Coatings

Application data and cure data

Nouryon is the world’s leading producer of organic peroxides for the curing of thermoset resins and coatings. We’re home to the best known brands in the thermoset market, examples include Butanox®, Perkadox® and Trigonox®. We also have a whole range of auxiliary products, such as accelerators and promoters, to meet your specific production requirements.

This application guide introduces you to our thermoset product portfolio and helps you find a suitable curing system for your specific application.

Application
Curing of UP (unsaturated polyester) resin based coatings.

Process equipment
Spray equipment and other coating equipment

Nouryon curing agents
Mainly Cyclonox® LE-50.

Main products
Coatings for furniture, wood and steel

Reactivity figures
Cyclonox LE-50
Cure of 1 mm pure resin layer at 20°C.

The speed of cure is expressed as the time to reach a Persoz hardness of respectively 30, 60 and 120 s.

<table>
<thead>
<tr>
<th>Persoz</th>
<th>30</th>
<th>60</th>
<th>120</th>
<th>s</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 phr Cyclonox LE-50 + 0.5 phr Accelerator NL-49PN</td>
<td>2.5</td>
<td>5.5</td>
<td>22</td>
<td>h</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN</td>
<td>2.4</td>
<td>4.1</td>
<td>13</td>
<td>h</td>
</tr>
<tr>
<td>2 phr Cyclonox LE-50 + 1.0 phr Accelerator NL-49PN</td>
<td>1.6</td>
<td>4.0</td>
<td>18</td>
<td>h</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>1.7</td>
<td>3.0</td>
<td>7.2</td>
<td>h</td>
</tr>
</tbody>
</table>

Reason for our products
• High quality
• Good after sales and technical service
• Intensive safety research
• Worldwide distribution
• Customized application research: special formulated products for an optimal performance in this application
Cure data

Cyclonox LE-50

Cyclonox LE-50 is a general purpose cyclohexanone peroxide for the curing of unsaturated polyester resins in the presence of a cobalt accelerator at room and elevated temperatures.

The curing system Cyclonox LE-50 with cobalt as accelerator is particularly suitable for the curing of lacquers, spray putties and in hand lay-up and spray-up applications. Moreover, the manufacture of light resistant parts may be possible contrary to the curing system based on benzoyl peroxide and an amine accelerator.

Cyclonox LE-50 shows compared to Butanox M-50 a more gradual cure with a lower peak exotherm.

Dosing
Depending on working conditions, the following peroxide and accelerator dosage levels are recommended in UP resin formulations:

<table>
<thead>
<tr>
<th>Cyclonox LE-50</th>
<th>Accelerator NL-49PN</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 - 4 phr</td>
<td>0.5 - 3 phr</td>
</tr>
</tbody>
</table>

*(parts per hundred resin)*

Cure characteristics
In a high reactive standard orthophthalic resin in combination with Accelerator NL-49PN (= 1% cobalt) the following application characteristics were determined:

**Gel times at 20°C**

<table>
<thead>
<tr>
<th>Cyclonox LE-50 + 0.5 phr Accelerator NL-49PN</th>
<th>11 minutes</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 phr Cyclonox LE-50 + 0.5 phr Accelerator NL-49PN</td>
<td>12 minutes</td>
</tr>
<tr>
<td>2 phr Cyclonox LE-50 + 1.0 phr Accelerator NL-49PN</td>
<td>6 minutes</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>7 minutes</td>
</tr>
</tbody>
</table>

**Cure of 1 mm pure resin layer at 20°C**
The speed of cure is expressed as the time to reach a Persoz hardness of respectively 30, 60 and 120 s.

<table>
<thead>
<tr>
<th>Persoz</th>
<th>30</th>
<th>60</th>
<th>120</th>
<th>s</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 phr Cyclonox LE-50 + 0.5 phr Accelerator NL-49PN</td>
<td>2.5</td>
<td>5.5</td>
<td>22</td>
<td>n</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN</td>
<td>2.4</td>
<td>4.1</td>
<td>15</td>
<td>n</td>
</tr>
<tr>
<td>2 phr Cyclonox LE-50 + 1.0 phr Accelerator NL-49PN</td>
<td>1.6</td>
<td>4.0</td>
<td>18</td>
<td>n</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>1.7</td>
<td>3.0</td>
<td>9.5</td>
<td>n</td>
</tr>
</tbody>
</table>

**Cure of 4 mm laminates at 20°C**
4 mm laminates have been made with a 450 g/m² glass chopped strand mat. The glass content in the laminates is 30% (w/w).
The following parameters were determined:

- Time-temperature curve.
- Speed of cure expressed as the time to achieve a Barcol hardness (934-1) of 0-5 and 25-30 respectively.
- Residual styrene content after 24 h at 20°C and a subsequent postcure of 8 h at 80°C.

