DESCRIPTION
Toray MicroPly™ SF-4 is a BMI syntactic film that provides excellent elevated temperature properties and compatible to Toray RS-8HT. Toray MicroPly™ SF-4 is available in unsupported or supported continuous film form in various thicknesses from 0.25–2.5 mm (10 mils– 100 mils). Toray MicroPly™ SF-4 has been evaluated and qualified in aerospace structures.

FEATURES
- Excellent ambient and elevated temperature properties processing
- Good handleability, drape, and processing
- Low dielectric and loss tangent over wide thermal and electrical range
- Good moisture resistance
- Good toughness
- Oven, autoclave, and compression consolidation
- Lightweight film core; 39 pcf, nom (0.62 g/cc)

PRODUCT TYPE
204°C (400°F) Cure BMI Syntactic Film

PRODUCT FORMS
- Film to 127 cm (50”) wide

TYPICAL APPLICATIONS
- Aerospace structures
- Radomes

SHELF LIFE
Out Life: 14 days out life ≤ 21°C (70°F) and ≤ 60% RH
Frozen Storage Life: 6 months at ≤ -18°C (≤ 0°F)

Out life is the maximum time allowed at 21°C (70°F) or below and 60% or less RH before cure, after a single frozen storage cycle in the original unopened packaging at -18°C (0°F) or below for a period not exceeding the frozen storage life noted above.

TYPICAL NEAT RESIN PROPERTIES

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
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<tbody>
<tr>
<td>Density</td>
<td>39 pcf, nom. (0.62 g/cc)</td>
</tr>
<tr>
<td>Tg (DMA); Dry/Wet</td>
<td>295°C (563°F)/305°C (581°F)</td>
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</tbody>
</table>

CURE PARAMETERS
- Apply vacuum. For autoclave or press applications, pressurize to 45–100 psi
- Heat to 204°C (+5/-0°C) at 3±2°C/min or 400°F (+10°F/-0°F) at 5°F ± 3°F/min
- Hold at 204°C (400°F) for 2 hours (+15 min/-0 min). Cool.
  Post cure at 250°C (482°F) for up to 6 hours (+30 min/-0 min)

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