

Composite applications for Marine

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Moscow, Russia

Fabienne Grandchamp

Expertise Manager RTM Marine

Ron Verleg

Expertise Manager Export

Agenda

- Welcome
- Short introduction DSM & DSM Composite Resins
- Basics on unsaturated polyesters chemistry
- Marine Application
 - Mold Making
 - Blistering of GRP boat hull due to osmosis
 - Gelcoat
 - Tiecoat
 - Structural resins for hull and decks – HLU / SU applications
 - Structural resins for hull and decks – injection techniques

- Superb adhesive for marine applications
- Case histories

DSM today

- Globally active “multi-specialty” chemical company
 - More than 200 locations, approx. 25,000 employees
- Leadership positions in ~75% of the portfolio
- R&D spent appr. € 300 million
- Solid balance sheet
 - Net debt < € 500 mln

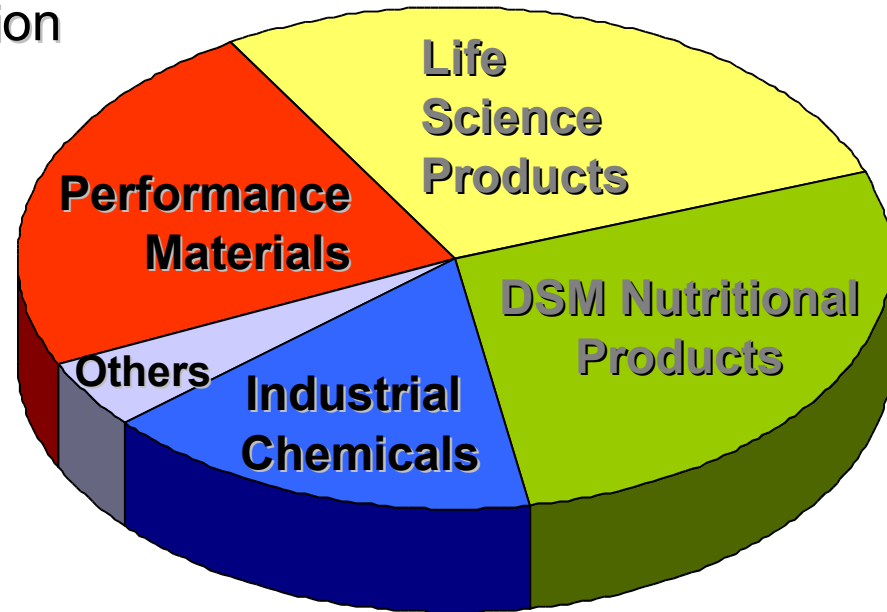
2003 key data*:

Sales : € 6,050 million

EBITDA: € 723 million

EBIT: € 294 million

* incl. one quarter DNP

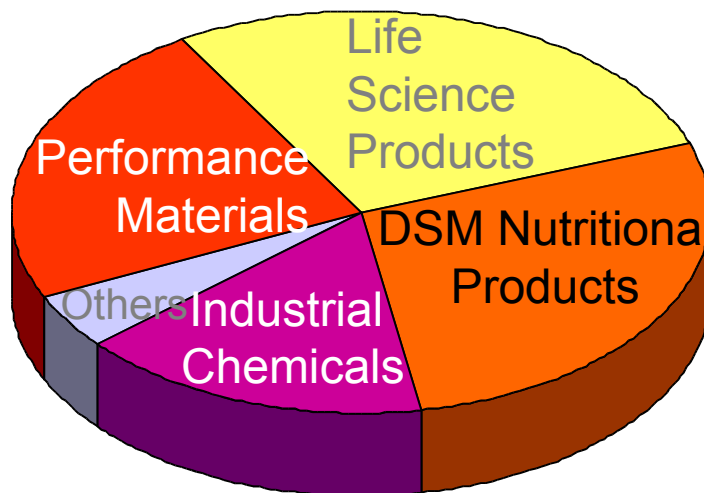
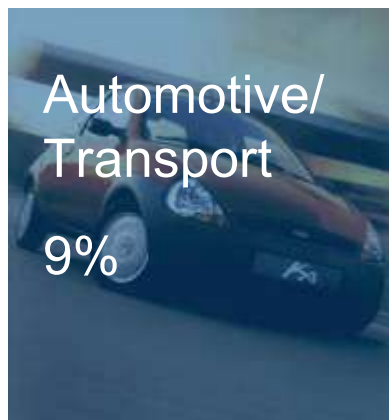


