

SERVICE LETTER 1

APPLICATION: All customers who receive or are shipped vinyl ester 411-45 resin after the date of this publication.

SUBJECT: VINYL ESTER RESIN CHANGE

The vinyl ester resin supplied with this shipment is 411-45. This formulation is the same as supplied in years past with earlier G-I, G-II, and G-III aircraft kits. Stoddard Hamilton Aircraft has continually improved the Glasair kits by incorporating improvements as they become available. We first changed to a specially blended 470-2000 resin with a higher heat distortion temperature of 300° F. While working well in our manufacturing environment, it did not lend itself well to your workplace. The shelf life was very limited and its workability less than desired. However, we still use it as the primary resin throughout the manufacturing of the kits at the factory because of our more frequent usage and shorter shelf life requirement.

What we then supplied to our builders was the 441-400 resin with a heat distortion temperature of 240°-250° F. However, builders have reported sufficient difficulty with short gel times, and long cure times, that we felt any slight improvement the new formulation offered, did not justify the builder inconvenience. We have had many years of excellent service from the 411-45 resin and feel our customers will be best served by returning to it.

The Instruction Manual charts listing promotion ratios and gel times will not change for the 411-45 resin. The 411-45 resin has a heat distortion temperature 210°-220° F, still well above any temperatures that may be encountered during service. From past experience the shelf life of the unpromoted 411-45 resin should be 6 months or longer, the best of any of the resins we have supplied in the past.

Stoddard Hamilton has also instituted a new system to closely monitor the manufactured date of the resins we receive from our suppliers. This will allow us to ship resin with the maximum remaining shelf life.



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