

MAKOBOND SURFACE COAT 504

PRODUCT DESCRIPTION

Makobond SC 504 is thixotropic surface coat system designed for tough applications. The mixed system is a smooth, creamy mix making it easy to mix and apply to difficult areas. SC 504 is tough and will stand up to difficult environments for a long time. The SC 504 is available in either black or white.

PRODUCT HIGHLIGHTS

- ROOM TEMPERATURE CURE
- EASY MIXING
- TOUGH
- LONG LASTING PARTS

PRODUCT CHARACTERISTICS

| | SC 504A | SC 504B |
|------------------|----------------|------------|
| Viscosity @ 25°C | 40,000 cps. | 12,300 cps |
| Specific Gravity | 1.40 | 1.09 |
| Color | White or Black | Amber |

PHYSICAL PROPERTIES

| | Results | ASTM Method |
|--|--------------|-------------|
| Cured Hardness (Shore D) | 85-88D | D2240 |
| Flexural Strength (psi) | 4,458 psi. | D790 |
| Flexural Modulus (psi) | 845,107 psi. | D790 |
| Compressive Strength (psi) | 15,866 psi. | D695 |
| Tensile Strength (psi) | 6,909 psi. | D638 |
| Tensile Modulus (psi) | 770,214 psi. | D638 |
| Glass Transition Temperature, T _g (DMA) | 210°F | D4065 |

HANDLING PROPERTIES

| Surface Coat 504 | |
|--------------------------------------|---------------|
| Mix Ratio By Weight, Resin, Hardener | 100:15 |
| Mix Ratio By Volume, Resin, Hardener | 5.2:1 |
| Mixed Viscosity @ 25°C | 25,400 cps. |
| Pot Life @ 25°C | 18-25 minutes |

HANDLING AND CURING

Measure out the proper weights of SC 504 and mix until uniform and no streaks are present throughout. Be sure to scrape the sides and bottom on mixing container to avoid any unmixed material. SC 504 will cure at room temperature. Leave overnight to be sure material is tack free and cured. No post cure is required to reach full properties.

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PACKAGING WEIGHTS

| | Quart Kit | Gallon Kit | Pail Kit |
|------------|-----------|------------|----------|
| SC-504A | 2.5 lbs | 10 lbs | 55 lbs |
| SC-504B | 0.38 lbs | 1.5 lbs | 8.3 lbs |
| SC-504 Kit | 2.88 lbs | 11.5 lbs | 63.3 lbs |

STORAGE AND SAFETY

Makobond SC 504 has a shelf life of 12 months from date of shipment when unopened and stored at ambient temperatures, (18-27°C). Nitrogen purging opened containers is recommended before re-sealing. SC 504B may darken over time, but this will have no effect on any finished product. Users need to exercise proper care while working with material; gloves, eyewear, and proper ventilation are recommended. Warning: All thermosetting matrix systems undergo exothermic reaction during vulcanization and/or curing, generating heat. If not properly managed, exothermic reactions may release possibly flammable or toxic gases into the surrounding. Users should exercise extreme caution when blending large volumes of ingredients (ie greater than 1 lb), and/or curing thick sections of components (typically greater than 0.200 inches). Users should monitor heat profiles of any curing or blended materials carefully and attentively during cure. Please contact a Mako team member with any concerns prior to use and/or to coordinate the proper management of safety and temperature monitoring process to avoid exothermic phenomena.