2004 E

DSM Composite Resins

Unlimited. **DSM**

DSM's key end markets



DSM Composite Resins

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DSM Worldwide

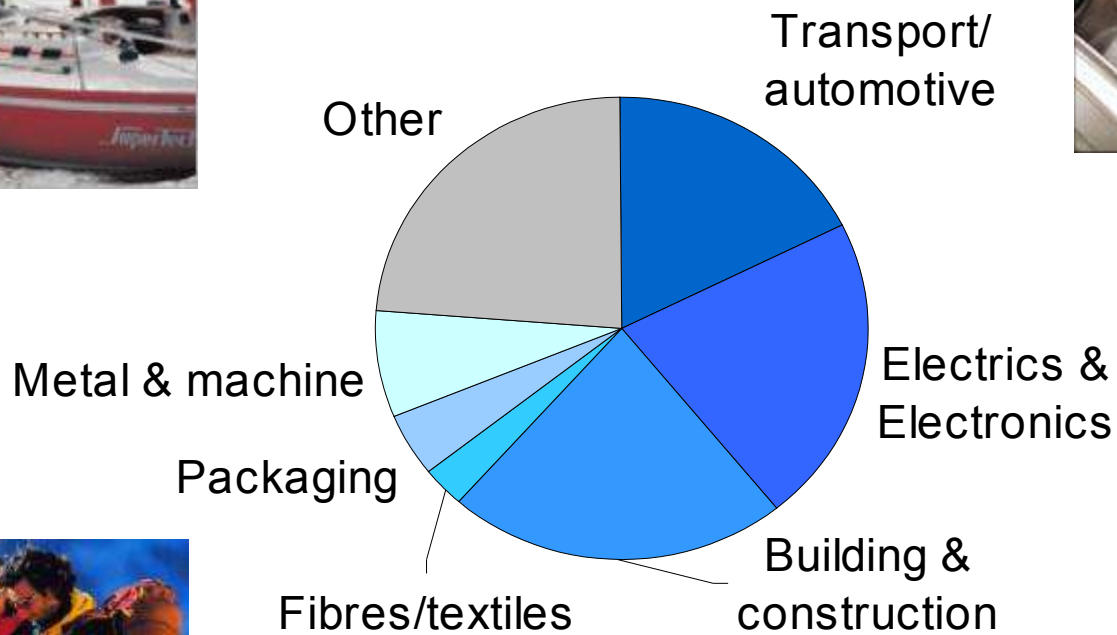


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DSM Performance Materials

End-markets



Sales 2003 € 1.6 bn

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Welcome to

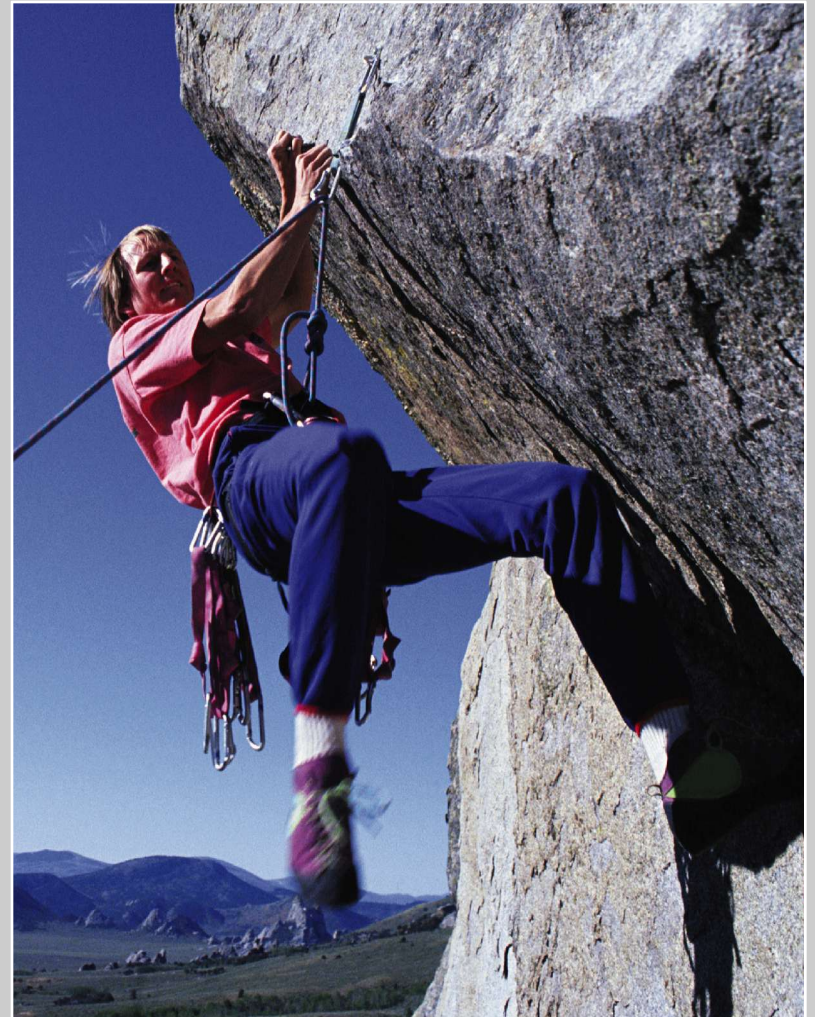
DSM Composite Resins

Leading the Composite Resins Industry by

focusing

on Customer's

needs for Success



DSM Composite Resins

- European market leader in unsaturated polyester resins
- Global leader in sizings and binders
- Euroresins is part of DSM Composite Resins and a leading distributor group in Europe

Product lines

- Unsaturated Polyester Resins
 - Gel coat Products
 - Polymeric Plasticizers
 - Sizings & Binders
-
- Sales: > EUR 400 million
 - Employees: > 750 people



Our presence in the world

The image features a world map with a callout to Europe. A detailed map of Europe is centered, with blue circles indicating DSM locations. A red circle highlights a location in Central Europe. Surrounding the maps are photographs of various DSM facilities, each with a label and country code.

