PLASTI CHEMIE
Produktionsgesellschaft mbH

Riverstone® 1005

Methacrylate first layer and Casting resin
cold-hardening, low-viscosity,

Application: Riverstone® 1005 is a cold hardening, pigment able methyl methacrylate that resin can be brushed or rolled on.

Properties: Riverstone® 1005 is a reactive methacrylate resin which is suitable not only as a first layer but also as binding agent. Riverstone® 1005 is reactive methacrylate resin, which is suitable for layer-resin and binding-agent. The layer-resin has a thickness between 0,2 – 0,4 mm. Units that are mechanically high loadable, temperature resistant hygienically harmless, free of pores, soil-resisting, easy to work and to work with, can be produced with fin fillers. Riverstone® 1005 forms surfaces with excellent light- and weather resistance.

Specifications:

Properties in conditions of delivery:

	measurement method	values	unit
Density 20ºC	DIN 51757	0,99	g/cm³
Refractive index, n_D 20	DIN 53491	1,43 – 1,44	
Colour number	DIN 53409	< 50	APHA
Acid number	DIN 53402	< 1	
Viscosity	DIN 51550	75 – 100	mPa·s
Draining time, ISO-beaker 4mm	DIN 2431	40 – 60	sec
Flash point	DIN 51755	+ 10	ºC
Polymerisation time	20 g resin +0,75% B-101** +1% BPO 50% conc.	30 – 40	min
Pot life*	100 g resin +0,5% B-101** +1% BPO 50% conc.	20 – 25	min

*Test in normal climate

** B-101 = accelerator 101

Properties in hardened condition:

	measurement method	values	unit
Bulk density	DIN 53479	1,18	g/cm³
Indentation hardness	DIN 53456	≥ 130	N/mm²
Shore-hardness D	DIN 53505	≥ 80	
Water absorption	DIN 53495/C	0,1	%
Surface resistance	DIN 53482	10^{13} – 10^{14}	Ω
Current flow resistance	DIN 53482	10^{15} – 10^{16}	Ω·cm

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Riverstone® 1005

Methacrylate first layer resin
cold-hardening, low-viscosity, non-accelerated

Processing:

Riverstone® 1005 hardens out after admixture of 0,5 – 0,75% hardness powder in layer thickness between 0.2 – 0,4 mm (consumption 200 – 400 g/m) within 45 minutes at room temperature. Riverstone® 1005 can be painted on the mold by brush or painting – roll. You can spray it after diluting Riverstone® 1005 with maximal 30% of Riverstone® 10015 (pre-trials are necessary). Riverstone® 1005 is pigment able and it can come to a thixotropication after the admixture of max. 2% Aerosil®.

If you spread Riverstone® 1005 on molds pay attention with it the fin paraffin wax doesn't get destroyed by over coating it, otherwise there will be partial indurations – interferences.

Processing of casting – resin

Riverstone® can not only be used as a pre-layer resin but also as binding for casting – resin.

Formulation-recommendation for casting - mass:

R1005/1

Riverstone® 1005	40-60 GT
aluminium - hydroxide < 100 ∝m	60-40 GT
pigment - paste	0-10 GT
Degament 1020	0-10 GT
hardness - powder or hardness - liquor	2- 4 GT

R 1005/2

Riverstone® 1005	40-60 GT
calcium - carbonate < 100 ∝m	60-40 GT
pigment - paste	0-10 GT
Degament 1020	0-10 GT
hardness – powder or hardness – liquor	2- 4 GT

The mixture has to be well homogenized and it has to be degassed in a vacuum before putting the hardener to it.

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