

Technical Data Sheet

Polyester Curing Ketone peroxides (Ambient temperature)

CUROX[®] M-104

Methyl ethyl ketone peroxide

CAS#1338-23-4

Liquid mixture

Description:

Colourless, mobile liquid, consisting of peroxides based on methylethylketone, essentially desensitised with phthalate plasticiser. This ketone peroxide is used as an initiator (radical source) in the curing of unsaturated polyester resins. Main application: curing of moulded, casted or winded glasfibre reinforced products at ambient temperature in combination with cobalt accelerators.

Technical Data:

Appearance	colourless liquid
Active oxygen	approx. 8.9 % w/w
Free hydrogenperoxide content.....	below 1.2% w/w
Water content.....	below 1.5% w/w
De-sensitising agent	dimethylphthalate
Density at 20°C.....	approx. 1.12 g/cm ³
Viscosity at 20°C	approx. 23 mPa·s
Miscibility	miscible with alcohols, phthalates
Critical temperature (SADT)	above 60°C
Cold storage stability.....	below -20°C
Recommended storage temperature.....	0 to 30°C
Maintenance of activity at 25°	> 6 months

Application:

POLYESTER CURING: Curing agent for all UP resin types as well as Vinylester resins at ambient temperature in combination with cobalt accelerators. Standard dosage level: 1-3% as supplied, with 0.5-2% of a 1% cobalt solution. Cobaltoctoate/Dimethylaniline-combinations can have a stronger acceleration effect in Vinylesterresins. Also suitable for Gel-and Topcoats.

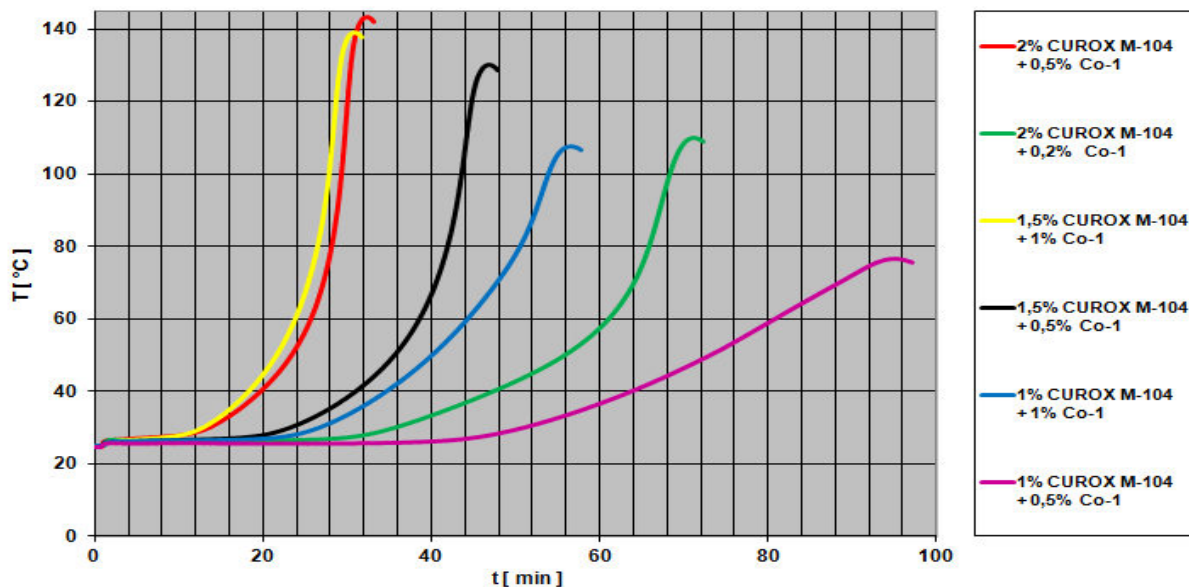
"Pot life" (gel time of resin + peroxide + accelerator) in Vinylester resins relatively short, but may be prolonged by adding Inhibitor TC-510.

CURING PERFORMANCE: Depending on resintype moderate/strong evolution of heat. Temperatures below 20°C prolong curing times considerably, alternatively cobalt / amine accelerators should then be used. Vinylester resins can be cured in reasonable time with less foaming effects but higher exothermal peak in thick layers

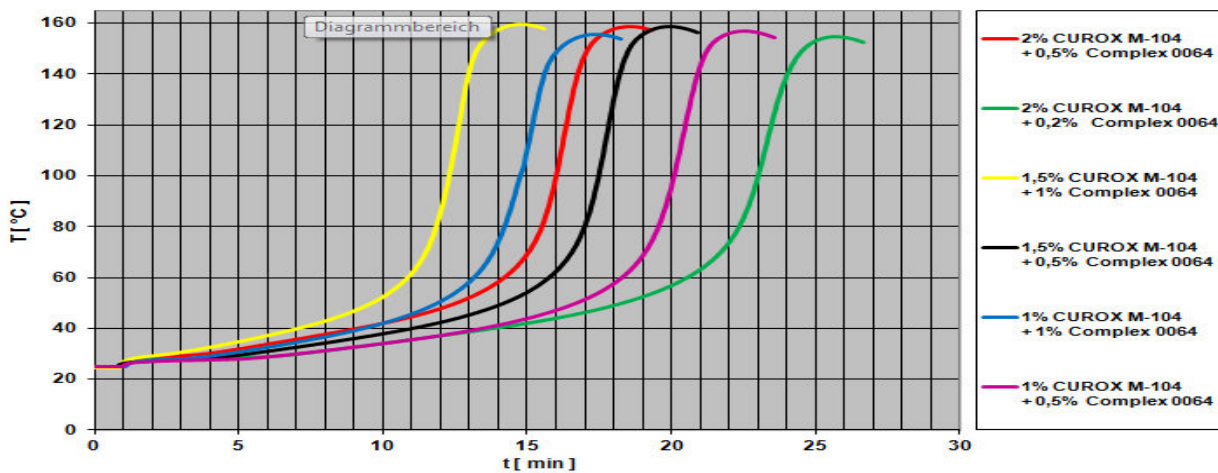
PROCESSING METHODS: Particularly hand lay-up, spray lay-up, centrifugal casting, filament winding, casting of resins, and surface coatings (putties, fillers, gelcoats and topcoats).

