



APPLYING GUIDE

MOULD SEALERS

Sealers or pore-fillers provide to the applied surface a transparent film, flexible and very resistant. This film is stuck to the substrate, sealing the possible sticking point both physical-chemical.

The use of the sealers avoid the elimination of the micro-pores and other mould surface irregularities which may result in sticking point during the manufacturing process. It also increases the safety margin against possible adhesions, facilitating and making safer the action of the release agents.

Sealers also produce improvements in the resistance against chemical agents and improve the surface development against the abrasion.

The use of ABABOL sealers/pore-filler allows an increase in the mould's life.

ABABOL PRODUCTS offers a wide range of sealants, of easy application, fast cured and adapted to all types of moulds.

All our sealers:

- Are compatible with all types of release agents, both water-based and solvent-based.
- Do not require special conditions for application. Cure time is around 15 minutes in standard conditions (20-25°C).

ABABOL S

- Sealer for a high process spectrum, recommended in all mould and substrate types.

ABABOL GSP

- Sealer for a high process spectrum, suitable for all surface types.
- Easy application and high performance.

ABABOL TOT

- Suited for all type of surfaces.
- ABABOL TOT can be used as release agent (dual function sealing and demoulding).

ABABOL TP

- ABABOL TP is specially recommended for manufacturing process of high shine pieces.

ABABOL Seco

- A sealer free of solvents. Based in our own technology LCC (liquid crystal coating).
- Recommended especially in metallic moulds.

APPLYING INSTRUCTIONS

For a correct application of any sealer, there are some basic steps you must follow. Before applying the sealer, the mould must be completely clean, without dust rest neither the cleaner itself. The looking and touch must be the one of a degreased surface. As much clean be the surface better will be the mould sealer and therefore better and more protected you will have it. For the cleaning we recommend one of our cleaners ABABOL C, C+, Cd or Dry cleaner. For more information visit our web www.ababoldemould.com

It is always better to apply multiple layers with a small product amount than fewer layers with more product amount. Follow the specific application instructions of each products.

The application should be with cellulose clean paper, white and without pigments. If you use cloth, avoid synthetic and colored ones. Discard this piece of paper and pick up other clean for lusting. Once it is used, discard the piece of paper.

APPLYING MANUALLY

Choose a small area of the mould (around 1 m²) and apply the product in the selected area with a wet piece of paper or wet cloth.

Wiping over the area until the sealer is well distributed and before it evaporates. Time between applying and wipe on depends on the evaporation speed of each sealer. Mould temperature is also very important.

In the case of quick evaporation some marks may appear in the mould, apply more SEALER and wipe on immediately.

Repeat the step 2, until the whole mould surface is covered. Waiting time recommended (usually 15 minutes) until the curing of the coat that has been applied. After that time, the mould is ready for applying more sealer coats if necessary or you can begin applying the mould release agent. Consult TDS to know the number of coats to apply.

APPLYING WITH A SPRAY GUN

As in the manually application, the spray gun application requires some basic recommendations to follow. You should look for a thinnest nozzle spray gun possible, similar, or lower than 0,5mm, with independent assistance of sprayed air and product. It must have a product pass regulation as well.

The movement of the gun must be uniform. There is important to follow a behavior patterns to guarantee a uniform proportion of release agent (Fig.3).



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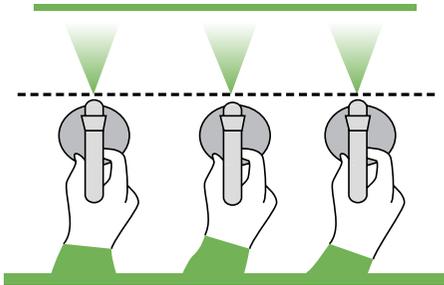


Fig.1. Wrong movement position. The movement of the gun must be left to right and not up and down.

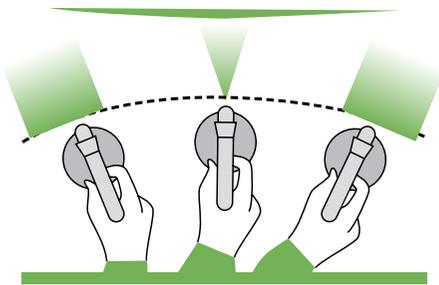


Fig.2. Too much product placed in the middle of the mould because of the wrong application.

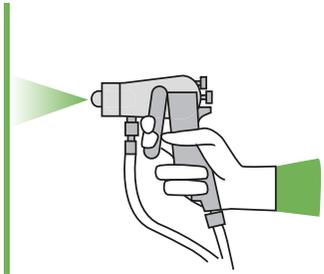


Fig.3. Right position.

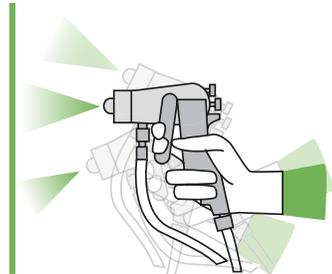
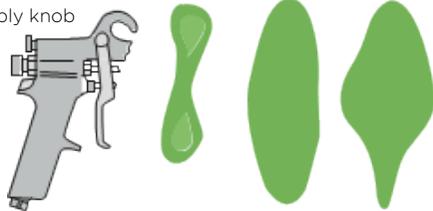


Fig.4. Wrong movement position. The movement of the gun must be left to right and not up and down.

Hand speed must be adjusted with the volume of release agent applied.

Air supply knob



Too much air Ideal pattern Too much fluid

In this picture you can see the type of mark must to make the product, when the gun is fixed on a horizontal surface's point.

As indicative data for an ambient temperature of 20-25 °C.

PRODUCT	DISTANCE TO THE SURFACE	APPLYING WIDTH
ABABOL TP/TOT/S	20-30 cm	30-40 cm
ABABOL S eco	25-35 cm	30-40 cm

In solvent based products applying is easy with a recommendation air/material 1.5/2.1, it depends of the nozzle type.

In solvent free products spraying is more difficult because you must ensure a perfect atomization and to avoid product accumulation and big drops of release agent. To this effect is recommended 3:1 air/material relation and a low pass of product.

You must re-apply several coats with low volume product. Then the evaporation will be almost immediate.

Ababol TP/TOT/S you must reduce the pass of material or speed of movement of the gun, increasing the coats if needed.

Ababol Seco, you can increase pace of material by reducing applying time.

At www.ababoldemould.com you can see spraying application of our release agents with the recommended amount and application velocity.

If you need more information of our Ababol products, you can visit our website www.ababoldemould.com or contact us sending an email at contacto@cladescomposites.com

