



TD Seal HT Application Notes

1. OPTIONAL but recommended: thoroughly mix container of TD Seal HT (using shaker, electric paint mixer, or paint stick according to container volume and convenience); draw 100 grams of the TD Seal HT material into a disposable cup and add 1.5 gm of MEKP 925H (or MEKP 9H) initiator; mix with paint stick or stirrer. Start a timer and note when mixture has notably thickened. This time will be the approximately pot life at your current environmental conditions.
2. Clean the machined tool surface to prepare for coating. Recommended machined surface finish is 125 micro-inches (RA 3.2 micro meters) or better. For sanding 320 grit or better is recommended. Surface should be cleaned with a substrate compatible solvent using a wipe-on, wipe-off with clean rag procedure followed by blowing off with dry, oil-free compressed air.
3. After thoroughly mixing (using shaker, drill, or paint stick according to volume being prepared) the TD Seal HT material and straining into HVLP spray cup add MEKP 925H (or MEKP 9H) initiator (1.5wt%) and stir in well with paint stick.
4. Use swab to fill visible surface porosity and wait 5 minutes prior to applying first full coat. If porosity does not fill in one application using a swab, then you will need to allow material in the pore to gel - pot life + 5 minutes (approximately 30 minutes) and reapply prior to first sprayed coat.
5. Spray tool surface with even coat approximately 0.003-0.004 inches thick (use mil gauge).
6. After 30 minutes to an hour inspect the tool surface for low areas, pinholes, or other flaws. Sand surface using a Dual Action (DA) sander with 500 grit paper to make the flaws visibly apparent. After noting locations of any surface flaws clean surface with dry oil-free air and a tack cloth.



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7. Retouch flaws using method described in step 4 above and allow 5 minutes to flash.
8. Apply final 0.002 to 0.004 inch thick coating to achieve a total coating thickness of 0.006 to 0.008 inch.
9. Wait an hour to flash/cure.
10. Inspect tool surface for entrapped dust or other debris, if present remove with a DA using 500 grit paper.
11. Post cure at 250F for 1 hour.
12. If you want to buff the tool to a higher finish or if there were flaws removed in step 10 above, sand post-cured surface in the following sequence: 500, 800, 1500, and 2000 grit before buffing using rubbing compound equivalent to 3M 36060, followed by 3M 06064 and finally 3M 06068. It's possible to start buffing after 800 grit, with an increase in rubbing compound consumption. If you have buffed the tool surface, wash with any substrate compatible general-purpose surfactant and solvent.
13. Seal and release surface just like any other composite tool at any time after cooling to room temperature following post-cure in accordance with sealer recommended procedure.

We recommend using breaker tape under very aggressive tacky tape. The yellow tape from general sealants doesn't require it but the ITW gray tape does. We also recommend using breaker tape under thermocouples.