

## Processing instructions

**ebalta** Sealer 02 is a sealer for all porous surfaces like epoxy-, polyurethane- or MDF-boards. By applying with a cloth, foam brush or by spraying high gloss surfaces can be achieved. Sealer 02 can be used as a mould primer for semi-permanent release agents. It works well to fresh up parts and to re-condition used moulds. If you apply one coat of Sealer 02 1 ltr. covers 20 - 25 m<sup>2</sup>.

### General Benefits and Advantages

- Higher solids content compared to standard sealers, thus you need less coats to achieve the same gloss
- Low-odour, no aromatic solvents
- Slight release properties, thus less layers of release agent are needed
- Thermal resistance higher than 200°C

### Application

Clean the mould with mould cleaner from oil, silicone, wax, dirt and dust with ebaclean T1-1.

Boards or blocks with a density below 1,0 g/cm<sup>3</sup>, e.g. **ebaboard** EP 138(epoxy) or **ebaboard** 0700 (PU):

Apply **ebalta** Sealer 02 on an area of 0,3 - 0,5 m<sup>2</sup> with a colourless, dry paper- or polypropylene cloth (e.g. "Kimberley Clark Wypall X60") to the dry and clean mould. Wait some minutes till the solvent has gone, then apply the next layer. Frequently re-wet the cloth to be sure a wet film covers the whole surface. Apply some 4 layers depending on the board material and the gloss you want to achieve. As soon as the board starts to get a glossy finish, wait 20 minutes before applying the next coat. In general now 4 more layers are applied what means 8 in total. Allow the dry film to cure for at least 2 hours at room temperature or for 20 minutes at 60°C before applying release agents.

### Spray Application:

2 – 2,5 bar, needle diameter not bigger than 1,2 mm.

Coat the whole surface to build up a close shiny film. Wait some minutes till the solvent evaporates, then apply the next layer 90° to the previous one. Epoxy boards or PU boards with a density below 1,0 g/cm<sup>3</sup> need 4-6 layers, before applying the last layer wait at least 20 minutes.

At room temperature the film should dry for at least 2 hours or at 60 °C for minimum 20 minutes, before you start applying the release agent. Longer drying time, for example over night or 40 minutes at 60°C, will improve film durability and performance.

Highest gloss you reach by subsequently sanding after every coat. Start with 240 grit to remove milling lines, then go to 320 after the first two layers of Sealer 02. After every layer use finer sanding paper and finish with 2000 grit. Then apply the final layer.

Don't wait too long before sanding Sealer 02, it becomes difficult to sand then.

As the material is sensitive to moisture, close container right after use.

As release agent we recommend **ebalta** Release Agent 17.

### Physical Properties

- Flash point < 21°C
- Specific gravity 0,78 g/cm<sup>3</sup>

## In General

**ebalta** Sealer 02 is available in 0,78 kg (1 ltr) units

## Storing

Do not store over 38°C. **ebalta** Sealer 02 reacts with moisture, containers need to be closed right after using. If the product is stored under cold conditions, always allow to heat up to room temperature before use. Do not use after expiry date.

## Safety measure

Please follow the precaution instructions of the Government Safety Organisation of the chemical industry when working with this material. Please follow safety advices !

## Waste Disposal

According to arrangement with local authorities cured material can be disposed as domestic or commercial waste. Non-cured products are waste which is subject to inspection and has to be disposed accordingly. In case of further questions please do not hesitate to contact our Department for Product Safety.

The instructions and recommendations are given in good faith and are based on long experience and careful tests. Since the conditions of use are beyond our control, and due to versatility of applications and working methods, we can't give any guarantee. All information are non-binding and are no guarantee for special characteristics or properties of the product. Despite information given from **ebalta** the customer has to make his own tests regarding applications and processing. If any special warranty is requested, written agreement on this subject is essential.