

**DESCRIPTION**

Variopox Sealer is a two component epoxy primer based on solvent free epoxy resins and polyamine adduct hardeners.

**PRINCIPAL CHARACTERISTICS**

- Specially developed as primer for models and plugs used for the production of polyester moulds;
- First coat in paint systems for models and plugs produced from polyurethane, epoxy or polyester tooling pastes;
- Low viscosity, reduces the absorption of porous surfaces;
- Improves the adhesion of subsequent epoxy- or polyurethane coatings;
- Good resistance to various chemicals;
- May be recoated with IJmopox ZF primer, IJmopox HB coating or Double Coat.

**COLOURS AND GLOSS**

Black - High gloss

**BASIC PROPERTIES (AT 23 °C AND 50% R.H.)**

Density	:	approx. 1,1 g/cm <sup>3</sup> (mixed product)
Solid content	:	approx. 100 % (volume)
Recommended d.f.t.	:	depending on application
Dust dry after	:	approx. 4 hours
Full cure after	:	approx. 2 days, see additional information
Recoating interval	:	min. 24 hours, see additional information max. unlimited, provided clean and dry
Shelf life	:	separate components, stored cool and dry in original packaging, minimum 6 months
Flash point (DIN53213)	:	base component >100 °C hardener 112 °C

**SPREADING RATE**

Depending on application : approx. 4,0 - 6,0 m<sup>2</sup>/kg (approx. 3,6 – 5,5 m<sup>2</sup>/l)  
The practical spreading rate depends on a number of variables, such as: shape and size of object to be painted, the condition and profile of the substrate, the method of application, climatologic conditions and skill of labour.

**SUBSTRATE CONDITION AND TEMPERATURE**

All surfaces : clean and dry, free from any contamination and loose particles, and sanded with grit paper P120 - 180;

During application and curing a minimum temperature of 15 °C is allowed. The temperature of the substrate should be minimum 3 °C above dew point.

**INSTRUCTIONS FOR USE**

Before use, mix base and hardener components thoroughly.

Mixing ratio : 67,0 base : 33,0 hardener (by weight)  
67,0 base : 33,0 hardener (by volume)

Do not prepare more material than can be applied within the pot life of the mixture.

Induction time : none at 20 °C  
 Pot life : 15 minutes at 25 °C  
 20 minutes at 20 °C  
 30 minutes at 15 °C

Application with:

	Brush/roller
Type thinner	n.a.
% of thinner	
Nozzle orifice	n.a.
Nozzle pressure	n.a.
Cleaning	Double Coat Degreaser

Do not add solvents or thinners to Variopox Sealer.

#### ADDITIONAL INFORMATION

- Recoating and curing Variopox Sealer:

	15 °C	20 °C	25 °C
Minimum, with IJmopox or Variopox, after sanding with grit paper P120	36 hours	24 hours	24 hours
Minimum, with Double Coat, after sanding with grit paper P180	3 days	2 days	2 days
Maximum, with IJmopox, Variopox or Double Coat, after sanding with grit paper P120-P180	unlimited	unlimited	unlimited
Fully cured after	4 days	2 days	2 days

- Application of Variopox Sealer  
 Variopox Sealer may be applied by brush or by roller. For roller application, a felt roller is recommended such as IJmopox Feltroller. When combined with IJmopox HB coating and Double Coat, one coat of Variopox Sealer is usually sufficient.
- Properties Variopox Sealer  
 Variopox Sealer reduces the absorption of porous surfaces and improves adhesion of subsequent coats of paint. Variopox Sealer eliminates the risk of surface defects and loss of gloss when a mould is made from the model or plug.

- Pot life  
Do not continue application when the pot life is about to end. As the reaction between base and hardener has progressed, a poor adhesion will be the result.
- Application of Variopox at lower temperatures:  
Curing at temperatures lower than 15 °C will result in a sticky layer on top of the cured resin. This will negatively affect adhesion of following coatings.

#### SAFETY INFORMATION

See the corresponding Material Safety Data Sheet for detailed instructions on safety, disposal and health.

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#### *Disclaimer*

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