



SIL65AA-895S

Orthophthalic Laminating Resin

Technical Data Sheet

SIL65AA-895S is an unsaturated polyester laminating resin used in the manufacture of glass fiber reinforced composites. SIL65AA-895S is tinted with a blue indicator for color change with addition of initiator.

FEATURES	BENEFITS
• Excellent Wetting of Glass Fibers	• High strength properties in laminates
• Moderate Gel Time	• Enables good line speeds
• Low Laminate Exotherm	• Even cure throughout laminate
• Moderate Hardness Development	• Good cycle times and dimensional stability

RELATED PRODUCTS	GEL TIME
SIL65AA-895W	8-12 Minutes
SIL65AA-895 (initiated with DDM-9)	13-18 Minutes

LIQUID PROPERTIES	RESULTS
Viscosity, Brookfield Model RV #2 Spindle @ 20 rpm, 77°F (25°C), cPs	400-600
Thixotropic Index	2.75-3.5
100 grams resin @ 77°F (25°C), initiated with 1.12% M-30a by weight *	
Gel Time, min:sec	23:00-28:00
Gel to Peak Exotherm Time, min:sec	15:00-20:00
Peak Exotherm	250-300°F (121-149°C)
Non-Volatile Content, %	55.5-58.5
Hazardous Air Pollutant (Styrene) Content, %	41.5-44.5
Specific Gravity	1.02-1.14

TYPICAL PROPERTIES					
Thickness	1/8 inch (3.2 mm) Casting		1/8 inch (3.2 mm) Laminate		
Construction	Not Applicable		4 Plies 1.5 oz/ft ² , 33% Glass Mat		
Flexural Strength, ASTM D790	16,200 psi	112 MPa	27,700 psi	191 MPa	
Flexural Modulus, ASTM D790	5.79 x 10 ⁵ psi	3,990 MPa	12.3 x 10 ⁵ psi	8,510 MPa	
Tensile Strength, ASTM D638	9,500 psi	66 MPa	17,800 psi	123 MPa	
Tensile Modulus, ASTM D638	5.90 x 10 ⁵ psi	4,070 MPa	13.1 x 10 ⁵ psi	9,007 MPa	
Tensile Elongation, ASTM D638	1.8 %	1.8 %	1.8 %	1.8 %	
Barcol Hardness, 934-1 gauge, ASTM D2583	42-46	42-46	48-52	48-52	
Heat Distortion Temperature, ASTM D648	151 °F	66 °C	-- °F	-- °C	
* 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.					

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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