TECHNICAL DATA SHEET

SK2TM80-3

Hard epoxy surface coat for board SK2TM125-1

► DESCRIPTION

SK2TM80-3 is two component epoxy paint, used to give a high gloss finish to epoxy tooling block. It is an essential element of a successful composite tooling package, and has been developed to provide the best interface between SK2TM125-1 epoxy tooling block and epoxy tooling prepregs.

► TECHNICAL CHARACTERISTICS

- Easily applied to the tooling block
- To be sanded (after thermal treatment)
- Spray gun or brush application
- High gloss finish
- High hardness

► MIX RATIO

Mix ratio by volume:	*1 volume part A* *1 volume part B*	*Mix ratio by weight:*	*100 part A* *80 part B*

► SURFACE PREPARATION

- The tooling block surface to be coated must be clean and dry, with all traces of oil and grease removed with the supplied solvent.
- On some absorbent surfaces, like wood, apply a layer of the epoxy paint SK2TM80-3, and cure for a night, then sand it slightly before applying the additional layers.
- Some boards would need a thin layer of epoxy primer on porous surface

► SPRAY GUN APPLICATION

- Whatever the surface, it is recommended to apply the first layer with a chiffon by wetting the surface and by removing the excess.
- **Method 1** : Apply 3 to 4 light coats, allowing a minimum 5 minutes between each coat, ensuring that the final coat has wet out the surface fully, thus ensuring the highest quality gloss finish. Let dry at room temperature for a minimum of 2 hours before curing.
- **Method 2** : Apply 2 to 3 coats with the spray gun (same process as method 1) , let dry for 2 hours minimum before curing. Proceed to the thermal treatment: Sand with an abrasive paper (e.g. P 600), clean then apply the top coat , let dry and cure.

► BRUSH APPLICATION

- Always use a good quality brush in order to prevent from having dust marks when the paint is dry.
- Apply 4 to 6 coats, allowing 20 to 30 minutes between layers according to the temperature.
- For best results, let dry for a minimum of 4 hours before curing.

► POSTCURE

After allowing the paint to dry (depending of the process used) for a minimum of 2 to 4 hours at room temperature the paint should be postcured in an oven to increase the hardness. A postcure of 4 hours at 60°C is recommended, if the master cannot withstand 60°, then cure for 12 hours at 45°C.
In these conditions, the epoxy surface coat SK2TM80-3 can withstand a 80°C final temperature.

► FINAL PREPARATION

The epoxy surface coat SK2TM80-3 can be easily sanded smooth to remove any surface blemishes or dust marks using fine wet and dry abrasive paper (P 1200). To achieve the best gloss surface finish, automotive type rubbing/polishing compounds can be used. Once the master model has been polished, wipe the surface with a suitable solvent to remove any final traces of polishing compound. Acetone is ideal if only postcuring has been carried out.

► STORAGE

Shelf life is 6 months in a dry place and in original unopened containers at a temperature between +15°C and +25°C. When stored several months blend each part before mixing.

► PACKAGING

The kit allows to paint from 5 to 10 m² (according to the shape complexity).

RESIN	HARDENER
1 litre	1 litre

► GUARANTEE

The information of our technical data sheet is based on our present knowledge and the result of tests conducted under precise conditions. It is the responsibility of the user to determine the suitability of the products, under their own conditions before commencing with the proposed application. We refuse any guarantee about the compatibility of a product with any particular application. We disclaim all responsibility for damage from any incident, which results from the use of these products. The guarantee conditions are regulated by our general sale conditions.