

Typical Gel Times for DERAKANE 470 Resins using MEKP

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	2.00% MEKP 0.30% CoNap 0.20% DMA	2.00% MEKP 0.20% CoNap 0.10% DMA	1.50% MEKP 0.20% CoNap 0.05% DMA
Warm – 70s°F 21°-26°C	2.00% MEKP 0.30% CoNap 0.05% DMA	1.50% MEKP 0.20% CoNap 0.05% DMA	1.00% MEKP 0.15% CoNap 0.05% DMA
Hot – 80s°F 27°-32°C	1.50% MEKP 0.20% CoNap 0.05% DMA*	1.00% MEKP 0.15% CoNap 0.05% DMA	1.00% MEKP 0.15% CoNap

Materials used with DERAKANE 470 series resins are 6% cobalt naphthenate (CoNap); 100% N, N-dimethylaniline (DMA); and MEKP (9% active oxygen). Because of the reactive nature of these products, gel times can vary.

Always test gel times with a small amount of resin before formulating large quantities.

*May be reduced or omitted at higher temperatures.

Typical Gel Times for DERAKANE 470 Resins using BPO and DMA

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	2.00% BPO 0.20% DMA	1.50% BPO 0.15% DMA	1.50% BPO 0.10% DMA
Warm – 70s°F 21°-26°C	1.50% BPO 0.15% DMA	1.00% BPO 0.10% DMA	1.00% BPO 0.05% DMA
Hot – 80s°F 27°-32°C	1.00% BPO 0.10% DMA	1.00% BPO 0.05% DMA	

Formulation was based on 98% active benzoyl peroxide (BPO); consequently, 2_{1/2} times as much of a 40% paste is required.

Because of the reactive nature of these products, gel times can vary.

Always test gel times with a small amount of resin before formulating large quantities.

Typical Gel Times for DERAKANE 470 Resins using BPO and DEA

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	1.50% BPO 0.40% DEA	1.50% BPO 0.30% DEA	1.50% BPO 0.20% DEA
Warm – 70s°F 21°-26°C	1.20% BPO 0.25% DEA	1.00% BPO 0.20% DEA	1.00% BPO 0.10% DEA
Hot – 80s°F 27°-32°C	1.00% BPO 0.15% DEA	1.00% BPO 0.10% DEA 0.01% TBC	0.80% BPO 0.10% DEA 0.03% TBC

Formulation was based on 98% active benzoyl peroxide (BPO); consequently, 2_{1/2} times as much of a 40% paste is required.

Materials used with DERAKANE 470 series resins are 100% N, N-diethylaniline (DEA) and a 10% tert-butylcatechol (TBC) solution. Since formulation was based on 100% active TBC, 10 times as much of a 10% solution is required.

Because of the reactive nature of these products, gel times can vary.

Always test gel times with a small amount of resin before formulating large quantities.

*Gel times will be slower than shown here for DERAKANE 470-300, but this table provides an accurate base from which to work.



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Typical Gel Times for DERA KANE 470 Resins Using CHP

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C		2.00% CHP 0.30% CoNap 0.20% DMA	2.00% CHP 0.20% CoNap 0.05% DMA
Warm – 70s°F 21°-26°C	1.50% CHP 0.30% CoNap 0.15% DMA	1.50% CHP 0.20% CoNap 0.05% DMA	1.00% CHP 0.20% CoNap
Hot – 80s°F 27°-32°C	1.00% CHP 0.30% CoNap 0.10% DMA	2.00% CHP 0.10% CoNap	1.00% CHP 0.10% CoNap

Materials used are 6% cobalt naphthenate (CoNap); 100% N, N-dimethylaniline (DMA); and CHP (80% active peroxide). Because of the reactive nature of these products, gel times can vary. Always test gel times with a small amount of resin before formulating large quantities.

Typical Gel Times for DERA KANE 470-300 Resin using MEKP

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	2.00% MEKP 0.30% CoNap 0.10% DMA	1.50% MEKP 0.20% CoNap 0.05% DMA	1.00% MEKP 0.20% CoNap 0.05% DMA
Warm – 70s°F 21°-26°C	1.50% MEKP 0.30% CoNap 0.05% DMA	1.00% MEKP 0.25% CoNap 0.05% DMA	1.00% MEKP 0.15% CoNap 0.05% DMA
Hot – 80s°F 27°-32°C	2.00% MEKP 0.20% CoNap 0.05% DMA*	1.00% MEKP 0.20% CoNap 0.05% DMA	1.00% MEKP 0.15% CoNap 0.05% DMA

Materials used with DERA KANE 470-300 resin are 6% cobalt naphthenate (CoNap); 100% N, N-dimethylaniline (DMA); MEKP (9% active oxygen); and 80% CHP. Because of the reactive nature of these products, gel times can vary. Always test gel times with a small amount of resin before formulating large quantities. *May be reduced or omitted at higher temperatures.

Typical Gel Times for DERA KANE 470-300 Resin using BPO and DMA

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	2.00% BPO 0.20% DMA	1.50% BPO 0.15% DMA	1.00% BPO 0.10% DMA
Warm – 70s°F 21°-26°C	1.50% BPO 0.15% DMA	1.25% BPO 0.10% DMA	1.00% BPO 0.10% DMA
Hot – 80s°F 27°-32°C	1.50% BPO 0.15% DMA	1.50% BPO 0.10% DMA	1.00% BPO 0.075% DMA

Formulation was based on 98% active benzoyl peroxide (BPO); consequently, 2^x times as much of a 40% paste is required. Because of the reactive nature of these products, gel times can vary. Always test gel times with a small amount of resin before formulating large quantities.



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