- Augusta (USA)
- Deeside (GB)
- Ellesmere Port (GB)
- Compiegne (F)
- Tarragona (ES)
- Zwolle (NL)
- Schoonebeek (NL)
- Ludwigschafen (D)
- Warsaw (P)
- Como (I)
- Filago (I)
- Schaffhausen (CH)
- Nanjing (CHN)

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Polyester resins chemistry

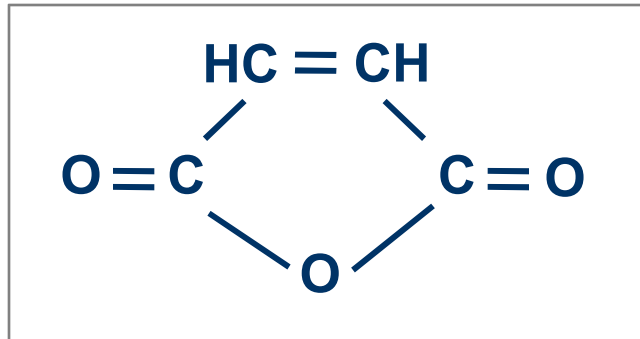
Polyesters are polymers resulting of the polycondensation (or poly esterification) at high temperature between multifunctional acids and alcohols.

Most of the times di-acids and di-ols (2 functionalities) are used :



Polyester resins chemistry

To obtain unsaturated polyesters, at least one of the components must contain a double bond (\diagup C = C \diagdown) able to react with a vinylic or acrylic monomer :

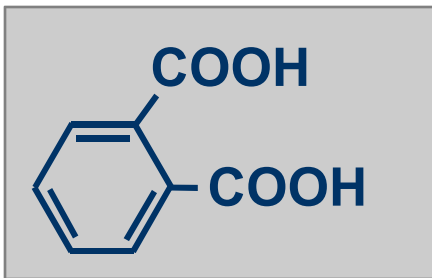


Maleic anhydride

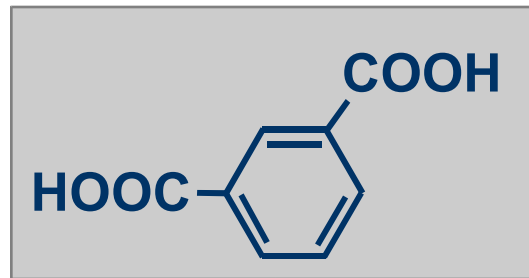
Polyester resins chemistry

Many different diacids and glycols types are used in the polyester polymer, providing a wide range of properties.

