

MAKOBOND SURFACE COAT 565

PRODUCT DESCRIPTION

Makobond SC 565 is a very tough, high temperature black surface coat. The SC 565 is durable and resistant to scratches and cuttings. This is due to the very hard surface that is formed once the system is cured. SC 565 creates a hard surface with excellent heat resistance for long lasting parts.

PRODUCT HIGHLIGHTS

- HIGH TEMPERATURE
- TOUGH SURFACE
- ABRASION RESISTANT
- EASY MIX

PRODUCT CHARACTERISTICS

	SC 565A	SC 565B
Viscosity @ 25°C	Paste	1,500 cps.
Specific Gravity	1.51	1.09
Color	Black	Amber

HANDLING PROPERTIES

Surface Coat 565	
Mix Ratio By Weight, Resin, Hardener	100:10
Mix Ratio By Volume, Resin, Hardener	7.2:1
Mixed Viscosity @ 25°C	145,000 cps.
Pot Life @ 25°C	40-50 minutes

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	90-92D	D2240
Coefficient of Thermal Expansion	2.15×10^{-5} in/in/°F	D696
Glass Transition Temperature, Tg, (DMA)	300°F	D4065

HANDLING AND CURING

Measure out the proper weights of SC 565 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 565 will cure at room temperature but does need a post cure. Follow the post cure schedule of the laminate resin being used.

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PACKAGING WEIGHTS

	Quart Kit	Gallon Kit	Pail Kit
SC-565A	2.5 lbs	11 lbs	55 lbs
SC-565B	0.25 lbs	1.1 lbs	5.5 lbs
SC-565 Kit	2.75 lbs	12.1 lbs	60.5 lbs

STORAGE AND SAFETY

Makobond SC 565 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 565B 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.