

Vinyl Ester Hi-Gloss

Clear 67X6

VINYL ESTER



Product Uses

- High HDT Tooling Environment
- Closed Mold Tooling
- Corrosion Application
- Swimming Pool/Slide Resurfacing*
- Architectural Wood
- Tooling Board Sealer (Thin Film)

Product Features

- **HIGH HEAT DISTORTION**
- Corrosion Resistant
- Rapid Cure / High Gloss Finish
- Low VOC Product
- Great UV Resistance
- High Heat distortion
- Good thin film Cure

Application Suggestions



Mix contents of can thoroughly



Optimum Temperature of 77°F (25°C) and above 60°F (16°C)



Catalyze 2% w/ MEKP initiator (20 cc/quart [20cc/L]) Mix well



Utilization of HVLP spray gun optimizes finish



Tip size 1.7-2.5 mm



Air pressure 25-40 PSI (175-275 kPa)



Allow full cure (24 hrs) prior to sand and polish

Start with flash coat of 2 MILS (50μ). Wait 2 min then start build coats of 4 MILS (100μ) per pass, up to optimum 24 MILS

Properties | @ 77°F (25°C)

Gel Time	16-20 min @ 77°F (25°C)
Viscosity	1200 cps w/ Brookfield RVT #4 spindle @ 50 rpm
Coverage (20 MILS [500μ])	80 sf/gal
Thix Index	5.22
Weight Per Gal	8.7 lbs (3.95 kg)
Flash Point	98°F (36°C)
VOC	1.74 lbs/gal
Monomer Content	20%
Shelf Life	3 Months @ 68°F (20°C)
Dust Free Time	30 min @ 77°F (25°C)
HDT	375°F (190°C)

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*Contact the manufacturer for suggestions and limitations

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