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DATA SHEET

HK925 TABLETOPS

HK925 Tabletops are manufactured of cast urethane. The work tabletops are self-sealing which provide a smooth working surface for the longest possible life.

SPECIFICATIONS

Durometer	90
Modulus, psi @ 50	800
Tensile Strength, psi	6,000+
Sizes:	
Width	12’ maximum
Length	50’ maximum
Thickness	9” maximum

ASTM tests used throughout as follows:

Tensile Modulus	ASTM D-412
Tear Strength	
Die “C”	ASTM D-624
Split	ASTM D-1938
Compression Modulus	ASTM D-575
Compression Set	ASTM 395-B

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DATA SHEET

SONTECTOR 112

Ultrasonic Leak Detector

Ultrasonic sounds in the range of 35,000 to 45,000 cps are detected by these instruments and converted to corresponding audible sound. This conversion retains the sound character so that little or no training is required prior to use. For example, the ultrasonic sound of a gaseous leak, when converted, has the same hissing characteristic with which we are all familiar.

Solid-state circuitry is used in all models for long battery life and high reliability under field conditions. The units use a standard 9 volt transistor radio battery obtainable at most drug stores. Maintenance consists of periodic battery replacement and requires no special batteries or other parts.

Leak Detection can readily be accomplished on both vacuum and pressure vessels. The hand probe or Sontector 112 is highly directional and is pointed at the area under test ad waved back and forth to locate the source of the leak sound by the sharp peak in audible intensity as the probe points directly at the leak source. Closer approach to the leak increases sound intensity so that a leak may be precisely located. In cases where several leaks or other ultrasonic noise sources interfere with this process, the sound concentrator may be slipped over the nose of the probe and the suspect area closely examined with its tip.

The Sontector 112 is our most versatile instrument. It incorporates a loudspeaker and meter read-out and may be used with the accessory contact probe to evaluate the condition of machinery and internal operations.

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DATA SHEET

K11 CUTTING MACHINE

The High Speed, Portable Precision
Cutting Machine for all Types of Sheet Materials

- **Standard Equipment**
  Each model K-11 machine comes complete with:
- MOTOR 115 Volt, 1/5 HP
  50-60 Hz. AC only
- BLADES – 2 each of nos: 6, 8, 11, 21U, 23D & 24
- 5/64" ALLEN KEY (14K3) for 8-32 guide tube
- 5/8" OPEN END WRENCH (14K5) for guide knob stud caps and stroke adjustment nut
- PULLEY PIN (15K23)
- SCREWS (2K3) 2 extra for chisel block
- SAFETY GUARD (15K17) covering the rear of the machine
- CUTAWL OIL – 1 container
- LUBRICANT – 1 tube
- INSTRUCTION MANUAL AND PARTS LIST C-62

Special Options:

230V Motor AC only, 50-60 Mz Current with radio frequency interferesynthetic fabrics, plus canvas, suppressor (15K18)

Shipping Weight & Dimensions:

K-11 in carton: 20lbs 14"x8"x11"

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DATA SHEET

FIRST STEP

FIRST STEP will take your shop to a cleaner, more efficient working environment. FIRST STEP adhesive coated contamination control products represent the most advanced technology for significantly reducing the level of traffic-borne contaminates.

FIRST STEP mats provide a 12% larger working surface, when compared to a typical beveled mat, and the use of First Step mats eliminate the undesirable contaminant build-up on the exposed edges of the typical beveled contamination control mat.

Take the FIRST STEP to a cleaner, more efficient working environment with the use of FIRST STEP adhesive coated contamination control products. FIRST STEP composites represent the most advanced technology for significantly reducing the level of traffic-borne contaminates.

FIRST STEP mats are designed the resist adhesive transfer and at the same time prevent premature sheet-to-sheet delamination (U.S. Patent 4559250). This safety feature significantly reduces the risk of a worker-related tripping accident.

All standard FIRST STEP products incorporated a bacteriacide, which provides long lasting protection against the growth of organisms including molds, mildew, fungi, and algae. This anti-microbial component does not leech out, and is nontoxic to the extent that it is approved for direct food contact by the F.D.A. (21 CFR 175.105).

