

## TECHNICAL DATA BULLETIN

### CONCENTRATED EPOXY SEALER FOR EPOXY TOOLING BOARD 692A RESIN / 692B HARDENER

CPD 692A resin with CPD 692B hardener is the base system to produce a low viscosity sealer specifically designed to function at the operating temperatures of epoxy tooling board and to generate a clear, tough, chemical resistant surface on the board. Multiple layers of the sealer will result in a high gloss finish. The system must be diluted with a solvent prior to application.

#### HANDLING PROPERTIES

	<u>VALUE</u>	<u>TEST METHOD</u>
Resin Density at 25°C, g/cm <sup>3</sup>	1.19	ASTM D1475
Hardener Density at 25°C, g/cm <sup>3</sup>	0.97	ASTM D1475
Resin Viscosity at 25°C, cP	3,600	ASTM D2196
Hardener Viscosity at 25°C, cP	40	ASTM D2196
Initial Mixed Viscosity at 25°C, cP	3,000	ASTM D2196
Starting Formula* Viscosity at 25°C, cP	90	ASTM D2196
Mix Ratio By Weight	100A : 15B	Calculated
Gel Time at 25°C, 150g mass, minutes	25	ASTM D2471
Starting Formula* Pot Life at 25°C, hours	>3	ASTM D2471

#### DILUTION OF THE SYSTEM

First combine part A and part B at the mix ratio published above, then thoroughly mix the two components. One of the following solvents is required to reduce the concentrated sealer mixture: lacquer thinner, xylene, methyl alcohol, isopropyl alcohol or acetone. The system will turn milky if the water content of the solvent is too high. The diluted resin mixture should be clear for best results. Lacquer thinner performed best under laboratory conditions.

#### \*Starting Formula

- 1 liter – Mixed Part A and Part B
- 3 liters – Lacquer Thinner

#### APPLICATION

The diluted resin mixture can be applied by spraying, brushing, or wiping. The amount of solvent used can be adjusted to suit the application technique and shop temperature. Care must be taken to clean any equipment used to apply the diluted resin mixture promptly. The resin mixture will begin to gel as the solvent evaporates.

**CURE OPTIONS:**

One to seven coats of the sealer can be applied. Select one of the following cure schedules for each coat depending on the available time and the desired physical properties of the final part. Please contact technical service if you find it necessary to have a different post cure schedule.

**CURE INCREMENTS:**

	OPTION 1	OPTION 2
2 hrs. at 25°C - Each Coat	X	
30 min. at 66°C - Each Coat		X
2 hrs. at 66°C - Final Coat	X	X

**STORAGE AND HANDLING:**

Store at 16-32°C in a dry place. After use, tightly reseal. (This product may crystallize during storage. If crystallized, vent container and heat to 55-65°C until crystal dissolve. Stir well after product has liquefied.) Always use clean dry tools for mixing and applying. Mix according to the mix ratio stated for the specific product as listed on the front page. Material temperatures should not be below 18°C when mixing.

**SAFETY HANDLING:**

Work in well ventilated areas using gloves, eye protection and clothing protection. Avoid contact to the skin and eyes. Avoid clothing contamination. Wash thoroughly after handling. These products may cause skin and respiratory allergic reactions. Consult Material Safety Data Sheets for complete precautions with this product.

**Endurance Technologies, Inc. is not a patternmaker. We have experience only in the compounding of resins, not in the actual manufacture of the tools or patterns. Each part is different. The user should run tests to assure the suitability of the system for use in a particular application. The test data and results set forth herein are based on laboratory work and do not necessarily indicate the results that the buyer or user will attain.**

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