

# Crystic VE671

## Bisphenol A Vinyl Ester Resin

### Introduction

**Crystic VE671** is a Bisphenol A epoxy based, standard vinyl ester resin.

**Crystic VE671** has outstanding chemical resistance to a wide range of substances, (acids, alkalies, oxidising agents) at room and elevated temperatures.

### Application

It is suitable for fabrication of fibre reinforced composites by all conventional techniques (contact moulding, filament winding and injection moulding) and for use in many chemical processing industry applications (storage tanks, vessels, ducts).

**Crystic VE671** is also used extensively in hot cure system for production of chemical resistant profiles by Pultrusion process.

### Features and Benefits

**Crystic VE671** is more reactive than **Crystic VE676** because of lower molecular weight. It has a lower styrene content and, also, a lower viscosity than **Crystic VE676**.

TYPICAL PROPERTIES (Test methods as in BS 2782 )

Property		Liquid Resin
Acid value	mgKOH/g	max. 9
Viscosity Brookfield RVT @ 25°C	mPas	450 ± 50*
Colour Gardner		max. 7
Volatile content	%	40 ± 2
Desnity at 20°C	g/ml	1.04 – 1.06
Shelf life (max 25°C, in the dark)	months	6
Geltime @ 25°C using: 100g resin 1.2 ml Accelerator D, DMA ( 10 % ) 3.0 ml Accelerator G, Co ( 1% ) Solution 2.0g Butanox LPT	minutes	14 – 20*
Time to peak	minutes	22 – 52
Peak exotherm	°C	160-180

\*Variants available, on request, designed for improved fabrication.

**NB:** LPT catalyst should be used in order to reduce the possibility of foam formation.

Property			Cured cast resin *
Tensile strength	**	MPa	80
Tensile modulus	**	GPa	3.4
Elongation to break	**	%	4 – 5
Flexural strength	**	MPa	130
Barcol hardness	**	-	40
HDT	***	°C	100 - 105
Water absorption: 7 days	**	mg	40

\*\* Curing Schedule : 24 hrs at 20 °C followed by 3 hrs at 80 °C.

\*\*\*Curing Schedule : 24 hrs at 20 °C followed by 5 hrs at 80°C and then 3 hrs at 120 °C.  
(Test methods as in BS 2782 )

Laminate Property	at different temperature					
Temperature (°C)	23°C	65 °C	93°C	107°C	121°C	149°C
Flexural Strength (MPa)	208	196	188	100	38	22
Flexural Modulus (GPa)	7.6	6.9	5.5	3.3	1.6	1.6
Tensile Strength (MPa)	137	139	145	124	76	50
Tensile Modulus (GPa)	9.2	8.9	8.5	6.2	4.3	-
Compressive Strength (MPa)	214	-	-	-	-	-
Glass Content (%)	40					
Laminate Construction:	V/M/M/WR/M/WR/M					

V = veil, M = CSM, WR = woven roving  
(Test methods as in BS 2782 )

## Post Curing

Satisfactory laminates for many applications can be made from **Crystic VE671** by curing at ambient temperature (20°C). For optimum properties and long term performance laminates should be post cured before being put into service. The laminate should be allowed to cure for 24 hours at 20°C and then be oven cured for a minimum of 3 hours at 80°C; the time will be dependent upon the thickness of the laminate. Post curing at 100°C is advisable for high operating temperatures.

## Chemical Resistance

**Crystic VE671** has excellent chemical resistance to a wide range of substances (acids, alkalis, oxidising agents) at room and elevated temperatures. A separate technical leaflet offers the user a comprehensive guide to the use of **Crystic VE671** based laminates in a wide variety of chemical environments.



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### **Storage**

Resin should be stored in dark. It is recommended that storage temperature should be less than 20°C, but should not exceed 25°C. In addition, it can be recommended that the vinyl ester resin is weekly aerated with dry and oil free air for 30 minutes through dip pipe (Note: this dip pipe should not contain any zinc or copper alloy). This is done to improve efficiency of inhibitor in order to extend the shelf life of the resin.

### **Packaging**

200 Kg resin is supplied in epoxy coated drums.

### **Health & Safety**

Please see separate Material Safety Data Sheet.

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