



EC85 HARD EPOXY SURFACE COAT

2 Part Epoxy Paint, used to give a High Gloss Finish to Epoxy Tooling Block

EC85 is an essential element of a successful composite tooling package, and has been developed to provide the best interface between high quality epoxy tooling blocks and HX range of epoxy tooling prepreg. EC85 provides a very hard, high gloss finish to the tooling block allowing tools with an excellent glossy surface finish to be easily produced.

CHARACTERISTICS:

- Easily applied to the tooling block
- Chemical and solvent resistant
- High gloss finish
- Competitive cost and delivery
- High hardness

PROPERTIES

Density	Part A	1.1 g/cm ³ (68.7lbs/ft ³)
	Part B	0.9 g/cm ³ (56.2lbs/ft ³)
Service temperature	75°C (167°F) (maximum)	



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MIX RATIO

EC85 epoxy surface coat is supplied as a two part system (1 Ltr + 1 Ltr) with an optional thinner constituent Part C (1 Ltr):

Part A: Epoxy base paint (Black coloured)

Part B: Hardener (Amber coloured)

Example

Mix Ratio (by volume)	1 part epoxy base (part A) 1 part hardener (part B)	100cm ³ 100cm ³
Mix Ratio (P.B.W)	100 part epoxy base (part A) 80 part hardener (part B)	100g 80g

1 x (1 Ltr + 1 Ltr kit) covers 3 to 4 m² assuming a good quality block has been used and the surface has been prepared to a high standard.

SPRAY APPLICATION

The surface of the tooling block to be coated must be clean and dry, with all traces of oil and grease removed with a suitable solvent, EC85 PART C THINNER is ideal.

For best results, spray application is recommended and a purpose built spray booth should always be used. A suitable breathing mask should be worn, preferably air fed.

Apply 4 light coats, allowing a minimum of 10 minutes between each coat, ensuring that the final coat has wet out the surface fully, thus ensuring the highest quality gloss finish.

A 3rd thinner constituent PART C is also available to aid application of the paint onto more porous surfaces. Use of this product depends on the substrate to be coated and it is recommended that the customer carries out trials beforehand.

Allow to air dry for a minimum of 2 hours.

OVEN DRYING/POSTCURE

After allowing the paint to dry for a minimum 2 hours at ambient temperature 20°C (68°F) the paint should be postcured in an oven to increase the hardness.

A postcure of 4hrs @ 60°C (140°F) is recommended, although if the master cannot withstand 60°C, 12 hrs @ 45°C (113°F) should be used.



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FINAL PREPARATION

EC85 epoxy surface coat can be easily sanded smooth to remove any surface blemishes or dust marks using fine wet and dry abrasive paper (P1200 grit). 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, EC85 PART C THINNER is ideal.

STORAGE

Shelf life at ambient temperature 20°C (68°F)

EC85 Part A – 6 months
Part B – 6 months
Part C – 24 months

HANDLING SAFETY

Observe established precautions for handling epoxy resins and solvents. Wear gloves and use suitable breathing masks, preferably air fed.

For further information refer to Material Safety Data Sheet.

FURTHER INFORMATION

Please contact Amber Composites for additional information.

NOTE: EC85 has been specially developed for use with high quality epoxy tooling blocks. No claims of performance are made with any other application, e.g. polyurethane blocks and we therefore recommend that EC85 is tested for each application individually.

This is not a specification. The information given in this data sheet in relation to the performance, storage and other characteristics of the product is based on results gained from experience and tests and is believed to be accurate. Given, however, that conditions of use and storage will vary, Amber Composites will not be liable for any loss or damage resulting from reliance upon such information. The purchaser is recommended to carry out his own tests to establish the suitability of the product for its particular purpose. The use of the product in certain processes may require third party consent.