

Typical Gel Times for all DERAKANE 510 Resins Using BPO and DMA

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	2.0% BPO 0.2% DMA	1.5% BPO 0.15% DMA	1.5% BPO 0.1% DMA
Warm – 70s°F 21°-26°C	1.5% BPO 0.15% DMA	1.0% BPO 0.1% DMA	1.0% BPO 0.05% DMA
Hot – 80s°F	1.0% BPO 0.1% DMA	1.0% BPO 0.05% DMA	

Formulation was based on 98% active benzoyl peroxide (BPO); consequently, 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.

NOTE: Antimony compounds can be added directly to DERAKANE 510 series resins and dispersed using the normal mixing equipment. Resin mixed with antimony should be stirred frequently to keep the materials well mixed. To minimize the effect of NYACOL APE-1540 on the gel time of DERAKANE resins, add the antimony compound immediately before use. If allowed to stand, resin mixed with cobalt naphthenate (CoNap) and NYACOL APE-1540 may be subject to gel time drift and may not cure properly.

Typical Gel Times for all DERAKANE 510 Resins Using BPO and DEA

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	2.0% BPO 0.4% DEA	1.5% BPO 0.2% DEA	1.5% BPO 0.2% DEA 0.01% TBC
Warm – 70s°F 21°-26°C	1.5% BPO 0.4% DEA	1.0% BPO 0.2% DEA	1.0% BPO 0.2% DEA 0.01% TBC
Hot – 80s°F 27°-32°C	1.2% BPO 0.3% DEA	1.0% BPO 0.2% DEA 0.02% TBC	1.0% BPO 0.2% DEA 0.03% TBC

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

Materials used with DERAKANE 510 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.

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

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Typical Gel Times for DERAKANE 510A Resin Using MEKP

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	2.5% MEKP	2.00% MEKP	1.25% MEKP
	0.30% CoNap	0.30% CoNap	0.30% CoNap
	0.25% DMA	0.10% DMA	0.05% DMA
Warm – 70s°F 21°-26°C	2.00% MEKP	1.25% MEKP	1.25% MEKP
	0.30% CoNap	0.30% CoNap	0.20% CoNap
	0.05% DMA		
Hot – 80s°F 27°-32°C	1.50% MEKP	1.25% MEKP	1.25% MEKP
	0.20% CoNap	0.20% CoNap	0.20% CoNap
	0.05% DMA		0.05% 2, 4-P

Materials used are 6% cobalt naphthenate (CoNap); 100% N, N-dimethylaniline (DMA); MEKP (9% active oxygen); and 100% 2, 4-pentanedione (2, 4-P). 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.

NOTE: Antimony compounds can be added directly to DERAKANE 510 series resins and dispersed using the normal mixing equipment. Resin mixed with antimony should be stirred frequently to keep the materials well mixed. To minimize the effect of NYACOL APE-1540 on the gel time of DERAKANE resins, add the antimony compound immediately before use. If allowed to stand, resin mixed with cobalt naphthenate (CoNap) and NYACOL APE-1540 may be subject to gel time drift and may not cure properly.

Typical Gel Times for DERAKANE 510C-350 Resin Using MEKP

Temperature	10–20 minutes	20–40 minutes	40–60 minutes
Cool – 60s°F 15°-20°C	1.25% MEKP	1.25% MEKP	1.25% MEKP
	0.30% CoNap	0.30% CoNap	0.30% CoNap
	0.05% DMA	0.05% DMA	0.05% DMA
Warm – 70s°F 21°-26°C	1.25% MEKP	1.25% MEKP	1.25% MEKP
	0.20% CoNap	0.20% CoNap	0.20% CoNap
	0.05% DMA	0.05% DMA	0.05% DMA
Hot – 80s°F 27°-32°C	1.25% MEKP	1.25% MEKP	1.25% MEKP
	0.20% CoNap	0.20% CoNap	0.20% CoNap
	0.05% DMA	0.05% DMA	0.05% DMA
	0.03% 2, 4-P	0.07% 2, 4-P	0.09% 2, 4-P

Materials used are 6% cobalt naphthenate (CoNap); 100% N, N-dimethylaniline (DMA); MEKP (9% active oxygen); and 100% 2, 4-pentanedione (2, 4-P).

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

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

NOTE: Antimony compounds can be added directly to DERAKANE 510 series resins and dispersed using the normal mixing equipment. Resin mixed with antimony should be stirred frequently to keep the materials well mixed. To minimize the effect of NYACOL APE-1540 on the gel time of DERAKANE resins, add the antimony compound immediately before use. If allowed to stand, resin mixed with cobalt naphthenate (CoNap) and NYACOL APE-1540 may be subject to gel time drift and may not cure properly.



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