VeroMetal® MouldProtect 150
Technical Data

VeroMetal

Description: **VeroMetal® MouldProtect 150** consist of 99% metal powder, a proprietary hybrid polyester binder and hardener system.

Recommended use: **VeroMetal® MouldProtect 150** can be applied to nearly every surface.

Type of Product: 4 component Kit: Metal, Binder/Resin, Hardener, Cobalt.

Pack Size: 1 Kit **VeroMetal® MouldProtect 150** consists of:
Part A Binder
Part B Cobalt (1% from weight of binder)
Part C Hardener (2% from weight of binder)
Part D Metal
Mixing ratio Metal to Binder is 3:1

!ATTENTION!
Risk of reaction:
Do not bring Cobalt (B) and Hardener-MEKP (C) into direct contact.

Shelf Life: Part A, B, C: 3 months
Part D Metal: 12 months
Both under dry conditions at 20° Celsius.

Physical Constants:

Colour:	grey
Finish:	matt, satin polished, high polished
Weight % Non-Volatile:	65% ± 1
Theoretical spreading rate:	3 m²/kg - 100 micron
Flash point:	32°C 89°F
Dry to touch:	1 hour at 20°C/68°F
V.O.C:	260 g/litre
TG Glasstransformingtemp.:	145°C

APPLICATION DETAILS:

Application method: High Volume Low Pressure (HVLP),
Nozzle orifice: 1.1 to 1.6
Nozzle pressure: 1.1 to 1.5 bar/16 to 22 psi
(HVLP spray data is indicative and subject to adjustment)
Roller (solvent resistant foam)
Casting, Moulding

Cleaning of tools: Acetone

Indicated film thickness, dry: approx. 140 micron

Indicated film thickness, wet: approx. 160 micron

Safety: Handle with care. Before and during use, observe all safety labels on packaging and containers, consult VeroMetal Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.

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Surface Preparation:

For application on negative mould: Remove possible oil and grease etc. with suitable detergent. Remove any possible weak or flaking structure of old coating. Allow the surface to be completely dry before coating. Sand the surface with a course grit paper like 100 grit or less with a dual action sander.
For application directly on the plug (master model): no sanding necessary. Important: After using a release agent the surface must be wiped off with a dry, smooth cloth.

Risk of reaction: ***Do not bring Cobalt (B) and Hardener-MEKP (C) into direct contact.***

Application Conditions:

The surface must be completely clean and dry at the time of application and its temperature must be 5 points above the dew point to avoid condensation.

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Risk of reaction:
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1. Open Pack A (Binder)
2. Stir the Binder thoroughly
3. Open Pack B (Cobalt) and add into Pack A (Binder) (2% weight of binder weight) and stir slowly and thoroughly to make a smooth, even-textured mixture free of clumping.
4. Open Pack C (MEKP-Hardener) and add into mixture. (2% weight of binder). Stir slowly and thoroughly to make a smooth, even-textured mixture free of clumping.
5. Open Pack D (Metal) and add into mixture. Stir with a flat stirring stick for at least 30 seconds, making sure to reach the sides and bottom of the container.

Mixing ratio Metal to Binder is 3:1
Thorough mixing during both mixing steps is essential for even curing and spraying/rollering.
Once you added the Cobalt (Pack B) you have approximately a 60 minute pot life at 20 degrees C°.
Spraying is the best way to apply the product. But also casting/moulding or rollering is possible. When using spray application, use a 50% overlap with each pass of the gun to avoid dry areas, and pinholes. If necessary, cross spray at a right angle. Do not mix previously catalysed material with new. In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended down-time with acetone.

Curing:

The coated product needs at least 72 hours curing at minimum 20°Celsius and maximum 35°Celsius. Then building of the mould can be continued. For optimum curing a post curing at 70°C is recommended.

Remarks:

This product contains heavy particles. Stir well before use.
Please stir very well before application to get a homogenous mixture.