<table>
<thead>
<tr>
<th></th>
<th>GEL TIME (min.)</th>
<th>TIME TO PEAK (min.)</th>
<th>PEAK EXOTHERM (°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 phr Cyclonox LE-50 + 0.5 phr Accelerator NL-49PN</td>
<td>10</td>
<td>29</td>
<td>40</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN</td>
<td>13</td>
<td>36</td>
<td>44</td>
</tr>
<tr>
<td>2 phr Cyclonox LE-50 + 1.0 phr Accelerator NL-49PN</td>
<td>5</td>
<td>17</td>
<td>50</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>8</td>
<td>26</td>
<td>64</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th></th>
<th>BARCOL</th>
<th>RESIDUAL STYRENE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>0.5-25 h</td>
<td>25-30 h</td>
</tr>
<tr>
<td>2 phr Cyclonox LE-50 + 0.5 phr Accelerator NL-49PN</td>
<td>5</td>
<td>23</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN</td>
<td>3</td>
<td>15</td>
</tr>
<tr>
<td>2 phr Cyclonox LE-50 + 1.0 phr Accelerator NL-49PN</td>
<td>&lt;1</td>
<td>8</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>1</td>
<td>5</td>
</tr>
</tbody>
</table>

**Pot life at 20°C**

Pot lives were determined of a mixture of Cyclonox LE-50 and a non-preaccelerated UP resin at 20°C.

- 2 phr Cyclonox LE-50: 35 h
- 4 phr Cyclonox LE-50: 21 h
Butanox M-50

Butanox M-50 is a general purpose methyl ethyl ketone peroxide (MEKP) for the curing of unsaturated polyester resins in the presence of a cobalt accelerator at room and elevated temperatures.

The curing system Butanox M-50/cobalt accelerator is particularly suitable for the curing of gelcoat resins, laminating resins, lacquers and castings; moreover, the manufacture of light resistant parts may be possible contrary to the curing system benzoyl peroxide/amine accelerator.

Practical experience throughout many years has proven that by the guaranteed low water content and the absence of polar compounds in Butanox M-50, this peroxide is very suitable in GRP products in particular for gelcoat and marine applications.

For room temperature application it is necessary to use Butanox M-50 together with a cobalt accelerator (e.g. Accelerator NL-49PN)

Dosing
Depending on working conditions, the following peroxide and accelerator dosage levels are recommended:

<table>
<thead>
<tr>
<th>Butanox M-50</th>
<th>Accelerator NL-49PN</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 - 4 phr</td>
<td>0.5 - 3 phr</td>
</tr>
</tbody>
</table>

* (parts per hundred resin)

Cure characteristics
In a high reactive standard orthophthalic resin in combination with Accelerator NL-49PN (= 1% cobalt) the following application characteristics were determined:

**Gel times at 20°C**
2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN 12 minutes
2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN 7 minutes

**Cure of 1 mm pure resin layer at 20°C**
The speed of cure is expressed as the time to reach a Persoz hardness of respectively 30, 60 and 120 s.

<table>
<thead>
<tr>
<th>Persoz</th>
<th>30</th>
<th>60</th>
<th>120</th>
<th>s</th>
</tr>
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<tbody>
<tr>
<td>2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN</td>
<td>2.4</td>
<td>4.1</td>
<td>13</td>
<td>h</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>1.7</td>
<td>3.0</td>
<td>9.5</td>
<td>h</td>
</tr>
</tbody>
</table>

*phr*
Cure of 4 mm laminates at 20°C
4 mm laminates have been made with a 450 g/m² glass chopped strand mat. The glass content in the laminates is 30% (w/w).

