Product Data Sheet

SPRAYOMER® Elastomer HT10 (Beta)

SPRAYOMER® Technology
Patented Industry Changing Solutions

Resin Infusion – Prepreg – Debulks – Bond Fixtures – Bladders – Blankets – Masks

Product Description

SPRAYOMER® elastomer HT10 is a partially pre-vulcanized liquid co-polymer that can be sprayed onto a surface and air dried into a durable film that provides a flexible diffusion barrier suitable for reusable vacuum membranes (see post cure requirements).

Excellent thermal stability and good chemical resistance make HT10 ideal for cure cycles of epoxy resin systems under typical autoclave conditions and also out of autoclave oven curies. Good puncture and tear resistance provide for repeated process cycles.
HT10 *does not contain any silicone rubber.*

Membrane Characteristics

Spray formable membranes enable prompt fabrication of net shape, seamless vacuum bags on nearly any surface regardless of size or geometric complexity.
SPRAYOMER® vacuum bags do not require any mesh reinforcement and therefore, can weigh up to 80% less than comparable articles made from Silicone, EPDM or Urethane.

Packaging & Handling

Shipped in a 5 gallon pails. Special order 50 gallon drums are available. Winter shipping requires freeze protection.
Store indoors in sealed container at 50°f- 90°f.
Use the insulated shipping box when transporting pails.
Shelf life up to18 months in controlled storage (nom. 75°f).

Cleanup & Disposal

Use only *Distilled* Water to clean tools & spray equipment. Pour effluent into a shallow pan and use cardboard or other absorbent material to dry it into a non hazardous solid state. Always follow local disposal regulations for handling solid waste. Dried elastomer can be removed from most non-porous surfaces by peeling.

Material Application

Surface Preparation
A semi permanent mold release is recommended to aid initial demold of cured membrane from working surface. Smooth non porous surfaces provide the best foundation for spray fabrication of a vacuum membrane.

Material Preparation
If practical, keep material between 70°f - 80°f. Use a clean stir mixing stick to stir material before use.
Pail lids are provided with small bung hole opening to accept the QuickMold™ Sprayer pickup tube and suction filter.

Spraying Conditions
Sprayomers are preferably applied in a vented, dust free room maintained at a temperature between 70°f - 85°f.
Avoid runs on vertical surfaces by applying less than 8 - 10 total wet mils between each drying stage.

Drying Stages
Dry the wet film effectively by using forced heated air flow, preferably between 125° - 140°f for approx.10-15 minutes after each spray pass. A humid environment and ambient temperatures below 75°f will increase drying time.

Post Cure
Post cure SPRAYOMER® HT10 membrane in heated air at 180°f – 200°f for 2 hour to achieve initial cure, followed by an additional elevated cure cycle for 2.5 hours at 300°f to final crosslink cure membrane. Followed with recommended bag treatment application.

Precautions
Please refer to SDS for proper safe handling and storage information. Wear personal protective equipment including protective eyewear and gloves. Follow OSHA guidelines for personal protective equipment and operating procedures for specific type of spray equipment being used. Always ground dried/cured membranes to dissipate static charge build up between the membrane and working surface.

In Liquid State	HT10
Appearance	Gray
Freezing Point	32°F
Boiling Point	212°F
Specific Gravity	1.28
Solubility in Water	Miscible

As a Cured Film	HT10
Color	Grey
Elongation	450%
Specific Gravity	1.28
Short Duty Cycles	350°F
Sustained Exposure	300°F

SPRAYOMER® Technology **www.srcomposites.com**
http://www.srcomposites.com/PATENTS.htm
U.S. Pat, # 8,916,073, U.S. Pat # 8,672,665, U.S. Pat # 10,434,690
Australian Patent # AU2008218935, Canadian Patent # 2,679,111,
Other U.S. & International Patents Pending