



Your Formula for Success
RESINS | GEL COATS | COLORANTS

VICAST® A541-DH SERIES POLYESTER RESIN



Product Information

POLYESTER RESIN FOR CULTURED OYNX AND MARBLE

Typical Cast Mechanical Properties¹

Test	Unit of Measure	Nominal	Test Method
Tensile Strength	psi	10,400	ASTM D 638
Tensile Modulus	psi	610,000	ASTM D 638
Tensile Elongation	%	2.1	ASTM D 638
Flexural Strength	psi	18,500	ASTM D 790
Flexural Modulus	psi	640,000	ASTM D 790
Heat Distortion Temp.	°F/°C @264 psi	140/60	ASTM D 648
Barcol Hardness		40	ASTM D 2583

Typical Liquid Properties²

Test	Unit of Measure	Nominal
Viscosity @ 77°F/25°C, LV SSA Brookfield Spindle #4 @ 60 rpm	cps	1800
Color	—	pink
Styrene Content	%	29
Specific Gravity @77°F/25°C	—	1.15
Gel Time, 77°F/25°C, 100g 1.0% M50 MEKP	minutes	9,15,20
Gel to Peak	minutes	10
Peak Exotherm	°F	300

Typical properties are not to be construed as specifications.

DESCRIPTION

Vicast A541-DH Series is a prepromoted, non-thixotropic, polyester resin formulation made for use in cultured marble, granite and onyx applications. This product is specifically designed to give good demold times in marble applications while maintaining good color in onyx type castings, enabling the use of only one resin for both marble and onyx. It can be used for both flat and contoured molds.

BENEFITS

Vicast A541-DH Series Polyester Resin The cure rate of Vicast A541-DH Series in marble applications is similar to that of a standard marble resin when used with the appropriate type and level of MEKP catalyst.

The color of Vicast A541-DH Series is superior in a marble matrix, it also gives a bright, clean translucency in matrixes filled with standard onyx type fillers.

Vicast A541-DH Series has excellent green strength for effective demold times in cultured marble and onyx.

VICAST®

A541-DH SERIES POLYESTER RESIN

PERFORMANCE GUIDELINES

A. Keep full strength catalyst levels between 1.25% - 2.0% of the total resin weight.

B. Maintain shop temperatures between 65°F/18°C and 90°F/32°C and humidity between 40% and 90%. Consistent shop conditions contribute to consistent gel times and will help the fabricator make a high quality part.

STORAGE STABILITY

Resins are stable for four months from date of production when stored in the original containers away from sunlight at no more than 70°F/21°C.

After extended storage, some drift may occur in gel time and viscosity.

During the hot summer months, no more than two months stability at 86°F/30°C should be anticipated.

SAFETY

See the appropriate Safety Data Sheet for guidelines.

ISO 9001:2008 CERTIFIED

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2008 standards. This certification recognizes that each AOC facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

FOOTNOTES

(1.) All tests at 77°F/25°C on unreinforced cured resin castings. Thixotropic components, if applicable, are excluded from casting samples. Castings were post cured.

(2.) The gel times shown are typical but may be affected by catalyst, promoter, inhibitor concentration, resin, mold, and shop temperature. Variations in gelling characteristics can be expected between different lots of catalysts and at extremely high humidities. Pigment and/or filler can retard or accelerate gelation. It is recommended that the fabricator check the gelling characteristics of a small quantity of resin under actual operating conditions prior to use.



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