

## SprayCore 4000 HDT Universal

Multi-functional, high heat distortion, sprayable syntactic that is VOC compliant.  
Can be applied as a barrier coat, bulk print barrier, core and wood replacement.

**Sprayable Coring**

**Sprayable Barrier Coat**

**Wood Replacement**

**Bedding Adhesive**

### Sizes

50 gallons in a 55 gallon drum  
189.2 liters in a 208.12 liter drum  
Catalyst not included

### Application Specific Features & Advantages

#### SprayCore 4000 HDT as Barrier Coat

- Premium vinylester matrix that provides higher resistance to water permeation and improves cosmetics when sprayed directly behind the gelcoat
- High strength to weight ratio with excellent adhesive properties which give reliable secondary bonding to the gelcoat and skin coat
- Spray-on application dramatically reduces or eliminates air entrapment behind the gelcoat, reducing warranty cost

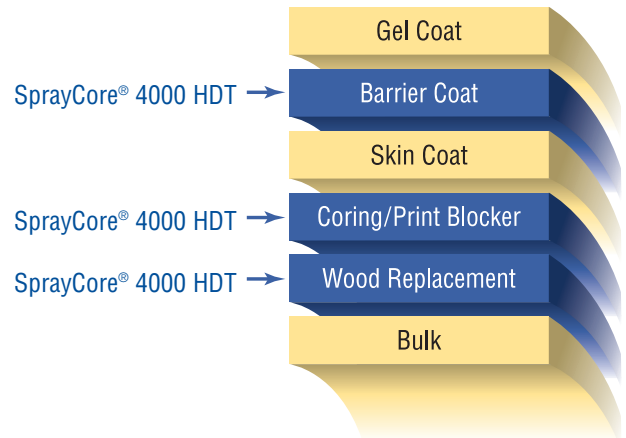
#### SprayCore 4000 HDT as Core/Bulk Print Blocker

- Replace labor intensive non-woven mat type material and eliminate potential air entrapment associated with the manual mat type application
- Reduce air voids associated with hand lay-up
- Reduce labor hours for application
- Low shrinkage upon curing, giving better dimensional stability prior to and after demolding
- Makes parts stronger, lighter, improves impact resistance and reduces manufacturing cost

#### SprayCore 4000 HDT as Wood Replacement

- Reduce labor hours for application (spray application vs. manually embedding wood)
- Eliminate warranty issues because SprayCore 4000 HDT will never rot
- Equal to or stronger than plywood with less thickness
- Guaranteed consistency – no knotholes or flaws

### Typical Laminate Structure



- Eliminate need for cutting room
- Eliminate waste, no leftover scrap pieces of plywood

### Features and Advantages

- Reduce emissions because SprayCore 4000 HDT is low styrene – less than 32%
- Improve productivity and reduce overall costs by increasing efficiencies
- Eliminate traditional costly, time-consuming and labor-intensive processes
- Simplify ordering and inventory management with one multi-usage product
- Rapid application and quick cure cycle make faster mold turnaround, decreasing labor costs

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**ITW SprayCore**  
Inventing Sprayable Syntactics

ITW SprayCore is the leading manufacturer of innovative sprayable syntactic materials and specialty sprayable fillers/primers for use in the fiberglass composites and industrial markets. ITW SprayCore is a division of Illinois Tool Works Inc., a Fortune 500 company.

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# SprayCore® 4000 HDT Universal

## Typical Properties/Performance

(all properties @ 77°F or 25°C)

**Appearance:** Off-white, thixotropic free flowing liquid

**Mix ratio:** 1.5 – 2.2% volume MEKP (Methyl Ethyl Ketone Peroxide)

**% Styrene:** 29%

**Viscosity:** 12,000 – 14,000 cps (HB #4 @ 20 rpm)

**Thix Index:** 3.0 – 4.0

**Density:** 5.25 – 5.75 lbs/gal, 0.63 – 0.69 g/cc

**Reduction:** NOT RECOMMENDED

**Coverage:** 1550 sq ft/gal/mil

**Typical Coating Thickness:** 250 – 500 mils wood replacement core

**Lbs/sq ft @ 1 mil:** 0.003428

**Gel Time\*:** 3 – 4 minutes

**Gel to Peak Range\*:** 5 – 8 minutes

**Peak Exotherm\*:** 300 – 350° F

When used as a barrier coat, laminate skincoat application interval is 15 – 25 minutes.

*\*Reactivity data based on a 100 gram mass sample*



## SprayCore 4000

Recognized for excellence  
by the National Marine Manufacturers Association (NMMA)

## Winner of the 2002 Innovation Award

Judged by Boating Writers International,  
the Innovation Award is the recreational boating  
industry's highest honor for product excellence.

**ITW SprayCore**