, are complying with one or more of the following programs or standards: Responsible Care, ISO 9001, ISO 14001 or OHSAS 18001.



Responsible Care*

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Handling and storage It is highly recommended that all material is stored at stable temperatures under 20 °C preferably indoors, and away from direct sunlight. Prolonged storage or storage outside of recommended conditions can influence liquid resin properties like viscosity and geltime. It is also strongly recommended to mix resin thoroughly before use. Shelf life of AROPOL M 604 TCR is three (3) months.

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