**DESCRIPTION**

Orca Solutions S-924 is a solution of methyl ethyl ketone peroxides and cumyl hydroperoxide in phlegmatizer. Orca S-924 is a liquid polymerization initiator for the room temperature cure of specialized unsaturated polyester and vinyl ester resins with the following advantages/properties:

- Low Peak exotherm
- Longer working time (gel time)
- Excellent final cure
- Eliminates in-plant mixing of peroxides
- Low impurity levels (water, hydrogen peroxide, MEK)

**APPLICATION**

Orca Solutions S-924 is an excellent liquid polymerization initiator for the room temperature cure of unsaturated polyester and vinyl ester resins, when a low peak exotherm is desired. Gel times will be slower compared to standard MEKP products, but final cured resin hardness is often better than for resins initiated with standard MEKP’s.

**TYPICAL PROPERTIES**

<table>
<thead>
<tr>
<th>Active Oxygen</th>
<th>Form</th>
<th>Liquid</th>
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<tbody>
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<td>9.0 %, max.</td>
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<tr>
<th>Specific Gravity @ 25°/4°C</th>
<th>Red</th>
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<tbody>
<tr>
<td>1.0</td>
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| Fire point | 150°F/66°C, min. |
| Flash point (SETA C.C.) | 170°F, min. |

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<th>Soluble in</th>
<th>Oxygenated organic solvents</th>
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<table>
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<tr>
<th>Slightly soluble in</th>
<th>Water</th>
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**STORAGE**

- Storage at 80°F or below is recommended. Storage below 70°F is recommended for maximum shelf life.
- Store in original containers away from flammables and all sources of heat, sparks, or open flames; out away from explosives, other promoters, accelerators, oxidizing or reducing agents and strong acids or bases.
- Leaking containers – Remove and isolate in a safe area. Re-package or dispose immediately (see spills).
- Never store in refrigerators containing food and/or beverages.
- Consult National Fire Protection Association (NFPA) Code 432 and/or local regulatory agencies.
- Rotate stock, use oldest date first.

**HANDLING**

- Inform all personnel of procedures for safe handling and review MSDS with them.
- Remove from storage area only the amount needed for one shift.
- Wear safety glasses or goggles and chemical resistant gloves.
- Keep away from heat, flames, and sparks.
- Avoid breathing vapors.
- Dilution is not recommended.
- Never add peroxides directly to promoters or vice-versa, violent decomposition can occur.
- Prevent contamination such as contact with dust, over spray, wood, and combustible material.
- Avoid contact with materials other than polyethylene, polypropylene, Teflon®, Tygon®, or similar materials, glass or glass-lined steel, and 304 or 316 stainless steel or equivalent.

**FIRST AID**

- EYES – Flush immediately with large amounts of fresh water and continue washing for at least 15 minutes. Medical attention is needed.
- SKIN – Wash with soap and water.
- INGESTION – Administer large amounts of milk or water and call a physician immediately. Do not induce vomiting. As an aid to the physician, suggest calling your local Poison Control Center.

**SPILLS**

- Clean up immediately by absorbing with inert material – vermiculite or sand.
- After absorbing, moderately wet immediately with water and place in a clean plastic bag inside a plastic pail.
- Dispose of immediately in accordance with local, state, and federal regulations.

**FIRE**

- Peroxides ignite readily and burn vigorously with acceleration.
- Use water from a safe distance – preferably with a water-fog nozzle.
- For very small fires, an extinguisher with carbon dioxide, foam, or dry chemical may be effective.
- In case of fire in or near a storage area, cool stored containers with water spray.

**PACKAGING, SHIPPING & AVAILABILITY**

- The standard package sizes of Orca S-924 MEKP are cases of 4x8 lb. and 4x4 kg polyethylene bottles; and 40 lb. or 20 kg Hedpacks. For custom package sizes, please contact your local distributor or Orca Composites.
- Classification – Please refer to the specific Orca S-924 MEKP Material Safety Data Sheet under section 14, Shipping Description.
- Orca S-924 MEKP is available through a nation-wide distributor network. Call Orca Composites, for the name of the distributor in your area.

**SAFETY**

See appropriate Material Safety Data Sheet for guidelines.