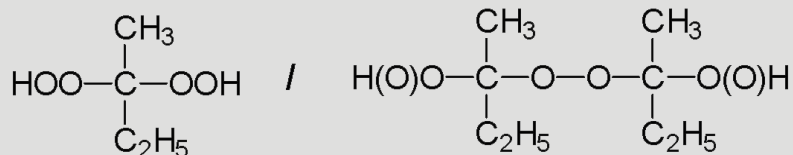


**CUROX® M-372**

Technical Data Sheet - Thermosets - Ketone peroxides (Ambient temperature)



Chemical Name	Methylethyl ketoneperoxide
CAS-No.	1338-23-4
Properties	Liquid mixture

Description

Colourless, mobile liquid, consisting of ketoneperoxides, essentially desensitised with aliphatic solvents. This ketone peroxide is used as an initiator (radical source) in the curing of unsaturated polyester resins.
Main application: RTM, curing of moulded parts at ambient temperature in combination with cobalt accelerators.

Technical Data

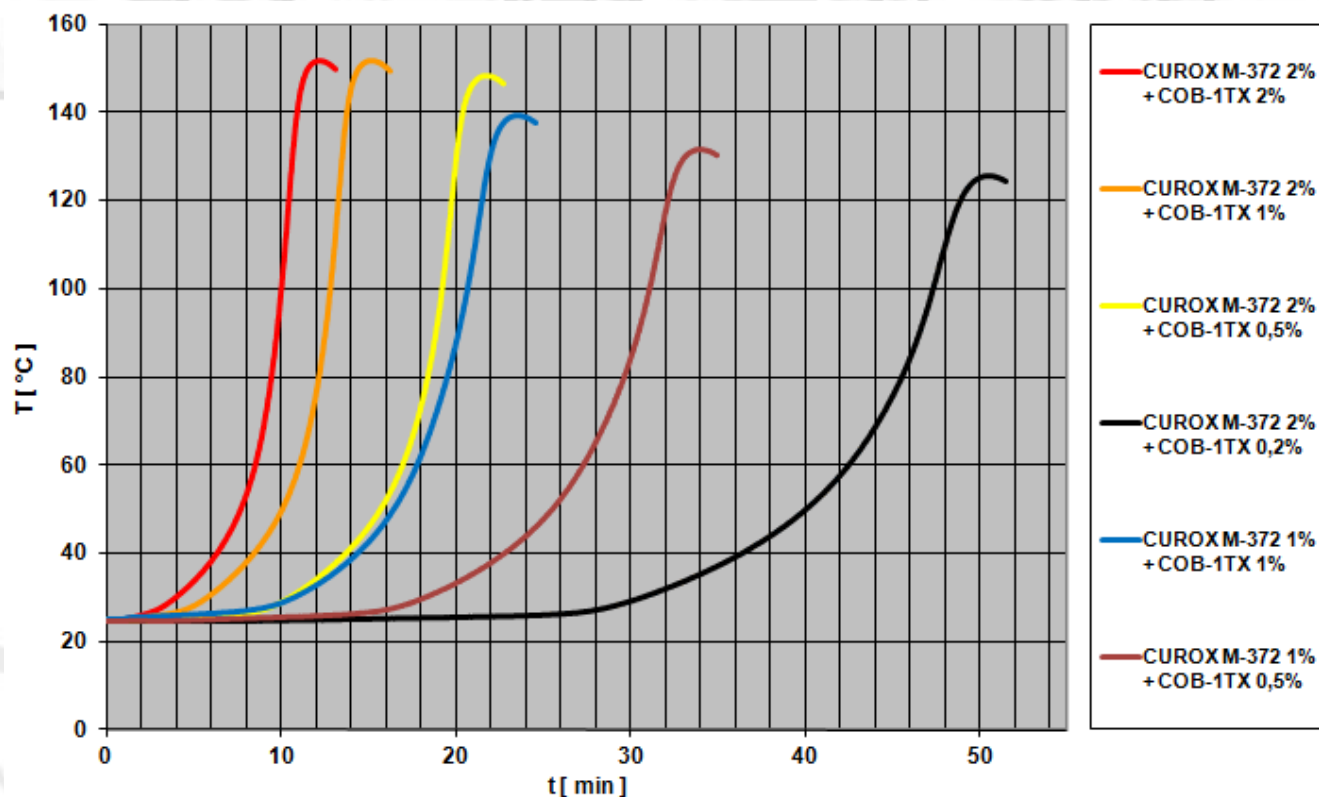
Property	Characteristics / Value
Appearance	colourless liquid
Active oxygen	ca. 7.4 % w/w
De-sensitising agent	aliphatic solvents
Density at 20°C	ca. 1.03 g/cm ³
Viscosity at 20°C	ca. 18 mPas
Miscibility	immiscible with water, miscible with ester, UP/VE-resins
Critical temperature (SADT)	ca. 50 °C
Cold storage stability	liquid to below -25 °C
Recommended storage temperature	below 30 °C
Storage stability (activity) as from date of delivery	3 months

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Technical Data Sheet - Thermosets - Ketone peroxides (Ambient temperature)

Activity:

"Cobalt Curing" after DIN 16945 at 25°C with OPA resin (20g in a test tube)						
Formulation (parts by weight)						
Medium reactive resin type (OPA)	100	100	100	100	100	100
CUROX® M-372	2	2	2	2	1	1
Accelerator COB-1TX	2	1	0.5	0.2	1	0.5
Curing data						
Gel time t_{gel} [min]	4.0	6.0	10.5	30.5	11.0	18.0
Curing time t_{max} [min]	12.0	15.5	22.0	50.5	23.5	34.0
Peakttemperature T_{max} [°C]	152	151	147	126	138	131





CUROX® M-372

Technical Data Sheet -Thermosets - Ketone peroxides (Ambient temperature)

Application - Polyester curing

- Usage level:

Specific curing agent for all UP resin types at ambient temperature in combination with cobalt accelerators. Standard dosage level: 1-3% as supplied, with 0.2-2% of a 1% cobalt solution.

"Shelf life" (gel time of resin + peroxide) usually only a few hours, depending on temperature and resin type.

"Pot life" (gel time of resin + peroxide + accelerator) relatively short, but may be prolonged by adding Inhibitor TC-510. Thus, the mould release factor ($fMR = tMR/tgel$) can be improved considerably.

- Curing characteristics:

Medium evolution of heat, short mould release time. Temperatures below 20°C prolong curing times considerably, alternatively cobalt / amine accelerators should then be used.

- Processing methods:

Hardener for Resin Transfer Moulding (RTM), but also suitable for hand lay-up, spray lay-up, centrifugal casting, filament winding and casting of resins.

- Spray equipment:

Use spray equipment in accordance with manufacturer's instructions. Ensure all safety devices are operational. Do not clear gun by spraying MEKP into the air.

This information and all further technical advice – whether verbal, in writing, by way of trials - are reflecting our present knowledge and experience based on internal tests with local raw materials with the purpose to inform about our products and applications. The information should not be construed as guaranteeing specific properties of products described or their suitability for a particular application, nor as providing complete instructions for use. The information implies no guarantee for product and shelf life properties, nor any liability or other legal responsibility on our part, including with regard to existing third party intellectual property rights, especially patent rights. We reserve the right to make any changes according to technological progress or further developments.

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