

## Control Material Flow with HV & XHV

Perfect for damming areas like equipment and console cut-outs in hardtops when working with J-Core 4501



For 4501 HV (Higher Viscosity) & XHV (Extra High Viscosity), we increased the viscosity of our lightweight hard top bonding compound to give you more flexibility. The higher viscosity allows for damming console and other cutouts to help prevent standard J-Core (4501) from leaking through. This means less finish work after the cure.

### Perfect for Other Small Part “Sandwich” Bonds, Too

J-Core HV & XHV can also be used in small parts with hand laid skins where more viscosity is required. You’ll still get the light weight, superb cosmetics and an extremely low number of costly defects the main product is known for.

### Performance Benefits

- Great for damming areas to prevent material flow
- Flows well under moderate clamping pressure
- Stays put when mold is flipped
- Cures with low exotherm for better cosmetics
- Available in multiple viscosities



Applying Standard J-Core to the hardtop shell

Marrying inner liner to the top shell after application

Standard J-Core Great for other “sandwich” style bonds

### ProTips & Other Resources at ArjayTech.com

- ProTip: Managing Material Flow with J-Core (PDF)
- ProTip: Beyond Light Weight with J-Core (PDF)
- ProTip: Avoiding Print in Mold Making (PDF)
- ProTip: Shedding Light on Light Weight Catalyzation (PDF)
- 4501 TDS (PDF) Available for download any time on our website
- 4501 HV & XHV (PDF) Available for download any time on our website

### TECHNICAL DATA SHEET

# 4501 HV / XHV

POLYESTER BONDING COMPOUND

### RECOMMENDED FOR

Damming in Hard Tops	Other “Sandwich Bonds”
Jobs Requiring More Viscosity	

### WORKING PROPERTIES

Gel Time	Reaction Time	Fixture Time	Peak Exo
28 min	45 min	73 min	150° F

### TYPICAL PHYSICAL PROPERTIES @75°F (24°C)

Color	White
Odor	Styrene
Texture	Smooth
Weight	4.8-5.1 lbs/gallon
Shelf Life	3 months

### VISCOSITY

RPM	μ Min	μ Max
2	130,000	180,000

### TYPICAL CURED PROPERTIES @75°F (24°C)

Test	Average HV	Average XHV
Tensile Elongation, %	6	6
Tensile Strength, PSI	1,080	1,000
Flexural Strength, PSI	7,120	6,400
Compressive Strength, PSI	1,850	1,500
Lap Shear, PSI	1,080	900
Heat Deflection, °F	150	150
Linear Shrinkage, %	< 1	< 1

### PACKAGING & AVAILABILITY

Pails  
5 Gal./19 L



ITEM# 4501 HV / XHV

Drums  
55 Gal./ 189 L



ITEM# 4502 HV / XHV