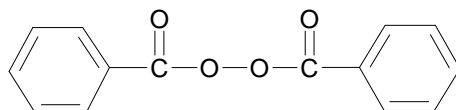




## Perkadox<sup>®</sup> CH-50

**Product description** Dibenzoyl peroxide, powder, 50% with dicyclohexyl phthalate



CAS No. : 94-36-0  
EINECS/ELINCS No. : 202-327-6  
TSCA status : listed on inventory

**Specifications** Appearance, 10-20°C : White free flowing powder  
Assay : 49.0-51.0%  
Water : 2.5% max.

**Characteristics** Bulk density : 0.640 g/cm<sup>3</sup> (40 lb/ft<sup>3</sup>)

**Storage** Due to the relatively unstable nature of organic peroxides a loss of quality can be detected over a period of time. To minimize the loss of quality, AkzoNobel recommends a maximum storage temperature (T<sub>s</sub> max.) for each organic peroxide product.

For *Perkadox* CH-50 T<sub>s</sub> max. = 25°C (77°F)

When stored under these recommended storage conditions, *Perkadox* CH-50 will remain within the AkzoNobel specifications for a period of at least 6 months after delivery.

**Thermal stability** Organic peroxides are thermally unstable substances, which may undergo self-accelerating decomposition. The lowest temperature at which self-accelerating decomposition of a substance in the original packaging may occur is the Self-Accelerating Decomposition Temperature (SADT). The SADT is determined on the basis of the Heat Accumulation Storage Test.

For *Perkadox* CH-50 SADT : 55°C (131°F)

The Heat Accumulation Storage Test is a recognized test method for the determination of the SADT of organic peroxides (see Recommendations on the Transport of Dangerous Goods, Manual of Tests and Criteria - United Nations, New York and Geneva).

**Major decomposition products** Carbon dioxide, benzene, benzoic acid, diphenyl, phenylbenzoate

## Packaging and transport

In North America *Perkadox* CH-50 is packed in non-returnable fiber cartons of 50 lb net weight.

In other regions the standard packaging is a non-returnable cardboard box of 25 kg net.

Both packaging and transport meet the international regulations. For the availability of other packed quantities consult your AkzoNobel representative.

*Perkadox* CH-50 is classified as Organic peroxide type D, solid; Division 5.2; UN 3106; PG I.

## Safety and handling

Keep containers tightly closed. Store and handle *Perkadox* CH-50 in a dry well-ventilated place away from sources of heat or ignition and direct sunlight. Never weigh out in the storage room.

Avoid contact with reducing agents (e.g. amines), acids, alkalis and heavy metal compounds (e.g. accelerators, driers and metal soaps).

Please refer to the Material Safety Data Sheet (MSDS) for further information on the safe storage, use and handling of *Perkadox* CH-50. This information should be thoroughly reviewed prior to acceptance of this product.  
The MSDS is available at [www.akzonobel.com/polymer](http://www.akzonobel.com/polymer).

## Applications

*Perkadox* CH-50 is a free flowing, fine, granular powder containing 50% dibenzoyl peroxide for the curing of unsaturated polyester resins and acrylic resins at ambient and elevated temperatures. At temperatures up to 80°C, *Perkadox* CH-50 should be used in combination with an aromatic tertiary amine accelerator, above 80°C the use of an accelerator is not required.

*Perkadox* CH-50 is easy to handle, easy to disperse and dissolves very quickly in unsaturated polyester resins and acrylic resins. When in acrylic resins a very high degree of transparency of the cured part is required the special grade *Perkadox* CH-50L is advised. The curing system *Perkadox* CH-50/amine accelerator shows a very fast cure that is hardly influenced by humidity and fillers. Even at low temperatures a relatively good cure will be obtained. A disadvantage may be the yellow color and poor light resistance of the moulded product.

For ambient temperature curing the following amine accelerators are available to adjust the gel time and speed of cure of the cure system based on *Perkadox* CH-50:

Accelerator NL-65-100 (N,N-Dimethyl-p-toluidine) for short gel times  
Accelerator NL-63-100 (N,N-Dimethylaniline) for medium gel times  
Accelerator NL-64-100 (N,N-Diethylaniline) for long gel times

## Dosing

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

<i>Perkadox</i> CH-50	2 - 5 phr <sup>*</sup>
Amine accelerator	0.05 - 0.5 phr

<sup>\*</sup> phr = parts per hundred resin

## Cure Characteristics

In a high reactive standard orthophthalic polyester resin the following application characteristics were determined.

### Gel times at 20°C

UP resin	100	100	100	100	100	100	100
<i>Perkadox</i> CH-50	3.0	3.0	3.0	3.0	3.0	3.0	3.0
Accelerator NL-63-100	0.1	0.4					
Accelerator NL-64-100			0.1	0.5			
Accelerator NL-65-100					0.05	0.1	0.4
Gel time (minutes)	22	6	160	20	20	5	1

### 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.

		Persoz: 30	60	120 s
3 phr <i>Perkadox</i> CH-50 + 0.1	phr Acc. NL-63-100	0.5	0.8	2 h
3 phr <i>Perkadox</i> CH-50 + 0.4	phr Acc. NL-63-100			<0.5 h
3 phr <i>Perkadox</i> CH-50 + 0.5	phr Acc. NL-64-100		0.5	1 h
3 phr <i>Perkadox</i> CH-50 + 0.05	phr Acc. NL-65-100	1	2.5	14 h
3 phr <i>Perkadox</i> CH-50 + 0.1	phr Acc. NL-65-100			0.5 h

### Cure of 4 mm laminates at 20°C

4 mm laminates have been made with 450 g/m<sup>2</sup> 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 24h at 20°C and a subsequent postcure of 8 h at 80°C.

		Gel time min.	Time to Peak min.	Peak exotherm °C
3 phr <i>Perkadox</i> CH-50 + 0.1	phr Acc. NL-63-100	24	31	99
3 phr <i>Perkadox</i> CH-50 + 0.5	phr Acc. NL-64-100	21	26	140
3 phr <i>Perkadox</i> CH-50 + 0.05	phr Acc. NL-65-100	28	35	64
		Barcol		Res. styrene
		0-5	25-30	24 h 20°C
		h	h	+8 h 80°C
				%
3 phr <i>Perkadox</i> CH-50 + 0.1	phr Acc. NL-63-100	<1		3.2
3 phr <i>Perkadox</i> CH-50 + 0.5	phr Acc. NL-64-100	<<1		2.9
3 phr <i>Perkadox</i> CH-50 + 0.05	phr Acc. NL-65-100	1	8.5	6.6
				0.8

### Pot life at 20°C

Pot lives were determined of a mixture of *Perkadox* CH-50 and a non-preaccelerated UP resin at 20°C.

3 phr <i>Perkadox</i> CH-50	21 days
6 phr <i>Perkadox</i> CH-50	11 days

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