



Technical Data Sheet

BDT-2620 Mold, Tool & Press Sealer

A Permanent Nano-Ceramic Clear Sealer Coat

BDT-2620 Mold, Tool & Press Sealer contains no Free Silicones and is a VOC exempt product that seals the mold tool surface for easy cleaning and less maintenance & down time

BDT-2620 MT&P Sealer has High Temperature performance, is a single component thin film that ambient air cures

BDT-2620 creates a covalent bond to the substrate creating a permanent bond to the tool face BDT-2620 fills and seals pinholes and micro-cracks within the mold tools face, properly preparing it for the **BDT 2600 Release Coat Material** to be applied.

BDT-2620 creates no dimensional change to the mold tool as it is applied at 2-5 microns Dry Film Thickness as a easy Wipe-on application

BDT-2620 is an inert & benign material when cured which penetrates the substrate as opposed to lying on it

BDT-2620 Mold, Tool & Press Sealer Properties:

- Color _____ Clear
- Viscosity _____ 16-18 sec. #2 Zahn
- Percent of Solids _____ 18
- Odor (liquid) _____ Slight Solvent
- Odor (cured) _____ None
- V.O.C. _____ Exempt per CFR 51.1 / regulation 8 Compliant
- RoHS _____ Compliant
- REACH _____ Compliant
- Halogens _____ None
- Thermal Stability (cured) _____ 1600°F + (648.8°C)
- Conical Bond (1/8 inch mandrel) _____ Passed (ASTM D522-93a)
- Cross cut adhesion _____ 5B (ASTM D3359)
- Coefficient of Friction _____ 0.03μ (ASTM D2047)
- Specific Gravity _____ 0.889 (ASTM D891-09)
- Pencil Hardness _____ 8h (ASTM D3363)
- Average applied dry film thickness _____ 2 to 5 microns
- Estimated Coverage Rate (@ 3 microns) _____ 2,400 sq./ft. per gallon
- Transfer to surrounding material _____ Zero (0) transfer of contaminates
 - Dry to Touch (time @ambient) _____ 15 – 25 minutes* (average)

(*a warm airflow will reduce time required to reach "Dry to the Touch")

General Notes: Once mold tool is sealed, apply 1-2 coats of BDT-2600 nano-Ceramic Release Coat before putting into production service.