

# AT 2620 - ALPHATEK MOLD REPAIR

NANO-CERAMIC COATING

APPLICATION INSTRUCTIONS

## 1. PRODUCT DESCRIPTION

AT 2620 coating rejuvenates and repairs all types of industrial molds. AT 2620 permanently fills and seals pinholes and micro-cracks on the face side of almost any mold tool extending the useful life of industrial molds. Ultra-thin application means no change to the mold dimensions. AT 2620 significantly improves the ROI for any molding tool by extending the useful life of the mold and repairing molds that would otherwise be inoperable.

## 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. This also applies to area where bagging tape will be applied later.
- Let the coated surface ambient dry until dry to the touch. Warm airflow (not to exceed 110°F/43°C) will accelerate cure time.
- Follow curing instructions in section below.
- Allow the part to cool.
- Apply second coat per instructions above.
- Vacuum test and continue to apply coats until the tool holds a vacuum to specification.
- Once mold can hold a vacuum, apply 1-2 coats of **AT 2600** before use in order to maximize release properties.

## 7. DRYING & CURING TIMES

<b>Solids</b>	18%
<b>Drying Time</b>	Dry to the touch in approximately 15-25 minutes at ambient temperatures. Warmer airflow (not to exceed 110°F/43°C) will accelerate dry time.

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<b>Curing Time</b>	Allow the coated surface to cross-link for <b>minimum</b> of 12 hours at ambient temperatures. Then oven cure in a convection oven or autoclave at 350°F (176°C) for minimum of 30 minutes to cure the resins deep within the structure. Do <b>not</b> oven cure until mold tool has cured for a minimum of 12 hours at ambient temperatures. Full cure will be achieved in 5 days under ambient conditions.
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## 8. COVERAGE RATE

- Coverage will be approximately 2,450 square feet per gallon (60 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.