FIRST STEP products are totally produced in-house on state-of-the-art coating and laminating equipment. These internal capabilities allow us to consistently provide top quality products, exceptional service, and competitive pricing.

FIRST STEP mats are commonly produced in a wide selection of colors and sizes. Typical sizes include 18" x 36", 18" x 46", 26" x 46", 36" x 46", and 46" x 69'- and are readily available in white, blue, and gray colors. Custom colors and sizes are available upon request. All standard mats are provided with numbered comer tabs, to eliminate the accidental removal of more than one layer at a time.

The FIRST STEP conductive mat, with a surface resistivity of 3 (10') to 1.2 (107) ohms, is preferred in work areas where static control is essential. The 30,000 volts of static electricity discharged from the sheet removal of a typical mat are reduced to less than 300 volts with the use of FIRST STEP "Stat-Mat *".*

FIRST STEP Cuff Sealers provide an effective means of sealing gloves and shoe covers to the garment for your dean room operations. The standard FIRST STEP Cuff Sealer is a 30 layer pad, 3-1/2" x 13", with an adhesive coated backing to affix to a stationary position. For ease of application, numbered tabs are provided on opposite ends of every sheet.

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DATA SHEET

HK103 FILLER PASTE

HK103 is a high temperature polyester quick setting filler paste. HK103 will withstand temperatures to 450ºF (232ºC). HK103 is a two-part system which can be used to repair composite tools, vacuum molds, radome porosity, drill potting, edge fill on honeycomb and gel-coat repairs.

MIXING

Mix Ratio

100 parts paste/1 part hardener	approx 7-15 minutes pot time
100 parts paste/2 parts hardener	approx 5 minutes pot time

Mixed Consistency — Smooth Creamy paste

PHYSICAL PROPERTIES

Ultimate Tensile Strength (ASTM D-638.91)	4074 psi
Tensile Elongation (ASTM D-638.91)	1.163%
Ultimate Flexural Strength (ASTM D-790.92)	7080 psi
Ultimate Compressive Strength (ASTM D-695.91)	8992 psi
Shrinkage (Cast Bar) (ASTM D2566.86)	0.00962 in/in
Coefficient of Thermal Expansion (ASTM D-696-91)	25.4 X 10(8) in/inºF
Heat Deflection Temperature (ASTM D-648.82)	152.4ºF
Moisture Absorption (ASTM D-570.81)	0.149%
Cured Hardness	80 Shore D
Shelf Life (stored at ambient temperature)	6 months

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DATA SHEET

APF7 FILLER PASTE

APF7 FILLER PASTE is a quick setting industrial filler paste used for manufacturing, fabrication and repair in aircraft, aerospace, and other industries having requirements for above normal temperature exposure. Applications of APF7 are both fast and permanent. It can be used at temperatures up to 400ºF (204 ºC). APF7 is both chemical and water resistant, and maybe used in applications which are below the water line.

Excellent machining and finishing results are accomplished by grinding, sanding, scraping, etc. When exposed to elevated temperatures, APF7 has a tendency to darken, but does not gas, bubble, or cause any finish distortion. This product does not contain was and readily bonds to itself and other substrates such as FRP/SMC, high temperature epoxy molds, aluminum, steel, cast iron, urethane foam parts, and others. APF7 is non-metallic, non-condu7ctive, and non-sparking. It contains no styrene and has low odor.

TYPICAL APPLICATIONS

High Temperature Repairs:	Void filler
RIM Repair:	RTM repair
Potting bushings	LPMC cosmetic repair

BENEFITS

High Temperature Resistance	Exceptional adhesion
Low Odor	Excellent finishing and machinability
Quick Setting	Styrene free
Chemical and water resistance	

HANDLING CHARACTERISTICS

	Test Method	Value
Colors: Resin		Light Gray, Black, White
Hardener (Benzoyl Peroxide)		White, Black, Red
Mix Ratio, Resin to Hardener – Parts by Wt or Vol		100 to 2
Hardener		BPO
Mixed Viscosity or Consistency	ASTM D2393	Thixotropic Paste
Pot Life, 100 grams at 77ºF (25ºC) (minutes)	ASTM D2471	4-7
Cure Time at 77ºF (25ºC) (minutes)		15-20
Specific Gravity	ASTM D792	1.70

