

# Atlac® E-Nova MA 6325

## Low Styrene Epoxy Bisphenol-A modified Vinyl ester resin for Marine skin coats

Atlac® E-Nova MA 6325 resin is broadly used for making fiber reinforced components through Hand lay-up and Spray-up processes. Skin coats based on Atlac® E-Nova MA 6325 resin provide great hydrolysis resistance.

Atlac® E-Nova MA 6325 has been certified by Lloyd's Register and RINA for use in Marine applications.

### Benefits

- Easy processing through excellent de-aeration and fiber wetting
- Great hydrolysis resistance
- Certified by Lloyd's Register and RINA
- Low styrene content (less than 35 %), complying with SCAQMD 1162 rule

## Major Applications

Atlac® E-Nova MA 6325 is developed as high solid tie coat resin with monomer content of less than 35% for marine applications.

Atlac® E-Nova MA 6325 has excellent wet out and air-release properties. Compared to conventional Vinyl ester resins foaming after MEK peroxide addition is highly reduced in Atlac® E-Nova MA 6325 leading to less air inhibition inside the laminate and on the surface.

Due to its high osmotic resistance Atlac® E-Nova MA 6325 is used as a tie coat resin to eliminate blistering in marine and swimming pool applications. Atlac® E-Nova MA 6325 is especially adapted to meet the requirements of hand layup and spray up applications.

Since it contains less than 35% of monomer, Atlac® E-Nova MA 6325 meets the SCAQMD 1162 rule.

## Certifications and Approvals

Cured Atlac® E-Nova MA 6325 is certified by Lloyd's Register and Registro Italiano Navale (R.I.Na) for use in Marine applications.

### Product Specifications

Property	Value	Unit	TM
Appearance	Hazy		TM 2265
Solids content	65 - 67	%	TM 2033
Viscosity 23 °C, 2 s <sup>-1</sup>	1000 - 2000	mPa.s	TM 2313
Viscosity 23 °C, 20 s <sup>-1</sup>	450 - 700	mPa.s	TM 2313
Viscosity 23 °C, 250 s <sup>-1</sup>	250 - 350	mPa.s	TM 2313
Gel time 25 until 35 °C	25 - 31	min	TM 2625
Peak time	33 - 43	min	TM 2625
Peak temperature	125 - 155	°C	TM 2625
Water content	0.05 - 0.1	%	TM 2350

Viscosity measurement: Z2/ 23 °C. Reactivity determined with 1.50 g (MEKP) Medium reactive Methyl Ethyl Ketone Peroxide added to 100 g of resin.

## Liquid

Property	Value	Unit	TM
Density 23 °C	1000	kg/m <sup>3</sup>	TM 2160
Flash point	33	°C	TM 2800
Stability (no initiator, dark, 25°C)	6	month	

## Solid Unfilled

Property	Value	Unit	TM
Tensile strength	70	MPa	ISO 527-2
Tensile modulus	4	GPa	ISO 527-2
Elongation at break	2.5	%	ISO 527-2
Flexural strength	120	MPa	ISO 178
Flexural E-Modulus	4	GPa	ISO 178
HDT	110	°C	ASTM D648
Water absorption	0.5	wt%	ISO 175

Cured with 1.5 g (MEKP) Medium reactive Methyl Ethyl Ketone Peroxide added to 100 g of resin. After 24 h. at RT, a post curing for 6 h. at 100°C was applied.

Water absorption value after 24 h. at 60 °C.

## Application Guidelines

Before use, the resin should be conditioned at a well-defined application dependent temperature (usually 15°C minimum for a MEKP/ Cobalt cure). Stir the resin thoroughly before use.

## Brochures

You can find additional information through the Atlac® Product Guide. For detailed information on the chemical resistance of Atlac® resins, please consult our Chemical Resistance Guide. Both brochures are available for download from the AOC web site ([www.aocresins.com](http://www.aocresins.com)).

## Storage Guidelines

The resin should be stored in a dark and dry place at temperatures between 5°C and 30°C. Shelf life is reduced at higher temperatures and the properties of the resin might change during storage.

The shelf life of styrene containing vinylester resins will be significantly reduced when exposed to light. Store dark and in 100% light tight containers only.

## Material Safety

A Safety Data Sheet (SDS) of this product is available on request.

## Test Methods

Test methods (TM) referred to in the table(s) are available on request.

## ISO 9001:2015 Certified

The Quality Management Systems at every AOC manufacturing facility have been certified as meeting ISO 9001:2015 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.

## AOC. Trusted Solutions

AOC is the leading global supplier of resins and specialty materials which enable customers to create robust, durable and versatile products and components. With strong capabilities around the world in manufacturing and science, the company works closely with customers to deliver unrivaled quality, service and reliability for today, and create innovative solutions for tomorrow. Partner with AOC and we will work together to find the right solutions for your business.

### Contact us for more information

We will help you to choose the right resin solution.

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