



# Factor II, Incorporated

Inventing and Innovating...

(Information: 1.928.537.8387)

ONLINE ORDERING [www.factor2.com](http://www.factor2.com)

## PRODUCT INFORMATION

### MM-100

### EPOXY SURFACE COAT

MM-100 is an excellent, general purpose, white epoxy system engineered primarily for use as a surface coat for plastic faced gypsum molds and epoxy laminates. The Epoxy Surface Coat is noted for its ease of application and its ability to hang on vertical surfaces without sag or runoff.

The versatility of this room temperature cure system provides a wide range of applications with heat resistance properties up to 200°F. For longer mold life and multiple castings recommended temperature is 175°F.

#### TYPICAL PROPERTIES AS SUPPLIED:

Color mixed

Part A .....White

Part B .....Amber

Complete Cure Max. Properties .....24 hours

Hardness (Shore D) @ 75°F.....90

Viscosity, Mixed

(cps) @ 77°F(25°C).....70,000

Mixing Ratio .....10:8 By weight

Cure Time @ 75°F.....8-12 hours

Pot Life @ room temp.....15-20 min

#### PRODUCT SUGGESTIONS AND DIRECTIONS:

1. Properly prepare model or pattern surface by spraying a light coat of epoxy parafilm.
2. After mixing 100 parts A to 8 parts B by weight, this creamy white epoxy can be easily spread to an even consistency approximately 1/8" thick, taking care not to entrap air.
3. Allowing the 1<sup>st</sup>. coat to set approximately 15 minutes (when surface coat reaches a tack free stage resin will not stick to your finger when touched) a second coat of catalyzed epoxy is spread onto the 1<sup>st</sup>. to an even consistency also approximately 1/8" thick.
4. A Mix of high quality dental stone is poured directly onto the 2<sup>nd</sup> layer of wet surface coat. This gypsum will bond to the epoxy creating an epoxy faced gypsum mold.

*Note: When using a gypsum backed mold, we do not recommend temperatures over 175°F.*

#### To create a more permanent mold:

Instead of using a high quality dental stone, cast MM-163, a rigid polyurethane elastomer onto the second coat of MM-100 surface coat. This will create a longer lasting more durable mold.

The viscosity of MM-163 is so low, a mold will have to be protected by walls, or a dam will have to be constructed around the casting) or a filler of silica flour (or something similar) can be used to raise the viscosity.

**NOTE:** Epoxy, polyurethane or almost any rigid mold making material can be applied to the tacky layer of MM-100 to fabricate a mold faced with white epoxy surface coat. A-505 Epoxy Parfilm is an excellent release for MM-100 Epoxy Surface Coat.



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## **SAFETY PRECAUTIONS:**

Use in a well-ventilated area. Avoid contact with skin using protective gloves and protective clothing. Repeated or prolonged contact on the skin may cause an allergic reaction. Eye protection is extremely important. Always use approved safety glasses or goggles when handling this product. *Refer to Material Safety Data Information before using this product.*

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