



# Clear Casting Resin

## Technical Data Sheet

Clear Casting Resin is a polyester resin promoted for ambient temperature cure with MEK peroxide. It is used to produce medium to large size castings with exceptional clarity. Clear Casting Resin was designed to reduce cracks in larger castings with a long cure time, low peak exotherm, and minimal shrinkage.

TYPICAL RESIN PROPERTIES @ 77°F	RESULTS
Brookfield Viscosity. (RV) #2 @ 20 rpm	400 – 600
Catalyst %, DDM-9	1.0
Gel Time, min:sec	14:00 – 25:00
Gel to Peak Time, min:sec	35:00 – 60:00
Peak Exotherm °F (°C)	175–225 (79-107)
Solids %	62.0 – 64.5

MECHANICAL PROPERTIES OF NEAT CURED RESIN		RESULTS	
Property:	ASTM Test Method	Psi	Mpa
Flexural Strength	D-790	13,200	91
Flexural Modulus	D-790	$7.32 \times 10^5$	5048
Tensile Strength	D-638	6,400	44
Tensile Modulus	D-638	$7.17 \times 10^5$	4945
Tensile Elongation, %	D-638	1.5	1.5
Heat Distortion Temperature	D-648	115°F /	46.1°C
Hardness, Barcol 934-1	D-2583	38 -	42

All specifications and properties specified above are approximate. Specifications and properties of material delivered may vary slightly from those given above. Lilly-Ram Chemical makes no representations of fact regarding the material except those specified above. No person has any authority to bind Lilly-Ram 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.

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