

S120 ADVANCED BOARD & MOULD SEALER

Key Features

- High Sealing Ability
- High Gloss Finish
- Easy, Quick Application
- Non-Contaminating
- Low Odour

Product Description

S120 is a remarkable new generation of high performance board sealer recommended for the sealing and restoring of epoxy and polyurethane model/tooling board and composite moulds. S120 can transform machined-finish tooling board into a hard-wearing high-gloss finish pattern or mould in just a few applications.

S120's high-solids formulation means that new boards can be sealed and glossed in around 8 applications resulting in a hard-wearing, high gloss surface ready for release agent preparation. S120 is suitable for use on new model board or tooling board patterns as well as on low to medium volume tooling board moulds and high volume composite moulds.

Cured applications of S120 can be flatted and polished, allowing a high quality, glossy surface finish to be produced.

Recommended Uses

S120 Tooling Board Sealer is ideal for the sealing, glossing and restoring of:

- Epoxy tooling board patterns and moulds
- Polyurethane modelboard and tooling board patterns and moulds
- Composite moulds (including un-gelcoated moulds such as carbon fibre)
- MDF, wood, filler and other porous pattern-making materials

SB120 is also suitable for eliminating porosity and restoring gloss to deteriorated surfaces on moulds made from epoxy, polyester and vinylester resin systems.

Properties

The table below shows the typical uncured properties:

| Property | Units | Result |
|------------------|-------------------|--|
| Appearance | - | Colourless liquid |
| Odour | - | Hydrocarbon, Disobutyl ketone, methanol |
| Specific Gravity | g/cc | 0.792 |
| Flash Point | °C | 18 |
| Solvents | - | Aliphatic Hydrocarbon, Diisobutyl ketone, methanol |
| Max. Temp. | °C | 280 Continuous, 410 for up to 30 mins |
| Coverage | m ² /L | 20 - 25 |
| Shelf Life | Months | 6 |
| Storage | - | Flammable Store |

How to Use

SB120 can be applied by wiping or spraying. When applying the sealer by hand, a lint-free wipe should be used. When spraying the sealer, smaller areas can be sprayed using a trigger-action atomiser whereas larger patterns will require a HPLV spray gun. In all cases, the sealer needs to be built-up over a number of applications and will usually involve some light flattening.

Before applying the S120 Board Sealer, clean the mould or tool surface to remove traces of dust, dirt, oils or release agent. The mould must be clean and dry before use. Mould cleaning and sealing should be performed in a well-ventilated area.

Spray Application

Smaller areas can be sprayed using a trigger-action atomiser whereas larger patterns will require a HPLV spray gun for best coverage.

When using the trigger spray nozzle, the S120 will cure inside the nozzle within around 30-40 minutes so the nozzle can be used for multiple sequential applications on the same project but will cure in the nozzle immediately afterwards.

Holding the nozzle of the gun approximately 20cm from the mould surface, systematically coat the entire surface of the mould. Care must be taken to over-lap sprayed areas.

Allow the product to dry (typically approx. 15-20 minutes at 20°C) before applying the next coat.

Depending on the porosity of the substrate, repeat the spray application until the mould is sealed and has taken on a good even gloss finish. A typical high density model board may take between 4 and 6 coatings to be sealed.

De-Nibbing

A "mirror-like" finish can be obtained by a light de-nibbing just prior to the final coat of S120 Board Sealer. Using 1200 grit paper gently work your way over the surface removing any high spots or surface defects. The Board Sealer sands very easily meaning this stage will be relatively easy to complete.

Once the defects have been removed, clean the surface of the board ready for a final coating of Board sealer. The application of an additional coat of S120 Board Sealer after the de-nibbing will generate a high gloss with virtually no imperfections.

Wipe Application.

For best results, we recommend applying the final coat by wiping the sealer on using a lint free wipe. Cut a cloth down to size before thoroughly wetting out with the S120 Board Sealer.

Gently wipe over the surface of the mould ensuring complete coverage of the mould. Take care not to double coat or over coat areas that have already been wiped as the double coating may leave wipe marks and/or surface imperfections which may ruin the high quality high gloss finish.

Final Curing

Before the sealed mould or board can be used, it needs to be allowed to fully cure. Typically leaving the board overnight will ensure a full cure, however, you can speed this cure up at an elevated temperature.

Place the board or mould into an oven at 60°C for a minimum of 20 minutes before allowing to cool. The Board is then ready for use.

Transport and Storage

Sealer should be kept in tightly seal containers during transport and storage. Sealer should be stored in ambient conditions of between 10°C (50°F) and 25°C (77°F).

When stored correctly, the Sealer will have a shelf-life of 6 months. Pay particular attention to ensuring that containers are kept tightly sealed.

Moisture Sensitivity

S120 Advanced Board & Mould Sealer is very sensitive to moisture and must be stored in a tightly sealed container. Each time the container is opened the life of the product will be reduced and as such it is strongly recommended to only purchase the amount you need for your current project or to purchase the board sealer in multiple smaller packs which can remain sealed until you need them.

Disclaimer

This data is not to be used for specifications. Values listed are for typical properties and should not be considered minimum or maximum.

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Easy Composites Ltd

Unit 39, Park Hall Business Village, Longton, Stoke on Trent, Staffordshire, ST3 5XA, United Kingdom.

Tel. +44 (0)1782 454499, Fax. +44 (0)1782 596868, Email sales@easycomposites.co.uk, Web www.easycomposites.co.uk