PHYSICAL PROPERTIES

	Test Method	Value
Volmetric Weight		D.061
Shore Hardness (D)	ASTM D2240	88-90
Tensile Strength (psi)	ASTM D638	3,150
Flexural Strength (psi)	ASTM D790	6,280
Flexural Modulus (psi)	ASTM D790	777,000
Ultimate Compressive Strength (psi)	ASTM D695	9,870
Glass Transition Temperature ºF (Cº)		150 (66)
Peak Service Temperature ºF (ºC)		400 (204)
Machinability		Excellent
Sandability		Excellent

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DATA SHEET

HK311 FOAMING FILM ADHESIVE

HK311 is an intumescent film adhesive formulated to splice honeycomb copre to adjacent close-out members or to splice individual sections of honeycomb together in the manufacture of sandwich structures.

HK311 is compatible with most 250ºF and 350ºF curing adhesive systems. HK311 will not sage or slump during the curing process. The expansion of HK311 is approximately 2.5 to 3 times the original thickness. HK311 allows the designed to use various core densities within a single sandwich to meet specific local load conditions. HK311 acts to stabilize honeycomb core materials when interfacing with adjacent structural members in the transfer of shear loads.

SPEIFICATIONS

Form:	Pliable Film
Standard Thickness:	0.050”
Standard Weight:	0.30 lbs/sq ft
Color:	Tan
Size:	1’ X 2’ Sheets
Shelf Life:	4 days @ room temperature (77ºF)
	3 months @ 40ºF
	6 months @ 0ºF
Cure Cycles:	90 minutes @ 235ºF
	60 minutes @ 250ºF
	40 minutes @ 275ºF
	15 minutes @ 350ºF

AVERAGE MECHANICAL PROPERTIES

	Core Shear Strength (psi)
-67ºF	780
	Room Temperature (77ºF)
180ºF	780

All tests result in failure of the core material

NOTE: HK311 should be allowed to reach room temperature before removing from protective packaging to avoid moisture condensation on film surface.

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DATA SHEET

HK6002 Film

PHYSICAL PROPERTIES

		HK6002 – 6	HK6002-9
Gauge	mil	5.97	9.48
Basis Weight	g/m²	146.00	224.03
Density	g/cc	0.9668	0.9597
Haze	%	19.3	33.1
OTR 2/20 mil	mil	6.05	9.27
OTR 2/20	cc/100 in²/day	1.446	1.065
Tensile Gauge MD	mil	6.13	9.42
Tensile @ Break MD	grams	12559	19746
Elongation @ Break MD	%	270	299
Tensile @ Yield MD	grams	10902	14269
Elongation @ Yield MD	%	7	5
Tensile @ 5% MD	grams	10971	17086
Tensile @ 10% MD	grams	12000	18724
Tensile @ 25% MD	grams	10698	15925
Elmendorf Tear MD	gf	176	327
Tensile Gauge TD	mil	5.94	9.66
Tensile @ Break TD	grams	12368	18443
Elongation @ Break TD	%	301	290
Elongation @ Yield TD	%	3	3
Tensile @ 5% TD	grams	11126	16098
Tensile @ 10% TD	grams	12211	18367
Tensile @ 25% TD	grams	9322	14741
Elmendorf Tear TD	gf	462	1346

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DATA SHEET

HK37 A&B RTV HIGH TEMPERATURE CASTING COMPOUND

HK37 A&B RTV is a two part modified RTV compound designed for use as a flexible mold-making material for urethane foams and other cast materials. HK37 A&B is ideal for casting pressure pads. The high differential in thermal co-efficient of expansion between HK37 A&B and a sealed metal tooling box makes it useful in trapped rubber molding

PROPERTIES – UNCURED

Base to curing agent ratio:	100 Parts A – 12 Parts B
Color – Base (Part A)	Tan
Color – Curing Agent (Part B)	Blue
Viscosity at 77ºF (25ºC) Cps after addition of curing agent	150,000
Shelf Life:	6 months from date of manufacture

PROPERTIES – CURED 24 HOURS AT 77ºF (25ºC)

