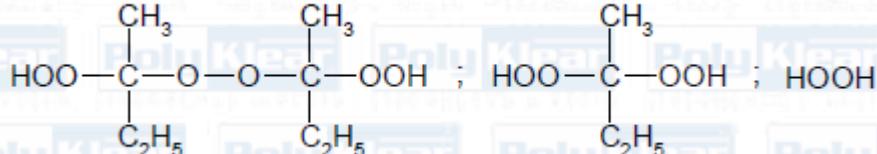




TECHNICAL DATA SHEET KLEARNOX-100

PRODUCT DESCRIPTION

Methyl ethyl ketone peroxide, in solvent mixture



CAS No. : 1338-23-4

SPECIFICATIONS

Appearance : Clear and colorless liquid
Total active oxygen : 9.8-10.0%

CHARACTERISTICS

Density, 20°C : 1.120 g/cm³
Flash point: : 37°C (closed cup)
> 63°C (open cup)

STORAGE

Due to the relatively unstable nature of organic peroxides, a loss of quality can be detected over a period of time. To minimize the loss of quality, it is recommended that the maximum storage temperature ($T_{s\max}$) be:

For Klearnox-100 $T_{s\max} = 25^\circ\text{C}$
 $T_{s\min} = -10^\circ\text{C}$

When stored under the recommended storage conditions, Klearnox-100 will remain within the specifications for a period of at least 3 months after delivery.

THERMAL STABILITY

Organic peroxides are thermally unstable substances, which may undergo self-accelerating decomposition. The lowest temperature at which self-accelerating decomposition of a substance in the original packaging may occur is the Self-Accelerating Decomposition (SADT). The SADT is determined on the basis of the Heat Accumulation Storage Test.

For Klearnox-100 SADT = 55°C

The Heat Accumulation Storage Test is a recognized test method for the determination of the SADT of organic peroxides (see Recommendations on the Transport of Dangerous Goods, Manual of Tests and Criteria – United Nations, New York and Geneva).

MAJOR DECOMPOSITION PRODUCTS

Carbon dioxide, water, acetic acid, formic acid, propanoic acid, methyl ethyl ketone

PACKAGING AND TRANSPORT

The standard packaging is a 20L HDPE can for 20kg peroxide solution.

Both packaging and transport meet the international regulations. For the availability of other packed quantities, contact your sales representative.

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SAFETY AND HANDLING

Klearnox-100 is classified as Organic Peroxide Type D; liquid; Division 5.2; UN 3105, PG II.

APPLICATIONS

Please refer to Material Safety Data Sheet (MSDS) for further information on the safe storage, use and handling of Klearnox-100. This information should be thoroughly reviewed prior to acceptance of this product.

Dosing

Depending on working conditions, the following peroxide and accelerator dosage levels are recommended:

Klearnox-100	1-4%
Accelerator	0.5-1%

Cure characteristics

In a high reactive standard orthophthalic resin in combination with accelerator, the following application characteristics were determined:

Gel times at 20°C

2% Klearnox-100 + 0.5% Accelerator	13 minutes
2% Klearnox-100 + 1% Accelerator	7 minutes

Cure at 4mm laminates at 20°C

4mm laminates have been made with 450 g/m² glass chopped strand mat. The glass content in the laminates is 30% (w/w)

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The following parameters were determined:

- Time-temperature curve
- Speed of cure expressed as the time to achieve a Barcol hardness (934-1) of 0-5 and 25-30, respectively.
- Residual styrene content after 24 hours at 20°C and a subsequent postcure of 8 hours at 80°C

	Gel time (min)	Time to peak (min)	Peak Exotherm (°C)
2% Klearnox-100 + 0.5% Accelerator	14	30	51
2% Klearnox-100 + 1.0% Accelerator	6	21	74

	Barcol		Res. Styrene	
	0-5 (h)	25-30 (h)	24h 20°C (%)	+ 8h 80°C (%)
2% Klearnox-100 + 0.5% Accelerator	<1	4	6.5	0.5
2% Klearnox-100 + 1.0% Accelerator		<1	4.9	0.3

Pot life at 20°C

2% Klearnox-100	22h
4% Klearnox-100	13h

Solubility

Klearnox-100 is miscible with phthalates and slightly miscible with water.

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