

## 1099 Room Temperature Epoxy Surface Coat



**Overview:** #1099 is a white, thickened epoxy material used to create a durable surface coat on room temperature epoxy molds. This surface coat on can be brushed on as thick as 1/8" at a time without developing runs or sags.

It is specially formulated to provide strong inter-laminar bond ability also makes later mold surface repairs easy and durable. Properly applied and cured, #1099 resists chipping and cracking and tends to retain a high gloss after repeated parts are pulled.

Available in quart resin/hardener kits or cases of 6 quart resin/hardener kits.

### Features & Benefits:

- #1099 is a versatile material, and will perform well in a variety of room temperature applications.
- It is often chosen for broad, flat tooling surfaces, where it can be applied fast.
- #1099 produces excellent reproduction of very fine detailed surfaces.
- #1099 has been formulated to provide good bonds to subsequently applied layers of epoxy. This feature provides good intercoat bonds, even if the previous layer of #1099 has cured completely hard. This elimination of surface coat adhesion failures is accomplished with no sacrifice in properties

### Typical Cure Schedule:

	#1099
Mix Ratio	100:11
Pot Life	20-25 Min
Cure Time at 77°F To Sand	16-18 Hrs
Cure Time at 77°F Full Cure	18-24 Hrs

#1099 will cure completely at room temperature.

### Typical Product Properties:

	#1099 (A Side)	#1099 (B Side)	Test Method
Color	White	Amber	Visual
Viscosity	Lt. Paste	300cps	ASTM D2393
Specific Gravity	1.52	1.08	ASTM D1475

### Typical Mechanical Properties:

	Test Results	Test Methods
Hardness. Shore D	90 D	ASTM D2240
Tensile Strength	5,500 PSI	ASTM D638
Compressive Strength	12,000 PSI	ASTM D695
Flexural Strength	5,900 PSI	ASTM D790

**Mixing Directions:** Mixing is easy! Using clean plastic or paper containers, measure out 100 parts of side A and 11 parts of side B by weight. Mix thoroughly for at least one minute or until a uniform color and consistency is achieved. Make sure to scrape the edges and the bottom of the container to avoid leaving unmixed material which can lead to soft spots in the cured surface coat.

**Safety and Handling:** #1099 Epoxy Surface Coat contains ingredients which could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating, drinking, or using toilet facilities. Individuals should observe conditions of good industrial hygiene and safe working practice. For more detailed instructions on handling, please see the MSDS sheet.

All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions and away from open flames and high temperatures. For more detailed instructions on storage, please see the MSDS sheet.