



SIL65AB-895S

Orthophthalic Laminating Resin

Technical Data Sheet

SIL65AB-895S is an unsaturated polyester laminating resin used in the manufacture of glass fiber reinforced composites. **SIL65AB-895S contains wax for styrene suppression.** Cured surfaces should be sanded before further lamination.

FEATURES	BENEFITS
• Excellent Wet-Out of Glass Fibers	• Makes high strength composite structures
• High Thixotropic Index	• Controls against sliding on vertical surfaces
• Low Exotherm, Long Trim Time During Cure	• Gives good surface appearance
• Excellent Impact Resistance	• Highly durable composite physicals
• Contains Wax Suppressant	• Reduces emissions of Hazardous Air Pollutants
• Contains Blue Catalyst Indicator Dye	• Blue color fades as catalyst activates resin gelation

RELATED PRODUCTS	GEL TIME
SIL65AB-895W	13-18 Minutes
SIL65AB-895	15-20 Minutes
SIL65AB-895SS	28-34 Minutes

LIQUID PROPERTIES	RESULTS
Viscosity, Brookfield Model RV #2 Spindle @ 20 rpm, 77°F (25°C), cPs	400-600
Thixotropic Index	2.5-3.5
100 grams resin @ 77°F (25°C), initiated with 1.12% DDM-9 by weight * Gel Time, min:sec Gel to Peak Exotherm Time, min:sec Peak Exotherm	18:00-24:00 10:00-17:00 290-340°F (143-171°C)
Non-Volatile Content, %	56.0-59.0
Hazardous Air Pollutant (Styrene) Content, %	< 44.0
Specific Gravity	1.02-1.14
Volatile Emissions, SCAQMD Rule 1162 Can Lid, gm/m ²	≤ 60

TYPICAL PROPERTIES					
Thickness Construction	1/8 inch (3.2 mm) Casting		1/8 inch (3.2 mm) Laminate		
	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.

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