

# COMPOTOOL CTS130 High Build Spray Sealer Technical Datasheet

The COMPOTOOL CTS130 High Build Spray Sealer is a two pack spray on application that fills blemishes or scratches on the surface of the tooling board giving it a smooth and faired surface for excellent surface finish. After application of the COMPOTOOL CTS130 High Build Spray Sealer the surface is coated with COMPOTOOL CTS202 sealing the micro-pores and gives a gloss finish to the COMPOTOOL surface.



## Key Features:

- High temperature resistance
- Durable surface
- Sands easily
- Non-contaminating

## Technical Information:

Properties	CTS130 High Build Spray Sealer Part A	CTH930 High Build Spray Sealer Hardener Part B	CTT931 Spraying Thinner
Appearance	Black liquid	Clear liquid	Clear liquid
Odour	Faint	Faint	Faint
Flash Point	31°C (87.8°F)	38°C (100°F)	31°C (87.8°F)
Solvents	Xylene	None	Xylene
Supply	4L	1L	2.5L
Mixing Ratio by Weight	100%	20%	30%
Estimated Coverage Mixed	3m <sup>2</sup> per litre (32 ft <sup>2</sup> per US Quart)		
Dry Film Thickness	Approximately 50 Micron per coat		
Shelf Life	12 Months		
Maximum Use Temperature	250°C (480°F)		

## Storage:

- Keep sealed when not in use
- Keep away from sources of ignition
- Store in a cool dry place and protected from frost

## Board Preparation:

1. The COMPOTOOL CTS130 High Build Spray Sealer must be applied to surfaces previously treated with a minimum of 10 coats of COMPOTOOL CTD003 Densifier. Be sure to follow the COMPOTOOL CTD003 Densifier Datasheet.
2. Apply one wipe on coat of COMPOTOOL CTS101 Sealer and follow the COMPOTOOL CTS101 Sealer Datasheet.
3. The surface of the COMPOTOOL board should be clean, dry and dust free. With a dry, oil-free air line gently dust off the surface being careful not to blow too many pits into the surface. Then wipe the surface with a wax and grease cleaning solvent to remove any contaminants. Allow the boards to completely dry before applying sealer.

## Mixing Ratios:

1. Thoroughly stir each component of the COMPOTOOL CTS130 Sealer separately prior to activation. Combine components and mix thoroughly.

Two Component System	Specific Gravity	Parts by Weight
CTS130 High Build Spray Sealer Part A	1.351	5 parts or 100%
CTH930 High Build Spray Sealer Hardener Part B	1.12	1 part or 20%

*Example i.e 1kg or 2.2lb of Part A with 200gr or 7.05oz of Part B by weight*

2. After mixing Part A and Part B together thoroughly, the COMPOTOOL CTS130 High Build Spray Sealer may be thinned with COMPOTOOL CTT931 Spraying Thinner. Suggested reducing by 30% for desired application and surface finish. Mix thoroughly and strain as you pour it into the spray gun.

Thinner	Specific Gravity	Parts by Weight
CTT931 Spraying Thinner	0.914	30% of total weight

## CTS130 High Build Spray Sealer Application:

1. Usual applications require three to four coats for best results. Additional coats may be applied to your satisfaction.
2. Prior to spraying on the COMPOTOOL CTS130 High Build Spray Sealer be sure to carefully inspect the mould for larger pits or blemishes. For any of these types of spots use a pencil brush and apply unthinned mixed COMPOTOOL CTS130 High Build Spray Sealer and gently fill the blemishes prior to spraying or post spraying.
3. Apply the thinned COMPOTOOL CTS130 High Build Spray Sealer to the surface of the COMPOTOOL block using a gravity feed or pressure pot spray gun. We recommend a 1.3mm (0.078 inches) nozzle set up and approximately 1.5 bar pressure (22psi).
4. Hold the nozzle of the gun approximately 200mm (8 inches) from the mould surface and adjust the output to form a wet film without running or dripping (especially on vertical surfaces). Coat the entire surface of the mould overlapping sprayed areas to ensure full coverage. Wait until the COMPOTOOL CTS130 High Build Spray Sealer is touch dry (approximately 15 to 20 minutes at 20°C (68°F) before applying the next coat.
5. Repeat Step 3 (typically 3 to 4 times). Some areas with small defects in the board will need more coats to ensure a flat surface.

6. After all coats are applied, allow the sealer to dry for 12 hours at 20°C (68°F) or 3 hours at 60°C (176°F) (allowing sufficient time for the board surface to reach temperature).
7. After the COMPOTool CTS130 High Build Spray Sealer has thoroughly dried lightly sand the surface with 320 or 400 grit until suitable smoothness is reached. Be careful not to distort the surface and take it out of tolerance. **DO NOT SAND THROUGH THE SEALER.** If you cannot remove the gloss without sanding through the sealer due to deep pitting use a pencil brush and apply unthinned mixed COMPOTool CTS130 High Build Spray Sealer and gently fill the blemishes, then lightly sand.
8. Please note if you have sanded through the COMPOTool CTS101 Sealer Densifier anywhere it could make demolding more difficult. Reapply COMPOTool CTS130 High Build Sealer over the sanded through areas.
9. After all surfaces are coated to your desired finish apply COMPOTool CTS202 Sealer. See COMPOTool CTS202 Sealer Technical Datasheet for application guidance.

## Notes

1. Application of COMPOTool products should be performed in a well-ventilated area. The COMPOTool board must be clean and dry before use.
2. COMPOTool CTS130 High Build Spray Sealer is sensitive to variations in application technique and thickness. It is important that the user carries out their own test and trials to determine how many coats are required for desired surface finish and application technique. Mould configuration, room temperature and humidity will influence the cure time from that detailed above.
3. COMPOTool CTS130 High Build Spray Sealer must be used in conjunction with COMPOTool CTS202 Sealer and COMPOTool CTS404 Release to seal the micro-pores and give a good release.

## Health and Safety:

### **FOR INDUSTRIAL OR PROFESSIONAL USE ONLY.**

**DO NOT HANDLE UNTIL PRECAUTIONS ON THE SAFETY DATASHEET HAS BEEN CAREFULLY READ AND UNDERSTOOD.**

**FOR ADDITIONAL ENVIRONMENTAL, HEALTH AND SAFETY INFORMATION REFER TO SAFETY DATASHEET.**

**BY ACCEPTING THE GOODS SUPPLIED BY COMPOTool SELLER AND BUYER AGREE TO THE FOLLOWING LIMITED WARRANTY AND REMEDIES LIMITATIONS:**

COMPOTool warrants that goods sold will be merchantable. If goods are defective, Buyer may return them at Buyer's cost to COMPOTool within 12 months of purchase for a full refund of the purchase price. Excluding CTS 202 Stage 2 Sealer. Other than this limited warranty, there are no express or implied warranties. There is no warranty as to fitness for a particular use. COMPOTool recommends that The Buyer shall take all recommended safety precautions while working with the goods. COMPOTool and Buyer agree that other than return of the purchase price COMPOTool will not be liable for any damages, consequential damages or incidental damages. When handling this product prolonged skin contact may lead to skin irritation and airborne dust can be released. It is recommended that suitable gloves, respiratory and eye protection equipment are used when handling. When sanding and machining use appropriate dust extraction and work in a well-ventilated area.

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