



# TECHNICAL DATA SHEET

## SK2TM200-2

Core material ready to use

### ► DESCRIPTION

SK2TM200-2 is a new high-temperature, water soluble fugitive core material. It is supplied as a moist powder which is machined, molded or hand shaped to the desired geometry and dried at 93°C. With a specific gravity of 0.45 wet, it is lightweight, easily machined, and thermally stable. SK2TM200-2 is compatible with most commercial epoxy and cyanate resin ester systems with cure temperatures below 193°C. It can be dissolved away from the cured composite quickly using tap water, and the effluent is nontoxic.

Unlike conventional mandrel materials, which must be tediously removed from composite lay-ups, SK2TM200-2 mandrel is readily soluble in cold tap water and can easily be washed away from the finished part. It saves time, labor and the wash-away feature minimizes the possibility of damaging fine details.

This product is used in various manufacturing processes of parts made of composite materials.

### Benefits

- Washes out in cold tap water in minutes
- Environmentally friendly
- Nontoxic and odorless
- Remove mandrel from previously
- Reduces labor and saves money
- Compatible with all commercial resins and disposal procedures required prepreg compounds
- Makes complex part manufacturing simple
- Strong and lightweight
- Easily repaired and re-formed
- Saves time inaccessible hidden areas
- Easily dried in a convection oven

It is recommended to seal the tool with SK2TM200-4 to prevent resin migration.

### ► TECHNICAL DATA

Material type:	Powder
Color:	White
Density Dry:	1500 -2000 psi
Coefficient of Thermal Expansion:	$5 \times 10^{-6}$ mm/mm°C

Drying at 120 to 135°C for 1.5 hour per inch (2,5 cm) of thickness in a hot air convection oven. Drying time can vary depending on geometry and size, you can control this by measuring weight loss in certain time steps.



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### ► SIZE

Volume	Weight
5 Gal (18,9 L)	Pail, Ø 330 x 380mm, 8,51 kg
55 Gal (208 L)	Drum, Ø 600 x 930mm, 93,61 kg

Shelf life: 24 months

Storage conditions: it is recommended to store at temperature from +10°C until +30°C in the original packing.

### ► NOTE

Please contact us for getting special manufacturing guide with involved techniques and properties of the product.

SK2TM200-2 is also available in machinable, pre-formed, dried blocks in virtually any size.

Please contact for more details about ordering mandrels in your shape and size.