The following parameters were determined:
- Time-temperature curve.
- Speed of cure expressed as the time to achieve a Barcol hardness (934-1) of 0-5 and 25-30 respectively.
- Residual styrene content after 24 h at 20°C and a subsequent postcure of 8 h at 80°C.

<table>
<thead>
<tr>
<th></th>
<th>GEL TIME (min.)</th>
<th>TIME TO PEAK (min.)</th>
<th>PEAK EXOTHERM (°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN</td>
<td>13</td>
<td>36</td>
<td>44</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>8</td>
<td>26</td>
<td>64</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th></th>
<th>BARCOL</th>
<th>RESIDUAL STYRENE</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>0-5 (h)</td>
<td>25-30 (h)</td>
</tr>
<tr>
<td>24 h 20°C (%)</td>
<td>80% (%)</td>
<td></td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 0.5 phr Accelerator NL-49PN</td>
<td>3</td>
<td>15</td>
</tr>
<tr>
<td>2 phr Butanox M-50 + 1.0 phr Accelerator NL-49PN</td>
<td>1</td>
<td>5</td>
</tr>
</tbody>
</table>

Pot life at 20°C
Pot lives were determined of a mixture of Butanox M-50 and a non-preaccelerated UP resin at 20°C.

<p>| | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>2 phr Butanox M-50</td>
<td>12 h</td>
</tr>
<tr>
<td>4 phr Butanox M-50</td>
<td>7 h</td>
</tr>
</tbody>
</table>

Solubility
Butanox M-50 is miscible with phthalates and slightly miscible with water.

Colors
Butanox M-50 is available in the colors blue, yellow, red-YM 1/6 and Vanishing Red (VR).
Coatings

For ketone peroxides like methyl ethyl ketone peroxides, cyclohexanone peroxides and acetylacetone peroxide a cobalt accelerator must be used.

For this purpose the following formulations of cobalt 2 ethylhexanoate also called cobalt octoate are available:

<table>
<thead>
<tr>
<th>Accelerator</th>
<th>Cobalt Content</th>
</tr>
</thead>
<tbody>
<tr>
<td>Accelerator NL-49PN</td>
<td>1% cobalt in aliphatic ester</td>
</tr>
<tr>
<td>Accelerator NL-51PN</td>
<td>6% cobalt in aliphatic ester</td>
</tr>
<tr>
<td>Accelerator NL-53N</td>
<td>10% cobalt in white spirit</td>
</tr>
</tbody>
</table>

The reactivity of the various cobalt accelerators is directly correlated with the cobalt content. The use of a lower concentrated version increases the dosage accuracy. However, when the dosage level of e.g. Accelerator NL-49PN must be higher than approx. 3% to achieve the required cure performance, it is advised to use a higher concentrated cobalt accelerator e.g. 0.5% Accelerator NL-51PN.

The cure characteristics of an unsaturated polyester resin/ketone peroxide mixture can, apart from the choice of the ketone peroxide, very effectively be influenced by the dosage level of the cobalt accelerator. The dosage level of the cobalt accelerator expressed as Accelerator NL-53N (10% cobalt) can for this purpose be varied between e.g. 0.025% up to approximately 0.6% calculated on the UP resin.

When the right peroxide has been chosen and still the required gel time and Cure characteristics cannot be obtained with the cobalt accelerator alone, it is possible to increase the reactivity of the cobalt accelerator by the extra addition of a promoter like N,N-Dimethylaniline or Promotor D (N,N Diethylacetoacetamide).

This adaptation of the accelerator system may be necessary when:

- a very short gel time and/or a very fast cure is required e.g. for resin transfer molding or the production of polymer concrete
- highly inhibited and/or low reactive resins must be cured e.g.
- bisphenol A/fumarate and vinylester resins.

The cure system ketone peroxide/cobalt accelerator can further be characterized by:

- the relatively low color, related to the cobalt dosage, of the cured molding
- a very good UV light resistance of the molded parts
- the long pot life of the cobalt accelerator in the polyester resin
- A possible disadvantage may be that the cure system is more sensitive for moisture, pigments and fillers than the cure system dibenzoyl peroxide/ amine accelerator.

Cobalt accelerators can also be used to increase the reactivity of organic peresters, which are applied for the cure of unsaturated polyester resins at elevated temperatures. Moreover, the use of a cobalt accelerator gives in general a lower residual styrene content in the cured molding. For this application peresters like Trigonox C, Trigonox 21S, Trigonox 42S and the special mixture Trigonox 93 can be used.

