

Description **SprayCore® 4700** is a High Performance shrink controlled filled Tooling Resin; it is formulated to reproduce exact shapes of master and meets the stringent Requirements of the Marine, Transportation, and Tub & Sower markets. **SprayCore® 4700** low shrink filled Tooling Resin is formulated with a unique Low HAP chemistry, is MACT Compliant and meets all current Federal regulations regarding emissions.

Product Features

- ✓ MACT compliant
- ✓ Shrink controlled
- ✓ Great resin transfer
- ✓ Rapid Barcol development
- ✓ Color change upon curing

Product Benefits

- ✓ Reproduce exact master dimension
- ✓ Minimize prerelease
- ✓ Reduce post finishing time
- ✓ Reduce labor cost 50%
- ✓ Shorten production cycle time 80%
- ✓ Faster demolding

Material Specification

Appearance	Packaging	Application Method	Approximate Coverage
Beige / Cream	Drum	Sprayable	1550 ft ² /gal/mil
Thix Index Range	Mix ratio	Preferred red dyed Catalyst	Gel Time Range
3.5-5.5 (LVT #3@ 3/30 rpm)	1.5% (volume)	MEKP-900, MEKP-925, MEKP 925H	13-30 minutes
Gel to Peak Range	Peak Exotherm (100 Gram Mass)	Application Density Range	Viscosity Range
5-12 minutes	280-330 °F	12.3-12.8 lb./gal	3,000-4,500 cps (LVT #3 @ 30 rpm)

Typical Mechanical Properties 0.45" laminate with VE 1st layer

Test type	ASTM #	Value	Test Type	ASTM #	Value
Flexural Strength (psi)	D-790	19,040	HDT (°C)	D-648	>300
Flexural Modulus (psi)	D-790	1,039,000	CTE (µm/m°C)	D-696	26.7
Tensile Strength (psi)	D-638	13,500	Impact (ft-lb.)	D-5420	28
Tensile Modulus (psi)	D-638	1,240,000	Panel Thickness (inches)		0.45
Elongation at Break (%)	D-638	1.6	Shrink (%)	D-2566	0.00

TECHNICAL DATA SHEET

SC 4700

EFFECT OF TEMPERATURE: Application of SC 4700 at temperatures between 65°F (18°C) and 95°F (35°C) will ensure proper cure, ideally above 75°F. Temperatures below 65°F (18°C) or above 95°F (35°C) will slow down or increase cure rate significantly. To ensure consistent dispensing between equipment, resin and catalyst, temperatures should be held reasonably constant throughout the year. Resin in cured state behaves differently at elevated and low temperatures. See ITW PANA for specific values.

STORAGE AND SHELF LIFE: Shelf life is based on continuous storage between 54°F (12°C) and 95°F (35°C). Prolonged exposure above 95°F (35°C) quickly diminishes the reactivity of the product and should be avoided.

PRODUCT USE: Many factors beyond ITW PANA control and uniquely within user's knowledge and control can affect the use and performance of an ITW PANA product in a particular application. Given the variety of factors that can affect the use and performance of an ITW PANA product, the end user is solely responsible for evaluating any ITW PANA product and determining whether it is fit for a particular purpose and suitable for user's design, production, and final application.

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Notes

1. ITW PANA strongly recommends that all substrates be tested with the selected laminate in the anticipated service conditions to determine suitability.
2. SprayCore® 4700 first draft

NOTE: The technical information, recommendations, and other statements contained in this document are based upon tests or experience that ITW PANA believes are reliable, but the accuracy or completeness of such information is not guaranteed. The information provided is not intended to substitute for the customers own testing.

SprayCore®

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