



Innovative Tooling Materials for Thermoforming

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Repair Instructions for HYTAC-B1X small voids (Quick Cure)

This procedure is for quickly curing small void or cut areas in the *HYTAC- B1X* product. This should only be used on very small voids, (less than 5 mm diameter). This procedure requires that the plug and the syntactic mix be heated separately to temperatures of 90°C and 60°C respectively. The mix is then quickly worked into the void, wiped with alcohol and cured. This process is repeated until the void is filled.

Included are 100-gram containers of *HYTAC-B1X Patch* and enough room temperature catalyst to be mixed with the container of *HYTAC Patch* to speed the cure of the repaired area for you, and tongue depressors to aid in mixing and filling the repair area.

Also enclosed are the MSDS for the *HYTAC-B1X Patch* syntactic foam and the catalyst.

Procedure:

Clean the area to be prepared with alcohol making sure all grit, dirt or cutting fluids are removed. Perform a light sand as necessary, and wipe with alcohol. Allow the plug to dry.

Place the plug in an oven at 90°C and allow the plug to come to temperature. (Roughly 1 hour)

Place the mix in an oven at 60°C. Allow the mix to come to temperature at minimum. (About 20 minutes)

When both the plug and mix are at temperature, cut open the catalyst eyedropper and mix the entire contents into the container of repair mix. Mix thoroughly for 2 minutes scrapping the sides of the container.

Apply to the area to be repaired, working the syntactic mix into the void. Once the void is satisfactorily filled, lightly wipe the area with a cloth wet with alcohol to bring the level of the syntactic in the void to the level of the plug. Place the plug back in the oven at 90°C and allow the mix to cure. Place the mix back in the oven at 60°C.

Repeat the above step as many times as necessary to fill the void. We expect you to have about 60 minutes of working time with the mix before the viscosity begins to build.

You can then cure the patch in an oven overnight at 90°C to finalize the cure. Lightly sand the surface to get to the desired final surface.

If you have any questions, please call.

Repair Instructions for HYTAC-B1X small voids (Overnight Cure)

This procedure is for repairing voids, cracks or cut areas in the *HYTAC-B1X* product. Included are 1/2 liter, (250 grams of mix), or 1 liter, (500 grams of mix), containers of *HYTAC-B1X Patch* and enough room temperature catalyst to be mixed with the container. Also included are tongue depressors to aid in mixing and filling of the repair area.

Also enclosed are the MSDS for the *HYTAC-B1X Patch* syntactic foam and the catalyst. Read these repair instructions and MSDS carefully prior to beginning work with the material.

Procedure:

Allow the mix to come to room temperature at minimum. It would be preferable to warm the mix up to 40°C-50°C if possible. This will allow the mix to flow better and the reaction to occur quicker. Note the viscosity of the mix. This is the viscosity that you will have during application. The mix must be applied to a fairly flat surface or it will run off during cure.

Thoroughly clean the area to be repaired. Remove any loose debris, oils, dirt or contaminants. Sand oxidized surfaces, (yellowed), back to the original light blue color. Wipe the entire surface with solvent. Fixture the area to retain the mix if necessary. Place the plug in an oven and heat to 70°C.

Cut open the catalyst eyedropper and mix the entire contents into the container of repair mix. Mix thoroughly for 2 minutes scraping the sides of the container. The entire mixture needs to be used at one time.

Apply to the area to be repaired. We expect you to have about 60 minutes of working time before the viscosity begins to build.

Once the repair area is filled and smoothed with the spreader, you may cure repair overnight at 70°C to solidify the syntactic. Heat the area with a heat gun to accelerate the cure if desired. Be sure to keep heat gun far enough away to prevent discoloration. It is suggested that you try a scrap piece first to get a feel for the closeness and amount of time. It is preferable to assure a complete cure by heating in the oven overnight. If you use the oven, position the repair such that the patch will not run out of the repaired area as the temperature increases before cure.

If you have any questions, please call.