Durometer Hardness Shore A,	ASTM D2240	50 +/-5
Tensile Strength, psi	ASTM D412	650
Elongation, percent	ASTM D412	180
Tear Strength, psi	ASTM D624	65
Specific Gravity @ 77ºF (25ºC)		1.25
Heat Resistance to Thermal Conductivity BTU/FT/HR FT2 ºF		1.5

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DATA SHEET

HK38 A&B RTV HIGH TEMPERATURE CASTING COMPOUND

HK38 A & B is a two-part silicone rubber designed for tool hardness, physical properties and chemical resistance. HK38 A & B has excellent high tear and tensile properties. Typical applications would be relief type molds because of its firmness and molds with deep undercuts, which are tough to de-mold

PHYSICIAL PROPERTIES (TYPICAL VALUES) - UNCURED

Base to curing agent ratio:	100 Parts A – 10 Parts B
Color – Base (Part A)	Tan
Color – Curing Agent (Part B)	Blue
Viscosity at 77ºF (25ºC)	100,000 CPS
Shelf Life:	6 months from date of manufacture

PROPERTIES – CURED 24 HOURS AT 77ºF (25ºC)

Durometer Hardness Shore A,	ASTM D2240	65
Tensile Strength, psi	ASTM D412	650
Elongation, percent	ASTM D412	250
Tear Strength, psi	ASTM D624	110
Specific Gravity @ 77ºF (25ºC)		1.28
Heat Resistance to Thermal Conductivity BTU/FT/HR FT2 ºF		1.5

Conditions to Test: Post cure of 1 hour @ 400°F after room temperature cure of 24 hours.

Mixing Instructions: The base and curing agent are mixed just before using. Mix 100 parts base to 10 part curing agent by weight. Automatic mixing equipment or manual mixing may be used to combinebase and curing agent. Immediately after mixing, place the material in a vacuum chamber to remove trapped air. As the vacuum is drawn, the material will expand as much as four times its original volume. Remove from vacuum chamber and pour.

Note: If settling should occur at the bottom of your container, do not mix material manually. Please call for further instructions.

INHIBITION: Certain materials will cause inhibition or neutralizing of the curing agent: sulfur and organo-metallic salt containing compounds found in organic rubbers, and many condensation cure RTV, chloride solvents, and amines-epoxy. Inhibition masy easily be determined by brushing a small quantity of these materials over a localized area of the part to be reproduced. If
the material remains gummy or uncured after the curing time, then the part's surface is acting as an inhibitor. ** See Addition Cure Technical Data Sheet for inhibiting substances.

CURING CHART

TEMPERATURE	POT LIFE	CURE TIME
100°F	30 MIN	2 HOURS
150°F	10 MIN	30 MIN
300°F	---	5 MIN

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DATA SHEET

SBS 40 SKIN BARRIER CREAM

SBS40 Medicated Skin Cream is a superior cream to help condition, soothe and heal skin. It is safe to use on all skin areas. SBS40 is specially formulated with emollients and moisturizers that soften and condition the skin by replacing lost natural oils and helps to prevent dryness.

SBS40 is a lustrous, white, thick-bodied cream with a pH of 5.3-6.3. The rapid rub-in leaves no "oily" or "greasy" after feel. SBS40 contains allatoin which is a cell proliferant that stimulates healthy skin tissue formation. SBS40 contains chloroxylenol – a proven bacteriostat to help reduce skin infections.

SBS40 is available in 1 and 5 fl oz plastic tubes and also in 85 fl oz plastic dispenser cans.

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DATA SHEET

RESIN FLOW GREEN

Resin-Flow Green is a high performance, low profile resin distribution medium for infusion molding. Resin-Flow Green has been specifically designed to distribute resin efficiently with little or no waste due to the low profile and tight construction. Resin-Flow Green can be used with polyester, vinylester and epoxy resin systems.

SPECIFICATIONS

Color	Green
Thickness	.035” +/- .003” (.89mm +/- 75µm)
Melt Point	320ºF (161ºC) (DSC Method)
Configuration of Net	Rhombic
Roll Size:	41” X 350ft (104cm X 106.6m)