

F 760 Glosskote

F760 is a resilient polyester Glosskote resin with good mechanical properties.

Applications :

For mould refinishing and pattern work. Can be applied using a soft, clean paint roller (shortpile) or gravity feed spray equipment.

The most important features are :

- Gloss , tack free surface , surface cure not inhibited with wax (No wax in system)
- Free from drainage on inclined or vertical surfaces in correct thickness
- Self Leveling
- Can be pigmented with pigment paste
- Good adhesion to the backing laminate

Typical gel times of Methyl Ethyl Ketone Peroxide (MEKP) at 25 deg C are :

- 1% MEKP 23 minutes
- 2% MEKP 10 minutes

Do not cure at temperature below 15 Deg C

TECHNICAL DATA	
Appearance	Pink Liquid
Viscosity (Centipoise @ 25 deg C)	4 - 5 000
Thix Index	3 - 5
Volatile Content	37 +-2%
Flash Point	35 deg C

Storage

Six months from date of manufacture if kept in closed opaque containers at 20 - 25 Deg C.

PLUG OR PROTOTYPE APPLICATION PROCEDURE

For the best results, follow the application guidelines listed below.

A. SURFACE PREPARATION

1. The surface will require sanding with a minimum grit of 36-DA or a maximum of 80 grit production sandpaper. The use of finer grit sand paper on the surface will require less F760 Glosskote to complete the job. Duroplastic F760 single pass coat will not fill in 60 or 80 grit open scratches made by hand, however, it will fill in 80 grit DA or Orbital sanding scratches.
2. If the surface of the plug has exposed wood, those areas will need to be primed with catalyzed sanding resin before the F760 Glosskote can be applied. Sanding resin is formulated to cure tack free, and sandable in 8 hours. After the resin has cured it will be necessary to sand those areas with a maximum grit of 80 or a minimum of 280 grit production sandpaper. DO NOT sand through to the wood.
3. Before spraying, the surface should be free of dust and moisture.

B. CATALYST

1. It is recommended that MEKP or LPT or LA3 equivalent be used to catalyze Duroplastic F760 Glosskote. Two percent by weight is also recommended. The scale below is converted to CC's by weight.
2. At 2% catalyst, and 25 degrees celsius room and material temperature, a pot life of 20 minutes can be expected. As the room and material temperature increases, the pot life will become shorter. To increase the pot life during high temperatures, keep the material at 22 degrees celsius until you are ready to use it.

ONE LITRE OF F760 Glosskote --- 20 CC'S OF CATALYST = 2% BY WEIGHT.

C. APPLICATION PROCEDURE (GRAVITY TYPE SPRAY SYSTEM)

1. Add up to 5 - 8% by weight of reducer as and when required. Add up to 80ml of reducer per litre of Duroplastic F760.

NOTE: It is recommended that a test spray be conducted using plain without reducer , only then add additional reducer up to the maximum amount of 80ml per litre, if needed.

2. For the best spraying results and minimum orange peel, use a gravity type spray gun like that used to spray spary filler paints or automotive lacquer, enamel or polyurethane.
3. For optimum control of the air pressure, a control valve with a pressure gauge should be installed on the air inlet of the spray gun.
4. Set the air pressure going to the spray gun at 2-4 Bar.
5. Spray test passes onto masking paper or plastic. Set the fan to be approximately 75mm wide at a point 15cm from the air cap wings. Fine tune the air to a pressure, adjusting the spray pattern to a fine atomized spray.
6. DO NOT use more air pressure than is needed, excessive air pressure will cause more orange peel than necessary.
7. Hold the spray gun 30 to 45cm and perpendicular to the spraying surface whenever possible. Apply (4-6 thou) 100 - 150microns of Duroplastic F760 Glosskote to the surface by making long even passes. Let the first layer flash off. **MIX SUFFICIENT FOR EACH PASS NOT SUFFICIENT FOR THE COMPLETE JOB**

8. Apply another 75-150 microns in the same procedure as the first. Let this application of F760 Glosskote flash for another 2 to 3 minutes.

9. The third application of F760 Glosskote can be applied in a 75 micron pass (It is best to add reducer as per above at this stage only)

10. After applying the desired amount of Duroplastic F760 , let the sprayed material cure until it has a dull tack free finish. At 25 degrees this should take approximately four hours, at which time the sanding procedure can be started.

NOTE: These are guideline pressures and delivery rates. Before spraying, test your equipment by spraying material onto masking paper or plastic. At this time, fine tune the equipment to suit your application requirements.

D. SANDING AND BUFFING

1. Choose a sandpaper that will remove the orange peel. If wet sanding is your choice, 220 wet and dry or 30 Micron will do the job. If dry sanding is your choice, 320 finishing paper should do the job. Use a modern DA sander such as a Rupes . Use water wherever possible.

2. To achieve the optimum finish, the final sanding should be equal 1200 Grit wet or dry.

3. For compounding and buffing use a light abrasive compound, such as TR 311 or equivalent with a wool buffing pad. For best results follow the compound manufacturers application instruction. (Remeber to use water to cool down polishing compound)

4. Use a low speed buffer (electric or air), with an RPM of 900 to 1600 RPM (Best is the Rupes polisher sanders)

5. After compounding, and the desired gloss has been obtained, a glaze or buffing swirl remover (such as TR Industries) may be applied. For optimum results use these products according to the manufacturers recommended procedures.

E. RELEASE AGENTS/WAXIN

1. All common mould release waxes can be used. A minimum of five coats should be applied to the plug surface. Since application of these products vary from manufacturer, it is important to read and follow each application procedure to the letter. TR release agents are recommended.

SAFETY AND HANDLING PRECAUTIONS

F760 Glosskote contains styrene monomer. All recommendations in the handling and care of styrene monomer as described in the Chemical Safety Data Sheet.

"OPEN WITH CAUTION" Read data sheets carefully before using Duroplastic products. Keep away from heat, sparks, and open flame. Avoid prolonged contact with skin and breathing of vapour or spray mist. If spilled upon clothing, remove immediately and wash before rewearing. Use with adequate ventilation. If swallowed, do not induce vomiting. In case of contact with eyes, flood repeatedly with plenty of water. In either case CALL A PHYSICIAN. KEEP OUT OF REACH OF CHILDREN. Do not add additional accelerators to catalyzed material.

STORAGE

Store Glosskote in a cool area below 25 deg C and out of direct sunlight. No warranties are given on shelf life, in as much as conditions of shipping, handling, and storage are beyond our control.

NOTE GLOSSKOTE IS NORMALLY NOT ACCELERATED. PLEASE CHECK ON CAN OR DO A TEST PRIOR TO USING TO ENSURE IT IS PREACCELERATED.