

# SC4600 HTT Premium Tooling Resin

**Description:** SC 4600 HTT Premium Tooling Resin is a promoted, vinylester blended premium mold building resin developed for the fabrication of FRP tooling in multiple pull and high temperature applications. MEKP Catalyst is not included.

**Item Number** 103847 4600 HTT drum unlined

## FEATURES & BENEFITS

- Excellent for High Temperature applications
- Offer a significant labor cost reduction
- Created for low shrinkage
- Minimizes pre-releases
- Improves laminate profile by eliminating print through and surface distortion
- Reduced cracking
- Helps increase balanced mold strength by up to 20%
- Reduces tooling costs by up to 25% when replacing balsa cores

## TYPICAL MATERIAL PROPERTIES

Appearance	Packaging	Application Method	Approximate Coverage
Light Tan	Drum	Sprayable	1550 sq ft/gal/mil
Mix Ratio	Preferred red dyed Catalyst	Gel Time, min.	Gel to Peak Range, min.
1.50 % MEKP	DHD-9, L50 MEKP-925, K10	12 - 20	20 - 30
Styrene	Peak Exo. Temp. (100 gm) °F / °C	Density Range, lb/gal	Viscosity Range, cP
20- 24%	210-255F / 99-124C	10.4 – 11.1	7,000 – 11,000 (RFV#5@2.5/20 rpm) Thix Index: 5.5 - 7.5

All properties are measured at 77°F / 25°C

Product features and benefits are calculated based on a 100 sqft sample compared to an all-glass laminate.

**SprayCore**<sup>®</sup>

ITW Performance Polymers  
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## EFFECT OF TEMPERATURE:

Application 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 Performance Polymers for specific values.

## STORAGE AND SHELF LIFE:

Expected Shelf life of 3 months, where 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 ITWPP's control and uniquely within user's knowledge and control can affect the use and performance of an ITWPP product in an application. Given the variety of factors that can affect the use and performance of our products, the user is solely responsible for evaluating the ITWPP product and determining whether it is fit for a particular purpose and suitable for the user's method of application. ITWPP recommends the User review all Safety Data Sheets, Technical Data Sheets and ITWPP's warranty and limited liabilities prior to use. These can be found at [www.itwpp.com](http://www.itwpp.com)

## Notes

1. ITW PP strongly recommends that all substrates be tested with the selected laminate in the anticipated service conditions to determine suitability.
2. Industrial Use Only

## DISCLAIMERS:

**TECHNICAL INFORMATION:** The technical information in, recommendations and other statements contained in this document are based upon good faith tests or experience that ITWPP 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.

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