

CHILL EPOXY™

P-TEC 8400™ INSTRUCTIONS



P-TEC 8400™ is a 100% solid, thixotropic and low density polyurethane repair paste for the repairing of wood. This product is used for fast repairing of CNC machined molds or prototypes made out from polyurethane boards or wood which show fissures, voids or any defects to the surface. The P-TEC 8400™ can also be of good help to repair damaged edges and design modification. This product can also be used as an adhesive to structurally assemble polyurethane boards and wooden panels among others.

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CHARACTERISTICS

Easy mixing ratio of 1A/1B volume
No shrinkage
No odor
Fast and easy sanding process

Fast setting time of 12 minutes at 22°C.
Excellent thermal and dimensional stabilities
Compatible with many surface coatings
Excellent adhesive for many substrate

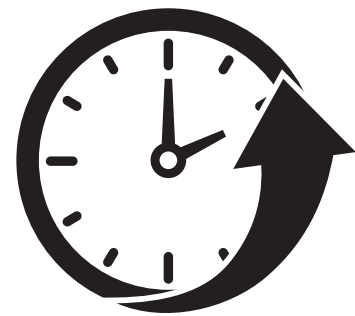
Both parts must be thoroughly mixed according to the mixing ratio indicated on this technical data sheet. Before use, check that the support is free of any dust, grease or pollution. During processing, pot life and time before sanding may vary depending on the ambient temperature.

The exothermic that will develop during hardening varies with the thickness of product applied, up to a maximal value of 79°C (174°F)

Advice: Test is necessary when using painting in order to verify compatibility between the putty and the primer. A polyester base primer is recommended.

Please consult POLYMERES TECHNOLOGIES for more details based on your application.

AVAILABLE COLORS




Ready to sand in
12 minutes


250gr kit

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METHOD OF APPLICATION

1. The mix ratio is 1/1 in both by volume and by weight, please take exactly the same amount of both the polyol and isocyanate..
i.e. : 50 millilitres of polyol and 50 millilitres of isocyanate.
 2. Mix both parts thoroughly to obtain a uniform color.
 3. Once the two parts are thoroughly mixed together, you have 4 minutes to apply the product at 720F (220C). If room temperature is higher than the suggested temperature, than your pot life will decrease which will give you less time for sanding. If your working climate is colder than the suggested temperature, this will prolong both your pot life and the polymerisation of the product.
-  **IMPORTANT** : do not prepare more product than necessary for usage.
4. Assure the complete absorption of the P-TEC 8400™ within the fissures, microfissures, knots and all defects on the surface of solid wooden panels and components with the use of a spatula in providing sufficient pressure.
 5. For optimum results, before sanding, allow the product to dry for 12 to 15 minutes at 72F (22C). To accelerate the polymerisation, you can activate the chemical reaction by heating the P-TEC 8400™ with a heat gun. Place heat gun 6 inches in height over the product for approximately 45 to 60 seconds. Let the product cool down for 60 seconds before usage.
 6. Use a 120 sandpaper to begin with to erase the rings around the cracks and finish up with the 150 sandpaper. Sand the panel or component all over the area and avoid putting pressure on the P-TEC 8400™. The sanding operation is vital and must be done in the most meticulous and efficient way to obtain the best desired results.
 7. Apply the dye as indicated on the technical data recommended by the manufacturer.

 **IMPORTANT** : For best results, select the color of P-TEC 8400™ best suited to your wood and dye coloring. i.e. : The beige color is often used with essences of light colored wood and the brown color is often used with essences of dark colored wood Please make sure to properly seal the cap of the product to eliminate contamination due to humidity.

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WARNINGS: Avoid skin and eye contact. In case of eye contact, wash thoroughly with water and consult a doctor. In the event of skin contact, wash thoroughly with soap and water. Keep out of the reach of children.

WARRANTY: Our recommendations are only given as a guide. Having no control on the use and applications of this product, the manufacturer cannot guarantee the results achieved. The warranty is therefore limited to the replacement of a product whose user can demonstrate that it is in fact defective.