



*1
 C=Corrosion
 A/B=Acrylic Bonding
 V/R=Infusion/RTM
 GP=General Purpose
 LH=Low HAP below 35%
 VE=Vinyl Ester
 MC= Marble/ Casting Resin
 FR=Fire Retardant

ORCACOMPOSITES.COM
 General Purpose Marine Laminating Resins
 ABS & Acrylic Bonding Resins
 Filled and Fillable resins
 ISO Corrosion Resins
 Fire Retardant Resins (Ortho, Iso and V/E)
 Marble/Casting Resins
 RTM/Infusion/Closed Mold Resins
 Vinyl Ester Corrosion resins

ORCA PRODUCT #	140	200/203	212/216/218	237	245	250
Type *1	V/R O/D	O GP	OD LH	O GP	O FR	GP UV SURF
Gel Time	VARIES	VARIES	VARIES	VARIES	VARIES	VARIES
Viscosity, 77°F	100-200	VARIES	VARIES	400-600	600-800	400-600
Elongation %	1.7%	2.5%	2.2%	3.7%	1.8%	1.6%
Tensile Strength (psi)	9,246	11,313	8,848	11,700	30,505	7,251
Flexural Strength (psi)	17,352	15,228	16,680	20,800	65,225	19,144
Flexural Modulus (psi)	611,603	436,564	552,885	490,000	2,210,010	580,151
Barcol Hardness, 934-1	47	45	45	41	43	40
Heat Distortion Temp	162°F	162°F	153°F	244°F	175°F	158°F

ORCA PRODUCT #	281	301	316	425	430	435
Type *1	O LH	C ISO	ID BLEND	MC O	MC O	MC O
Gel Time	VARIES	VARIES	VARIES	VARIES	VARIES	VARIES
Viscosity, 77°F	400-600	VARIES	VARIES	VARIES	VARIES	VARIES
Elongation %	2.0%	1.7%	2.0%	3.2%	2.0%	1.6%
Tensile Strength (psi)	9,000	8,532	8,690	12,600	7,977	10,298
Flexural Strength (psi)	14,000	16,637	16,658	21,400	14,940	15,809
Flexural Modulus (psi)	590,000	597,380	306,308	630,000	609,159	580,151
Barcol Hardness, 934-1	47	48	47	47	43	45
Heat Distortion Temp	203°F	194°F	174°F	144°F	148°F	167°F

ORCA PRODUCT #	456	511	512	515	516	555
Type *1	MC O	V/R VE	BIS A VE	LH VE BLEND	VE BLEND	VE
Gel Time	VARIES	VARIES	VARIES	VARIES	VARIES	VARIES
Viscosity, 77°F	VARIES	100-200	VARIES	VARIES	VARIES	VARIES
Elongation %	2.2%	2.9%	6.2%	3.4%	4.2%	4.5%
Tensile Strength (psi)	7,252	12,228	12,800	10,733	10,824	12,618
Flexural Strength (psi)	13,053	20,618	22,000	18,347	19,340	20,015
Flexural Modulus (psi)	522,136	604,893	500,000	544,763	526,443	536,640
Barcol Hardness, 934-1	40	54	39	43	42	41
Heat Distortion Temp	144°F	230°F	248°F	196°F	200°F	239°F

The information herein is general information designed to assist customers in determining whether Orca products are suitable to their applications and intended for sale to industrial and commercial customers. We require customers to inspect and test our products before use and to satisfy themselves as to contents and suitability for their specific applications. Nothing herein constitutes any warranty express or implied, including any warranty of merchantability or fitness for a particular purpose, nor is any protection from any law or patent to be inferred. The exclusive remedy for all proven claims is limited to replacement of our materials and in no event shall we be liable for special incidental or consequential damages.

Orca Composites manufactures and formulates products to customers' requirements. In our lab, we are able to change viscosity, gel time, trim time, elongation, thix index and other crucial properties to suit what you are looking for your project. Please reach out to your local sales rep for more information.

