

CarbonBond Pourable Transom Compound(PTC)

INSTRUCTIONS:

STEP 1

Cavity needs to be dry and void of holes . Once you have determined the correct quantity of material to fill the cavity in continuous pour, catalyse the correct amount of material, no more than 5 gal at a time. We recommend doing a small test batch, to monitor gel time and cure rate, that may allow you to closely estimate the time you will have to get the material into the cavity. Working time should be at least 20 min up to an hour, depending on atmospheric and climate conditions. Mix EXACTLY the correct amount of catalyst into PTC.

Material Temperature	% by weight	gm/gal	gm/5 gal	cc/gal	cc/5 gal
60-65° F	2.00	66	323	63	310
65-70° F	1.80	59	290	57	279
70-75° F	1.60	53	258	51	248
75-80° F	1.50	49	242	47	232
80-85° F	1.20	39	194	38	186
85-90° F	1.00	33	161	32	155
90-95° F	0.80	26	129	25	124

Using a heavy duty double mixing blade, attached to a heavy duty ½” or larger drill, mix the product for 5 minutes. Use a mixing head with two blades, at least 4” in diameter. PTC does not expand, nor shrink when mixed. 5 Gallons needs 10.5 oz MEKP at 2%

STEP 2

In about 2 hours, or after the material has totally solidified , remove the dam(if used) and proceed with laminating , drilling and further fabrication, if necessary. Material reaches full cure in about 48 hours, but you can start working on it as soon as it has solidified and cooled down. Material should never exceed 160 F during curing cycle.