



MTC475

Epoxy Component Prepreg

Introduction

MTC475 is an epoxy resin system designed to combine excellent clarity and elevated service temperature. It cures from 175°F to 250°F, allowing flexibility in component manufacture. It can be supplied on a variety of fabrics to meet your cost and manufacturing requirements.

Typical applications: *Higher service temperature – Visual*

Key Features & Benefits

- Cure temperature from **175°F to 250°F**
- Service temperature up to **355°F** after post cure
- Low CTE and shrinkage
- Work life at 70°F: **30 days**
- Storage life at 0°F: **12 months**
- Very low VOC content – no added solvents during manufacture
- Excellent clarity

Storage & Out Life

This material should be kept frozen at 0°F. It must be kept sealed in a polythene bag which must not be opened until fully thawed to room temperature. If the material is not fully used, then the material must be resealed in the polythene bag to prevent moisture absorption.



Cure Cycles & performances

CURE CYCLE OPTIONS:

Temperature		Duration	Tg
175°F	(minimum)	16 hours	195°F
195°F		8 hours	210°F
210°F		4 hours	230°F
250°F	(maximum)	1 hour	265°F
355°F	Post Cure	2 hours	330°F
390°F	Post Cure	2 hours	375°F

- Curing Schedule is meant to be a guide only and is subject to local conditions.
- To avoid exotherm particular care must be taken with thick laminates.
Ramp rates must not exceed **5°F** per minute during **initial cure**.
Ramp rates must not exceed **1°F** per minute during **post cure** (free standing).

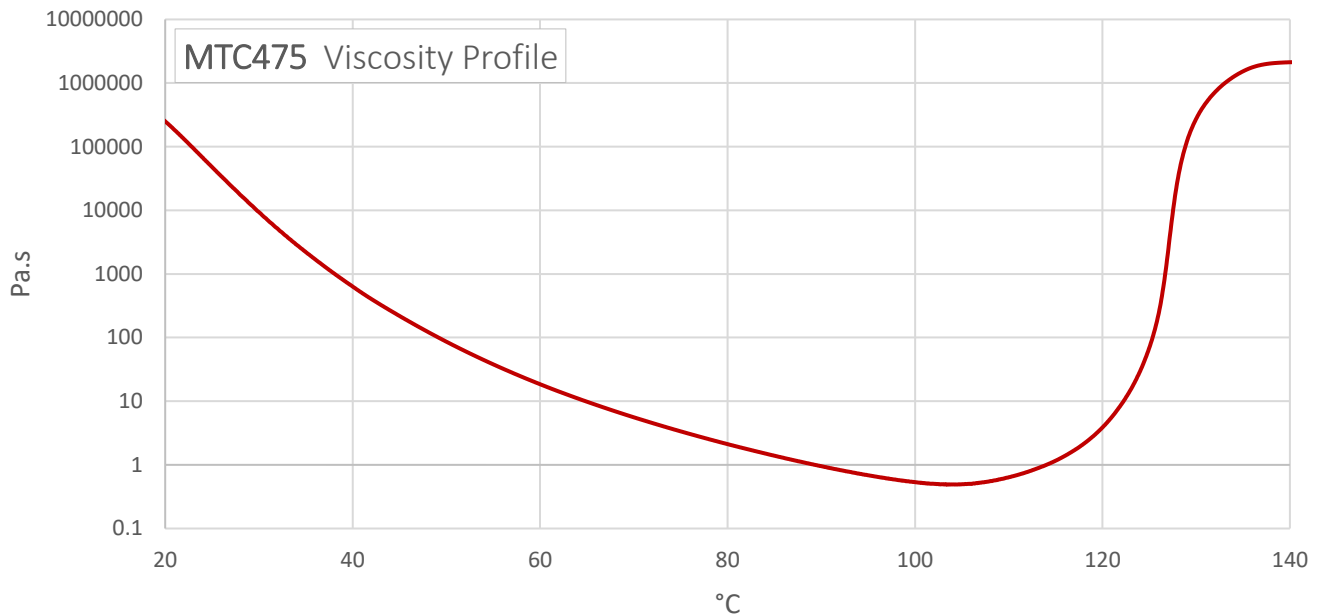
Cured Material Properties

Test	Results	Standard
DMA	Tg – Storage Modulus Onset	374 °F ASTM D7028
	Tg – Tan δ Peak	403 °F

Data obtained after a 390°F, 2h post cure.



Viscosity Profile



Health and Safety

This material contains epoxy resin which can cause allergic reactions with skin contact and must avoid repeated and prolonged skin contact.

Please refer to the product Safety Data Sheet before using this material. The following precautions must be taken when using epoxy resin preregs:

- Overalls must be worn.
- Impervious gloves must be worn.
- Curing schedule is meant to be as a guide only and is subject to local conditions.
- To avoid exotherm, particular care must be taken with thick laminates.
- Ramp rates must not exceed 5°F/min during initial cure and 1°F/min during post cure.

Disclaimer: Technical advice, instruction, data or recommendation, whether verbal or in writing, is given in good faith. The SHD company providing any such advice gives no warranty or guarantee, whether express or implied, in relation to such advice.

Customers must carry out their own tests and assessments as necessary in order to determine the quality and suitability of the product for their particular application and circumstances. Such testing should be performed under conditions identical to those to which the final component/product may be subjected. Values listed in any SHD document are for typical properties of the product or substance in question and are not intended to be used in establishing either statistical specifications nor engineering basis values. They do not constitute either minimum or maximum values for the product or substance in question.