

Product Data Sheet

SPRAYOMER® Elastomer HT15



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

Product Description

SPRAYOMER® elastomers are pre-vulcanized single component liquids 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.

HT15 combines excellent puncture and tear resistance with the chemical and thermal stability required by repeated exposure to 250°F cycle temperature, oven or in and out of autoclave pressures with PE, VE & Epoxy resin systems.

HT15 does not contain any silicone/synthetic 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° - 90°F. Shelf life up to 18 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

Surfaces should be clean and free of oils, waxes and releases. 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 cup filter.

Spraying Conditions

SPRAYOMERS are preferably applied in a vented, dust free room maintained at a temperature between 70° - 85°F. Avoid runs on vertical surfaces by applying less than 7 - 8 total wet mils between each drying stage. Ideal horizontal surface build is less than 12 wet mils between drying stages.

Drying Stages

Dry the wet film using forced air flow, preferably heated to 120° - 145°F for approx. 15 after each spray pass, final film thickness build up dependant on total spray passes. A humid environment and ambient temperatures below 75°F will increase drying time.

Post Cure

It is recommended to expose the SPRAYOMER® membrane contact surface to heated air at 180°F for 4 hours to achieve optimal cure followed by recommended bag treatment application. Demold of membrane should be no less than 24 hours from completion of spraying.

Precautions

Please refer to MSDS & 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

HT15

Appearance	Tan Cream
Freezing Point	32°F
Boiling Point	212°F
Specific Gravity	0.96
Solubility in Water	Miscible

As a Cured Film

HT15

Color	Amber
Elongation	650%
Specific Gravity	1.06
Short Duty Cycles	300°F
Sustained Exposure	260°F