Dosage
Depending on working conditions the following accelerator dosage level is recommended:

| Accelerator NL-49PN | 0.25 - 3.0 phr |

*(parts per hundred resin)
Cure characteristics
In the following cure experiments the performance of cobalt 2 ethylhexanoate as accelerator will be demonstrated.

**Gel times at 20°C**
in a standard orthophthalic resin with various ketone peroxides

<table>
<thead>
<tr>
<th>ACCELERATOR NL-49PN (PHR)</th>
<th>0.25</th>
<th>0.5</th>
<th>1</th>
</tr>
</thead>
<tbody>
<tr>
<td>2 phr Butanox M-60</td>
<td>22</td>
<td>12</td>
<td>7</td>
</tr>
<tr>
<td>2 phr Butanox LPT-IN</td>
<td>65</td>
<td>31</td>
<td>20</td>
</tr>
<tr>
<td>2 phr Cyclonox LE-50</td>
<td>20</td>
<td>11</td>
<td>6</td>
</tr>
<tr>
<td>2 phr Trigonox 44B</td>
<td>24</td>
<td>14</td>
<td>8</td>
</tr>
</tbody>
</table>

in various resins with Dimethylaniline, 100% as promoter

**standard orthophthalic resin**
2 phr Butanox M-60 + 1 phr Acc. NL-49PN + 0.05 phr Dimethylaniline, 100% 4 min.
2 phr Butanox M-60 + 1 phr Acc. NL-49PN + 0.10 phr Dimethylaniline, 100% 2 min.
2 phr Trigonox 44B + 1 phr Acc. NL-49PN + 0.05 phr Dimethylaniline, 100% 5 min.
2 phr Trigonox 44B + 1 phr Acc. NL-49PN + 0.10 phr Dimethylaniline, 100% 3 min.

**bisphenol A/fumarate resin**
2 phr Butanox LPT-IN + 3 phr Acc. NL-49PN + 0.05 phr Dimethylaniline, 100% 65 min.
2 phr Butanox LPT-IN + 3 phr Acc. NL-49PN + 0.10 phr Dimethylaniline, 100% 34 min.

**bisphenol A/vinylester resin**
2 phr Butanox LPT-IN + 3 phr Acc. NL-49PN + 0.05 phr Dimethylaniline, 100% 22 min.
2 phr Butanox LPT-IN + 3 phr Acc. NL-49PN + 0.10 phr Dimethylaniline, 100% 16 min.

**Time-temperature curves at elevated temperatures (70°C and 90°C)**

<table>
<thead>
<tr>
<th></th>
<th>CURE TEMP (°C)</th>
<th>GEL TIME (min.)</th>
<th>TIME TO PEAK (min.)</th>
<th>PEAK EXOTHERM (°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 phr Trigonox 21S</td>
<td>70</td>
<td>916</td>
<td>233</td>
<td></td>
</tr>
<tr>
<td>1 phr Trigonox 21S + 1 phr Accelerator NL-49PN</td>
<td>70</td>
<td>35</td>
<td>214</td>
<td></td>
</tr>
<tr>
<td>1 phr Trigonox 21S</td>
<td>90</td>
<td>16</td>
<td>258</td>
<td></td>
</tr>
<tr>
<td>1 phr Trigonox 21S + 1 phr Accelerator NL-49PN</td>
<td>90</td>
<td>0.3</td>
<td>1.5</td>
<td>240</td>
</tr>
<tr>
<td>1 phr Trigonox C</td>
<td>90</td>
<td>925</td>
<td>236</td>
<td></td>
</tr>
<tr>
<td>1 phr Trigonox C + 1 phr Accelerator NL-49PN</td>
<td>9</td>
<td>26</td>
<td>258</td>
<td></td>
</tr>
</tbody>
</table>

**Pot life at 20°C**
The pot life has been determined of Accelerator NL-49PN in a standard orthophthalic polyester resin at 20°C.

1 phr Accelerator NL-49PN 6 months
Contact us

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Additional information
Product Data Sheets (PDS) and Safety Data Sheets (SDS) for our polymerization initiators are available at [www.nouryon.com](http://www.nouryon.com).

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