AT 2600 - ALPHATEK MOLD RELEASE

NANO-CERAMIC COATING

APPLICATION INSTRUCTIONS

1. PRODUCT DESCRIPTION

AT 2600 mold release coating significantly improves the effectiveness and efficiency of composites manufacturing. The simple to apply coating maximizes ROI by improving the efficiency and longevity of molds. Treated molds have faster cycle times due to easier release. More cycles are possible without cleaning or re-coating. No free silicones result in the elimination of contamination of molded components. The coating operates up to 1200^0F/648^0C making it effective for modern high temperature composite processes. It works with all common high temperature resin systems and all common industrial-molding technologies.

2. SURFACE PREPARATION

- Surfaces must be free from oils and other containments before starting the coating process.
- Air blow any dust from the surfaces to eliminate any surface contamination before coating.

3. APPLICATION

- As with any new material, always test application and finished properties on a low value test article or panel before working on valuable surfaces.
- Mix coating well before applying to ensure that no solids have settled to the bottom of the container. If in doubt, pour the contents into a new container just prior to application to ensure that no solids have settled.
- Coat the face side of the mold.
- Apply a modest amount of the coating on the surface or on a lint free pad or cloth.
- Use a circular motion to work the release coating into the surface of the mold tool.
- Once any absorption seems to stop, gently glide the wetted applicator over the surface to ensure that there is a complete coverage at 2-3 microns (dry film thickness) on the entire surface of the mold tool.
- Keep in mind that applying more (than 2-3 microns) coating does not result in better performance.
- Dry and cure per the instructions below.
- If a second coat is required, allow it to dry for a minimum of 20 minutes between applications.

7. DRYING & CURING TIMES

Solids	12%
Drying Time	Dry to the touch in approximately 15-25 minutes at ambient temperatures. Warmer airflow (not to exceed 110^0F/43^0C) will accelerate dry time.
Curing Time	Allow the coated surface to cross-link for 20 minutes or longer. At this point it is ready for lay-up of pre-preg or similar materials. Do not put parts in an oven to cure until film is dry to the touch and/or 20 minutes have passed since initial application. If the mold surface is green and needs to be sealed, apply 1st coat and oven cure at 350°F for 30 minutes. Allow mold to cool and then apply a 2nd coat per instructions above.

8. COVERAGE RATE

- Coverage will be approximately 1,630 square feet per gallon (40 square meters per liter) at dry film thickness of 3 microns.

9. STORAGE STABILITY & SHELF LIFE

The shelf life is one year when stored in the original, unopened container. Store containers in a well-ventilated and covered area away from extreme heat and moisture. Contact your ALPHATEK representative if you have any questions about the products or its uses.

10. SAFETY

Refer to the Safety Data Sheet for this product prior to use.