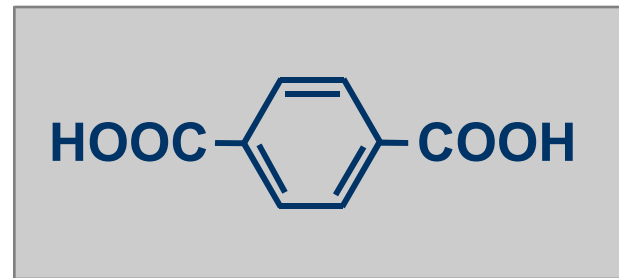
Main acids :



Orthophthalic
acid/anhydride



Isophthalic acid



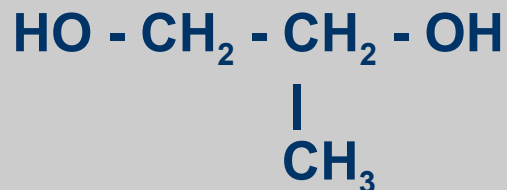
Terephthalic acid

Polyester resins chemistry

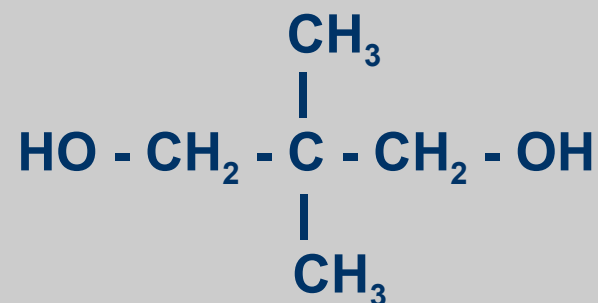
Main glycols



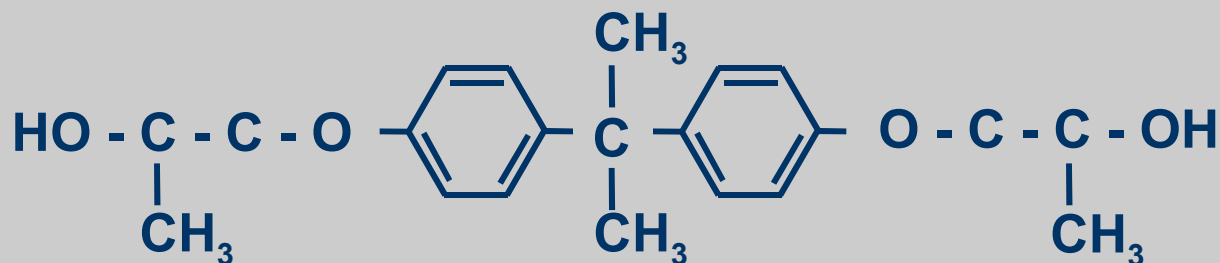
(Di-)Ethylene glycol



(Di-) Propylene glycol



Neopentyl glycol

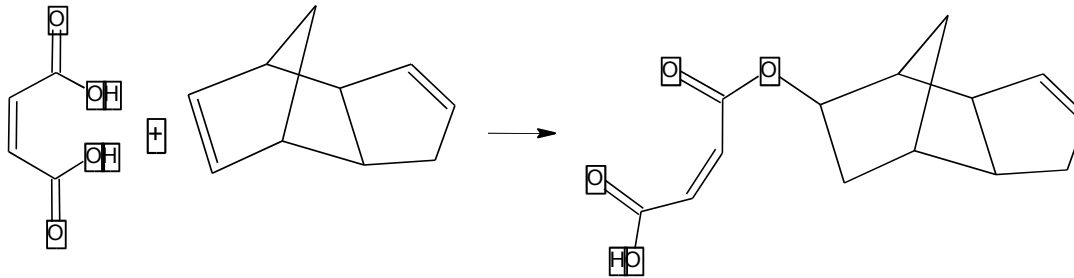


Propoxylated bisphenol A

Polyester resins chemistry

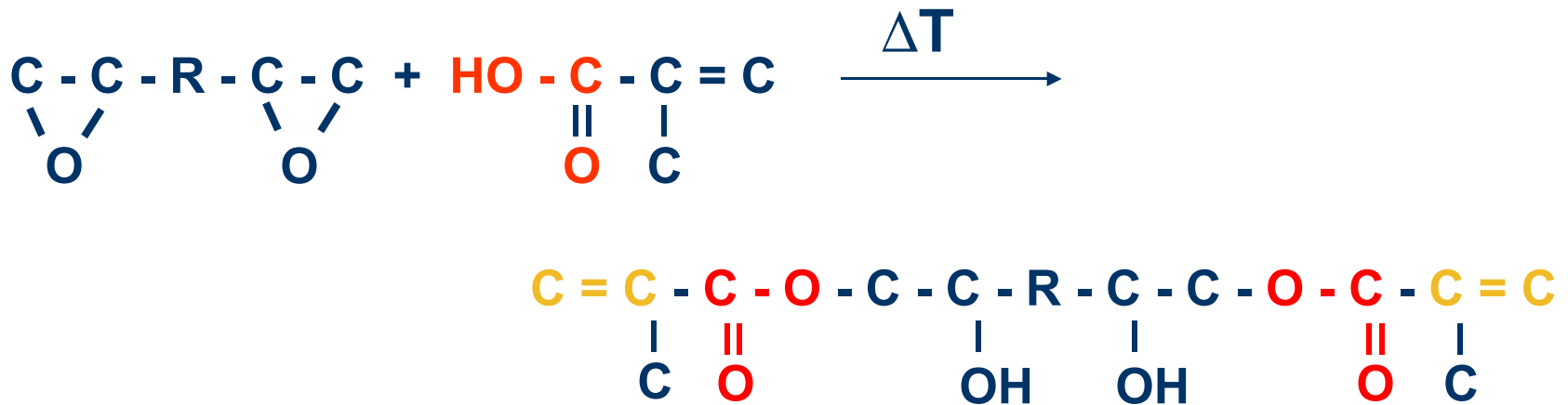
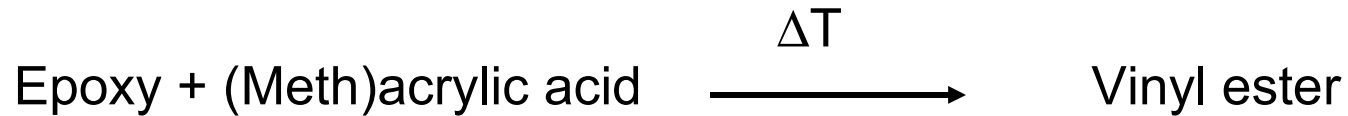
DCPD (dicyclopentadiene)

To comply with regulation concerning styrene emission we developed resins based on DCPD . Resins with less styrene



Polyester resins chemistry

Vinylester



