

BreeZ[®] MPP 2698W

Mold Prep and Primer

Description

BreeZ[®] MPP 2698W is formulated for sealing/priming tooling in both the FRP and advanced composites sectors. Appropriate substrates include, but are not exclusive to polyester, vinyl ester, epoxy, phenolic, bmi, urethanes and most metals.

General

BreeZ[®] MPP 2698W should be applied onto a clean mold surface. BreeZ[®] MPP 2698W is an excellent sealing material, but should not be used as a mold release agent. Use of this product without a release agent may result in severe damage to the mold. The primer may also work to re-surface a worn mold. The appropriate sealer or releasant should be applied on top of the product after it has been cured.

Mold Preparation

1. After the mold has been buffed and polished with rubbing and polishing compounds, wash the mold surface thoroughly with clean water. The proper water wash will remove all fillers and water-soluble contaminants from the buffing and polishing compounds. Use liberal amounts of water. Wipe dry with clean cotton cloths. If following with a water-based cleaner, there is no need to dry the mold surface.
2. Following the water wash, use a mold cleaner to remove all traces of contaminants such as waxes, silicones, oils, etc. Use liberal quantities of the mold cleaner in a well-ventilated area, according to the specific instructions on the Product Data Sheet. Wipe dry with clean cotton cloths until the mold is "squeaky clean" by thumb or hand rub test.
3. The wiping cloth should be changed regularly to ensure that a clean, absorbent surface of the wiping cloth is always presented to the mold surface. This procedure prevents recontamination of the mold by wiping cloths which carry contaminants lifted from the mold.

Application Instructions

1. Apply BreeZ[®] MPP 2698W by a wipe-on/leave-on technique. Use clean, soft cotton cloths. "Fill" the cloth with BreeZ[®] MPP 2698W, but product should not drip from the cloth. Wipe a light coat on to the mold surface. **As a guide to achieving a "light coat", when the film is applied to a VERTICAL mold surface, the wet film should shine, but there should be no runs or sags in it.** Apply the product to the whole mold as quickly as possible, ensuring complete coverage. Care should be taken on large structures to ensure that the overlap area is as small as possible and that the product on the area overlapped has not already cured – you should perform overlaps on the "wet edge". Generally, 2 or 3 coats are sufficient to seal/prime. Allow 30 minutes between each coat. After the final coat, allow a 1-2 hour cure at room temperature.

2. When the product has cured, apply the appropriate water-based mold sealer or topcoat. Please refer to the proper Product Data Sheet for application details and instructions.

Cure Test

Under the best conditions, BreeZ[®] MPP 2698W has been found to cure in as little as one hour. A simple test method for complete cure is: Apply one drop of water onto a flange area that has been coated with the product. Wait a few seconds then wipe off with a clean cloth. If there is no evidence of the drop on the tool surface, the product is completely cured.

Important

The recommended number of coats and cure times are a general guideline found to be sufficient in a broad spectrum of molding conditions. When molding products with extreme geometries or experiencing low-humidity conditions in the shop, the customer may find it necessary to extend the cure time between coats and increase the number of coats applied to the mold.

Storage

The container should be kept closed at all times when not in use to prevent contamination, evaporation and/or premature curing. Do not store at temperatures above 100°F/38°C. Although BreeZ[®] MPP 2698W is water-based, it is a flammable product. Keep away from heat, sparks, flames and combustion sources during storage and use. If stored in cold temperatures, allow to warm to room temperature before using.

Packaging

BreeZ[®] MPP 2698W is available in a variety of package sizes. Please contact Granudan ApS for details.

Safety Data

Safety Data Sheets are available for all products and should be consulted prior to use of the product.

While the technical information and suggestions for use contained herein are believed to be accurate and reliable, nothing stated in this bulletin is to be taken as a warranty either expressed or implied.