AOC
World Leader in Resin Technology

Vipel® L704-FCW Series Polyester Resin

Product Information

Vipel® Isophthalic Based Resin for Underground Sewer Pipe Liners

TYPICAL FILLED LIQUID RESIN PROPERTIES* see back page

	Nominal
Viscosity @ 77°F/25°C, RVF Brookfield (with ATH-filler)	
Spindle #4 @ 20 RPM, cps.	3,200
Thix Index 2/20	2.5+
Color	Opaque
Specific Gravity @ 77°F/25°C	1.255
Styrene, %	40
Gel Time @ 140°F with	
.77% Cumene Hydroxide 90%, minutes	55
Pot Life @ 77°F/25°C	>24

TYPICAL FILLED CAST MECHANICAL PROPERTIES* (2) See back page

		Test Method
Tensile Strength, psi/MPa	8,000/58	ASTM D 638
Tensile Modulus, psi/GPa	730,000/5.0	ASTM D 638
Tensile Elongation, %	2	ASTM D 638
Flexural Strength, psi/MPa	12,000/83	ASTM D 790
Flexural Modulus, psi/GPa	750,000/5.2	ASTM D 790
Heat Distortion Temperature, °F/°C @ 264 psi	207/97	ASTM D 648
Barcol Hardness	40	ASTM D 2583

*Typical properties are not to be construed as specifications.

DESCRIPTION

The Vipel L704-FCW Series is a filled high molecular weight isophthalic/unsaturated polyester resin for use exclusively for Over the Hole Installations of large diameter pipe . The Vipel L704-FCW series provides the corrosion resistance, durability and toughness that is required for cured in place pipe applications.

BENEFITS

- Excellent catalyzed pot life
- Superior mechanical properties
- High molecular weight
- High viscosity version

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PERFORMANCE GUIDELINES

A. Keep full strength catalyst levels between 1.0% - 3.0% of the total resin weight.

B. Beyond 14 days from manufacture date, additional promoter may be required to achieve the desired gel time.

STORAGE STABILITY

Resins are stable for three months from date of production when stored in the original containers away from sunlight at no more than 70°F/21°C. After extended storage, some drift may occur in gel time.

During the hot summer months, no more than two months stability at 86°F/30°C should be anticipated.

SAFETY

See appropriate Material Safety Data Sheet for guidelines.

ISO 9001:2000 CERTIFIED

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2000 standards. This certification recognizes that each AOC facility has an internationally accepted model in place for managing and assuring quality. We follow the practices set forth in this model to add value to the resins we make for our customers.

FOOTNOTES

(1)

The pot life times shown are typical but may be affected by catalyst, promoter and inhibitor concentrations in resin, and environmental temperature. Variations in gelling characteristics can be expected between different lots of catalysts and at extremely high humidities. Pigment and fillers can retard or accelerate gelation. It is recommended that the fabricator check the gelling characteristics of a small quantity of resin under actual operating conditions prior to use.

(2)

Based on tests on Vipel® L704-FCW pipe at 77°F/25° and 50% relative humidity. Castings were prepared using .77% Cumene Hydroxide.

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Effective Date: March, 2006