



COR61-AA-930KS

Low Exotherm Laminating Resin

Technical Data Sheet

COR61-AA-930KS is a DCPD laminating resin specially designed for use in medium to thick laminates such as boat hulls and decks and for excellent bonding to acrylic substrates.

COR61-AA-930KS contains a maximum of 35% styrene (HAP) by weight, which meets the EPA 40 CFR Part 63 requirements of the National Emission Standards for Hazardous Air Pollutants (HAP) for boat manufacturing and National Emissions Standards for Hazardous Air Pollutants: Reinforced Plastics Composites Production: Non-Corrosion and/or Not High Strength. The application method for both EPA standards is non-atomized spray.

FEATURES	BENEFITS
<ul style="list-style-type: none"> • Low Exotherm & Even Cure, Even in Thick Sections 	<ul style="list-style-type: none"> • Improved cosmetics
<ul style="list-style-type: none"> • Excellent Glass Wetting 	<ul style="list-style-type: none"> • Easier to remove air during roll-out
<ul style="list-style-type: none"> • Good Trim Time 	<ul style="list-style-type: none"> • Allows for good working time
<ul style="list-style-type: none"> • Less Than 35% HAP (Styrene) Content 	<ul style="list-style-type: none"> • MACT compliant for Non-Atomized Spray-Up; fewer emissions in the manufacturer's shop
<ul style="list-style-type: none"> • Contains a Low Level of DCPD 	<ul style="list-style-type: none"> • Tack-free without addition of wax; low HAP content

RELATED PRODUCTS	GEL TIME
COR61-AA-930K	20-25 minutes

LIQUID PROPERTIES	RESULTS
Viscosity, Brookfield Model LV #3 Spindle @ 60 rpm, 77°F (25°C), cPs	575-700
Thixotropic Index	3.0-4.0
100 grams resin @ 77°F (25°C), initiated with 1.5% DDM-9 by volume *	
Gel Time, min:sec	25:00-30:00
Gel to Peak Exotherm Time, min:sec	15:00-30:00
Peak Exotherm	210-270°F (98-132°C)
Hazardous Air Pollutant (Styrene) Content, %	≤ 35.0
Specific Gravity	1.02-1.14

TYPICAL PROPERTIES		
Thickness	1/8 inch (3.2 mm) Casting	
Flexural Strength, ASTM D790	17,286 psi	120 MPa
Flexural Modulus, ASTM D790	5.67 x 10 ⁵ psi	3,910 MPa
Tensile Strength, ASTM D638	4,335 psi	29.9 MPa
Tensile Modulus, ASTM D638	5.65 x 10 ⁵ psi	3,895 MPa
Tensile Elongation, ASTM D638	0.83 %	0.83 %
Barcol Hardness, 934-1 gauge, ASTM D2583	45	45
Heat Distortion Temperature, ASTM D648	167 °F	75 °C
Specific Gravity at 23°C, ASTM D792	1.21 lb/gal	0.14 Kg/L
* Gel time and reactivity will vary due to the type and concentration of Free Radical Initiator (catalyst), shop temperature, humidity, and type of fillers used. In order to meet your individual needs consult our technical sales representative for assistance.		
Testing conducted at 77°F (25°C) and 50% relative humidity. Results may depend on post-cure and batch variations within nominal blend component compositions.		
The air-curing capabilities of DCPD laminating resins are well documented. Ambient temperature, catalyst level, laminate thickness and configuration can all contribute to accelerating and surface cure. Care must be taken to ensure that secondary laminates have good adhesion. Cured surfaces should be sanded between laminates.		

All specifications and properties specified above are approximate. Specifications and properties of material delivered may vary slightly from those given above. Interplastic Corporation makes no representations of fact regarding the material except those specified above. No person has any authority to bind Interplastic Corporation to any representation except those specified above. Final determination of the suitability of the material for the use contemplated is the sole responsibility of the Buyer. Our technical sales representatives will assist in developing procedures to fit individual requirements, but all advice is accepted at your risk and should be checked for suitability to your particular processes. These test data and properties are based on results obtained for a specific material under the specified test conditions. They are not to be used as specifications and are not warranted as performance attributes for any product or system. Specifications and properties of standard production material may vary slightly from those in this report. Interplastic Corporation makes no warranties regarding any material and/or samples described in this report unless that representation is provided to your company in writing by a Technical Director of Interplastic Corporation or one of his or her managers.

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