Vinylester Urethane



Polyester resins chemistry

Unsaturated polyester resins

- Ortho-, iso- and terephthalic resins
- DCPD resins

Vinyl ester resins

- Epoxy-acid

Vinyl ester urethane resins

- Isocyanate-hydroxyl (meth)acrylate

End of introduction

Start of the marine related topics

Marine market – Production of GRP boats

DSM systems for every stage :

Mold making

Hull and Deck construction

Bonding and fixing

Marine application - Mold Making

Traditional mould making

- Double gel, tissue, low wt / tex first layer
- Structural - < 2 x 450 CSM / day.
- Exotherm must be minimised.
- Typical 6-10 days per mould.



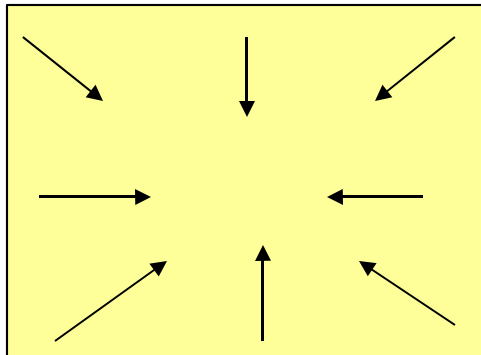
TIME
CONSUMING

WHY SUCH A SLOW PROCESS ?

