

MAKOBOND SURFACE COAT 576

PRODUCT DESCRIPTION

Makobond SC 576 is a high temperature black surface coat designed for composite parts and tooling. The SC 576 has minimal thermal expansion and with its thixotropic nature, makes it easy to apply to difficult areas. SC 576 has a resistance to chipping and cracking. SC 576 is similar to our SC 575 system; however, the SC 576 provides a longer pot life as well as a higher glass transition temperature.

PRODUCT HIGHLIGHTS

- HIGH TEMP
- LOW CTE
- GRAPHITE FILLED
- EXTENDED POT LIFE

PRODUCT CHARACTERISTICS

	SC 576A	SC 576B
Viscosity @ 25°C	Paste	1,100 cps.
Specific Gravity	1.51	1.01
Color	Black	Amber

HANDLING PROPERTIES

Surface Coat 576	
Mix Ratio By Weight, Resin, Hardener	100:13
Mix Ratio By Volume, Resin, Hardener	5.1:1
Mixed Viscosity @ 25°C	39,300 cps.
Pot Life @ 25°C	140-160 minutes

PHYSICAL PROPERTIES

	Results	ASTM Method
Cured Hardness (Shore D)	88-92D	D2240
Flexural Strength (psi)	11,894 psi	D790
Flexural Modulus (psi)	643,196 psi	D790
Compressive Strength (psi)	20,180 psi	D695
Tensile Strength (psi)	7,597 psi	D638
Tensile Modulus (psi)	658,639 psi	D638
Glass Transition Temperature, T _g , (DMA)	317°F	D4065

HANDLING AND CURING

Measure out the proper weights of SC 576 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 576 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-576A	2.5 lbs	11 lbs	55 lbs
SC-576B	0.325 lbs	1.4 lbs	7.2 lbs
SC-576 Kit	2.825 lbs	12.4 lbs	62.2 lbs

STORAGE AND SAFETY

Makobond SC 576 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 576B 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.