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.

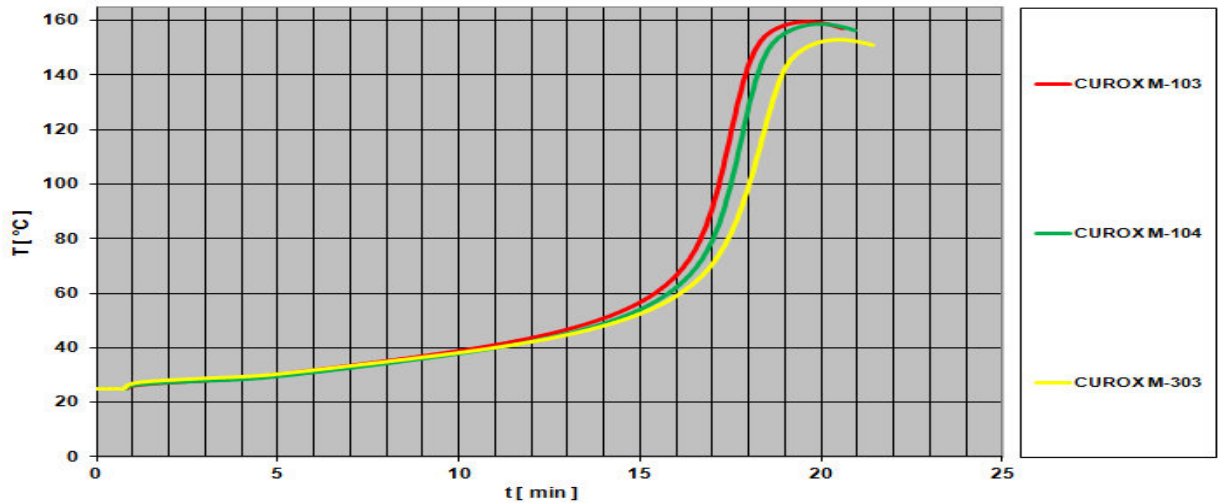
Reactivity:



Measurements in compliance with DIN 16945 at 25°C with OPA resin (20g in a test tube)						
Medium reactive resin type (OPA)	100	100	100	100	100	100
CUROX® M-104 [Vol-%]	2.0	2.0	1.5	1.5	1.0	1.0
BÜFA® Accelerator Co 1 [Vol-%]	0.5	0.2	1.0	0.5	1.0	0.5
Curing data						
Gel time 25 -30°C tgel [min]	14.0	35.5	12.5	23.5	26.5	50.5
Gel time 25 -35°C tgel [min]	17.0	42.0	16.0	27.5	31.0	58.0
Curing time tmax [min]	32.5	71.5	31.0	47.0	56.5	94.5
Peaktemperature Tmax [°C]	144	110	139	130	108	76



Measurements in compliance with DIN 16945 at 25°C with VE resin (20g in a test tube)						
Medium reactive resin type (VE)	100	100	100	100	100	100
CUROX® M-104 [Vol-%]	2.0	2.0	1.5	1.5	1.0	1.0
BÜFA® Accelerator Complex 0064 [Vol-%]	0.5	0.2	1.0	0.5	1.0	0.5
Curing data						
Gel time 25 -30°C tgel [min]	4.0	7.0	2.5	5.5	4.5	7.0
Gel time 25 -35°C tgel [min]	6.5	10.5	5.0	8.5	7.0	10.5
Curing time tmax [min]	18.5	25.5	15.0	20.0	17.5	22.5
Peaktemperature Tmax [°C]	160	154	159	158	156	156



Measurements in compliance with DIN 16945 at 25°C with VE resin (20g in a test tube)			
Medium reactive resin type (VE)		100	100
CUROX® M-103 [Vol-%]	1.5		
CUROX® M-104 [Vol-%]		1.5	
CUROX® M-303 [Vol-%]			1.5
BÜFA® Accelerator Complex 0064 [Vol-%]	0.5	0.5	0.5
Curing data			
Gel time 25 - 30°C t _{gel} [min]	5.0	5.5	5.0
Gel time 25 - 35°C t _{gel} [min]	8.0	8.5	8.0
Curing time t _{max} [min]	19.5	20.0	21.0
Peaktemperature T _{max} [°C]	160	158	153

Further information on suitable curing agents for unsaturated polyester resins is given in our application brochures on this subject.

Contact: <http://www.united-initiators.co>

Disclaimer

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