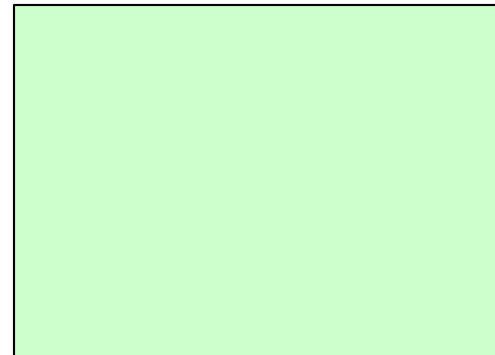
- PE'S shrink typically 8% volumetric, 1% laminate linear.
- High build = High exotherm = Rapid, uncontrolled shrinkage = Distortion of pattern and mould = Loss of original dimensional accuracy.
- Built-in stresses = Difficulty in mould release from pattern

Mold Making : How to improve

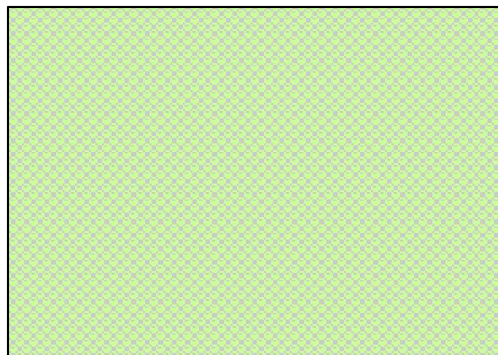
SHRINKAGE ELIMINATION BY LOW PROFILE TECHNOLOGY



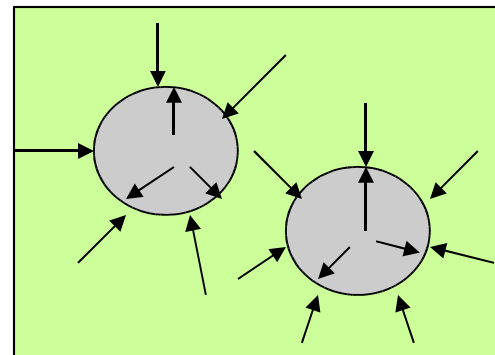
SHRINKAGE STD POLYESTER



LIQUID LP PE - ADDITIVE IS COMPATIBLE



GELLED LP PE - ADDITIVE PHASES OUT



EXOTHERM EXPANDS THERMOPLASTIC DROPLETS, SHRINKAGE OF PE IS COUNTERACTED

Mold Making : the solution

- Exotherm is important - More is better.
- Special catalyst needed - Counteracts residual Benzaldehyde (cure / odour).
- Effective phase out of LP additive is evident from colour change.

HOW

Euroresins RAPID TOOLING SYSTEM
A LOW SHRINK MOULD LAY UP SYSTEM

RTS – STAGES OF PROCESS

- Double Gelcoat (ISO / VE)
- (Surface tissue)
- 1 Layer low tex light weight MAT / ERTS Resin
- 5 X 300 GM layers / ERTS Resin (4mm)
- Allow exotherm to subside (2 hrs)
- 4 X 450 GM layers (5mm)

Mold making – High standard molds

RTS FOR HIGHER DEMAND MOULDS

- Double gelcoat (VE)
- 1 layer low tex light weight MAT / VE TOOLING RESIN (ATLAC 580 ACT). Cure overnight
- 4 X 450 GM layers / ERTS Resin (5 mm)
- Allow exotherm to subside (2 hrs)
- 4 X 450 GM layers (5mm)

Mold making steps



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Mold Making : Technical advantages of the RTS

- ✓ TOTAL MOLD MAKING TIME REDUCED TO 1-2 DAYS
- ✓ EASY RELEASE FROM PATTERN
- ✓ EXCELLENT DIMENSIONAL REPRODUCTION
- ✓ FULLY PRE FORMULATED - **JUST ADD CATALYST** (MAJOR ADVANTAGE OVER COMPETITIVE SYSTEM SYSTEM)
- ✓ MIX IS STORAGE STABLE
- ✓ MINIMAL SLIP / DRAIN FROM VERTICAL SURFACES
- ✓ HIGH HDT
- ✓ CAN BE USED FOR **HLU / SU AND RTM MOULDS**
- ✓ OFFERS EXCELLENT SYSTEM POTENTIAL WITH 8397-W-0100 VE TOOLING GEL