

ES930

# High gloss mold and tool sealer

**Trelleborg ES930 has been specifically formulated to seal all types of highly porous substrates,** especially our range of epoxy tooling boards. ES930 is a moisture cure system with a high solids content which allows a high gloss finish to be obtained.

## Features & Benefits

- High gloss
- Easy application
- Excellent sealing capability
- Quick cure
- Low odor
- No aromatic solvents

## Application

- ES930 can be applied by either a simple 'wipe-on' technique or by spraying
- It may be rubbed down or polished if required

## Product Sizes

ES930 high gloss mold and tool sealer is available in 1 liter cans or 250 ml tins.



## Storage

The sealer should be stored in a dry warehouse.

## Health & Safety

Eye protection, gloves and a face mask should be worn when working with Trelleborg ES930.

Please refer to the Trelleborg MSDS.

## TYPICAL PROPERTIES

Appearance	Low viscosity colourless liquid
Odor	Slight hydrocarbon presence
Flash Point	<21 °C
Specific Gravity	0.780 g / cm <sup>3</sup>
Solvents	Aliphatic hydrocarbons, dimethylethers, alcohols
Coverage	20 - 25 m <sup>2</sup> / liter
Shelf Life	6 months from date of manufacture

## Processing Guidelines

### Preparation

- Read the Material Safety Data Sheet before use
- ES930 sealer will react with moisture. Ensure the container is closed when not in use and immediately after use. Do not mix with other products or solvents
- ES930 must be applied in a dust free area with good ventilation
- The tool surface must be cleaned and dried to remove traces of dust, dirt, oils or release agent before applying ES930
- ES930 can be applied by wiping or spraying. A superior finish is achieved by wiping

### Application by Wiping

- ES930 is sensitive to moisture and it is important to use a dry, soft synthetic cloth such as Kimberley-Clark® Wypall® X60
- Fold the cloth so that a smooth, flat surface is always used on the mold surface
- Apply ES930 to the cloth and wipe on the mold surface to cover an area of approximately 0.5 m<sup>2</sup> each application. Vigorous rubbing or polishing is not required
- Continue applying to adjacent areas using a clean piece of cloth each time ensuring to minimize the overlap area with previously applied product
- Repeat the process until the mold is completely coated
- Allow the coated surface to dry for a minimum of 20 minutes at room temperature (21 °C) before applying a further coat
- Apply further coats as above until the mold is sealed and a high gloss surface is obtained. Please note that this can range up to a maximum of ~ 12 coats depending upon the porosity of the surface being sealed
- Please note that only 3 or 4 coats may be required to seal a composite tool
- After application of the final coat, allow the sealed mold to cure for at least 2 hours at room temperature before applying a release agent. The durability of the sealed surface can be improved by either extending the cure time or by using elevated temperature (e.g. 30 minutes at 50 °C)
- A release agent must be applied before using the mold or tool

### Application by Spraying

- The use of a high volume pressure spray gun is strongly recommended
- The spray gun should be set at 30 – 35 psi and should ideally use a fluid needle with a diameter of <1.2 mm
- Hold the gun nozzle ~ 200 mm from the mold surface and adjust the output so that the product forms a thin film without running or dripping
- Systematically coat the entire surface of the mold ensuring to minimize the amount of over-lap between sprayed areas
- Allow the product to dry before applying any additional coats
- Apply each subsequent coat at right angles to the previous coat
- Repeat the above process until the mold is sealed. Please note that this can range up to a maximum of ~ 12 coats depending upon the porosity of the surface being sealed
- After application of the final coat, allow the sealed mold to cure for at least 2 hours at room temperature before applying a release agent. The durability of the sealed surface can be improved by either extending the cure time or by using elevated temperature (e.g. 30 minutes at 50 °C)
- A release agent must be applied before using the mold or tool

### Contact Us

Trelleborg's Applied Technologies division is an industry expert in delivering innovative and reliable solutions that maximize performance for our customers. Our vast range of specialized, customizable materials ensure peace of mind at every stage of your project. With reliable and efficient project management and manufacturing we endeavor to take performance to new levels by achieving your goals safely, on time and within scope.

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