



F1 HARDENER

Applications

F1 hardener is used for applications such as a hand lay-up, spray up, centrifugal casting, filament winding, polyester concrete, etc. It is particularly suitable for gel coat curing. Its low viscosity makes it ideal for spray-up techniques (airless) with external mixing.

Cure Performance

The factors to be considered in selecting the optimum initiator / accelerator system are:

1. process
2. Resin type
3. Required gel time or pot-life
4. Part thickness
5. Room temperature
6. Nature and quantity of additives
7. Dosage optimization between Sentinel Hardener and accelerator

Sentinel Hardener is Methyl Ethyl Ketone Peroxide used for the cure of unsaturated polyester resins at room temperatures in combination with a cobalt accelerator.

Typical Properties

Density at 20°C	1,128g/ml
Viscosity at 20°C	16mPa s
SADT (self-accelerating decomposition temp.)	65°C
Flash point (setpoint)	60°C

Product can be stored maximum three months after receiving date, if kept in appropriate conditions and below its maximum storage temperature. Refer to the Safety Data Sheet for detailed storage instructions.

Dosage

Sentinel Hardener is recommended for the curing of ortho- and isophthalic resins at temperatures between 15°C and 50°C. Concentration at a rate of between 1 and 4% by weight based on resin, depending on weather conditions.

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