Technical Data Sheet

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CUROX®M-303R

Methyl ethyl ketone peroxide
CAS#1338-23-4
Liquid mixture

Description

Red dyed, mobile liquid, consisting of peroxides based on methylethylketone, essentially desensitised with phtalate 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. This red dyed version helps to control homogenous mixing and during curing discolouration will take place again.

Technical Data

Appearance	Red liquid
Active oxygen	Approx 9.1 % w/w
Free hydrogenperoxide content	Approx. 1.7 % w/w
Water content	Approx. 1.5 % w/w
De-sensitising agent	Dimethylphthalate
Density at 20°C	Approx. 1.1 g/cm^3
Viscosity at 20°C	Approx. 20 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 30°C as from date of delivery	6 months

Application

POLYESTER CURING: Curing agent for all UP resin types at ambient temperature in combination with cobalt accelerators. Standard dosage level: 1-3% as supplied, with 0.5-2% of a 1% cobalt solution.
Suitable also for gelcoats with improved osmosis resistance and lowest porosity due to low water- and hydrogenperoxide content.
"Pot life" (gel time of resin + peroxide + accelerator) relatively short, but may be prolonged by adding Inhibitors, such as tert.butyl catechol.

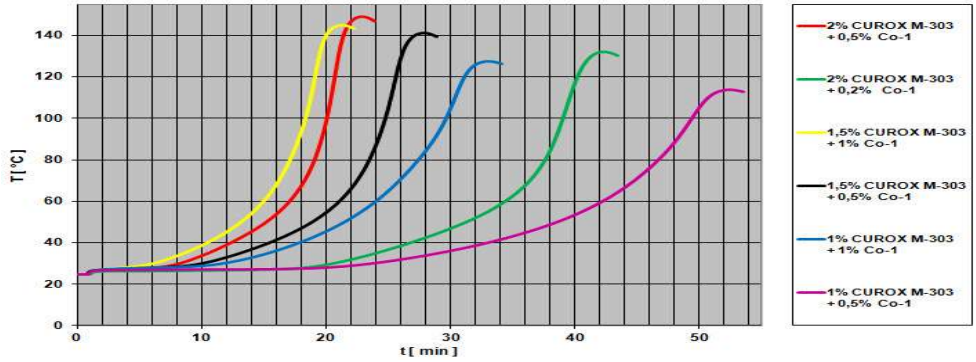
CURING PERFORMANCE: Moderate evolution of heat. Relatively long mould release time, moderate mould release factors. Temperatures below 20°C prolong curing times considerably, alternatively cobalt / amine accelerators should then be used.

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

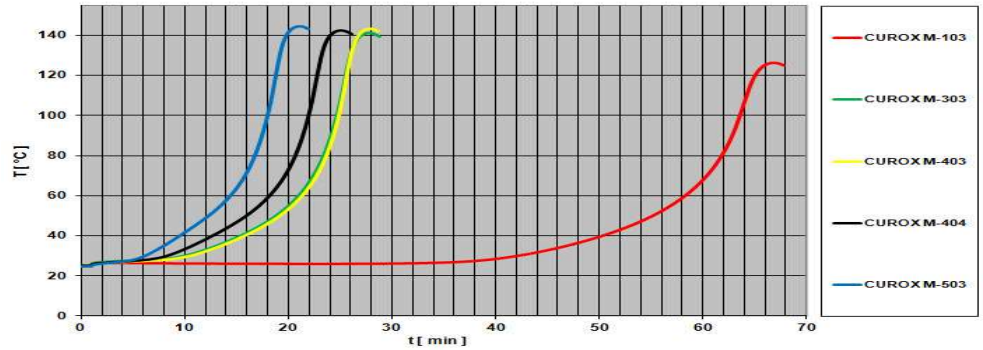
SPRAY EQUIPMENT: Use spray equipment in accordance with manufacturer's instructions. Ensure all safety devices are operational. Do not clear gun by spraying MEKP into the air.

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

Activity:



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-303	[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 t_{gel}	[min]	8.0	20.5	6.0	10.0	11.5	23.5
Gel time 25 -35°C t_{gel}	[min]	10.5	24.0	8.5	13.0	15.5	29.0
Curing time t_{max}	[min]	23.0	42.5	21.0	28.0	33.0	53.0
Peaktemperature T_{max}	[°C]	149	132	145	141	127	114



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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
CUROX® M-103	[Vol-%]	1.5				
CUROX® M-303	[Vol-%]		1.5			
CUROX® M-403	[Vol-%]			1.5		
CUROX® M-404	[Vol-%]				1.5	
CUROX® M-503	[Vol-%]					1.5
BÜFA® Accelerator Co 1	[Vol-%]	0.5	0.5	0.5	0.5	0.5
Curing data						
Gel time 25 - 30°C t_{gel}	[min]	42.0	10.0	10.5	8.5	6.0
Gel time 25 - 35°C t_{gel}	[min]	47.0	13.0	13.5	11.0	8.0
Curing time t_{max}	[min]	66.5	28.0	28.0	25.0	21.0
Peaktemperature T_{max}	[°C]	127	141	143	143	145

Standard Packaging

The standard package size of Curox®M-303R are 5 kg and 25 kg polyethylene bottles.

Disclaimer

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Revision number: 1.0. Date: 01.07.2014. Device M: TDS.