



The Repro Surface Coat and Laminating Resin System is a Freeman exclusive which can be used to quickly produce close tolerance, lightweight tools and molds.

■ INSTRUCTIONS FOR USE

MATERIALS NEEDED

- Repro Surface Coat A & B components
- Repro Laminating Resin A & B components
- 1/4" Fiberglass Strand
- Freeman Wax Release & Partall #10 Mold Release
- Jiffy, Plunge, or Red Devil Mixer
- Acetone or Alcohol Solvent
- Plastic or Lined Paper Mixing Containers
- Mixing Paddles or Tongue Depressors
- Vinyl, Latex, or Nitrile Gloves
- Clean Cotton Cloth
- Disposable Pure Bristle Brushes
- Freeman 302 Urethane Protectant

PREPARATION

- If Repro is to be separated from the surface that it is poured against, follow proper sealing and release procedures to prevent the Repro from bonding to the surface.
- Procedures for releasing Repro from metal, wood, plastic, wax, and plaster are available from Customer Service at 800-321-8511 or our website www.freemansupply.com.

MIXING AND POURING

- Gloves **MUST** be worn when working with Repro (read Warning Information).
- Fillers will settle and may be hard packed. Fillers should be mixed thoroughly with a plunge mixer or paint shaker. Using an appropriate mixer, **THOROUGHLY** mix Parts A and B in their original containers. When using a drill driven mixer, it is preferable to use separate mixers for the A and B components. A single mixer may be used, but it essential to completely clean it with solvent before mixing the other component to avoid contamination.
- By weight or volume, mix equal amounts of Part A and Part B of the Repro Surface Coat to cover the desired tool surface.
- Apply the mixed Repro Surface Coat to the mold surface using a throwaway brush. Be sure to brush the material into sharp corners and areas of detail first, because the material will gradually thicken during the pot time.
- Allow the Repro Surface Coat to reach a "tack-free" state, approximately 20-25 minutes. Upon reaching a tack-free state, apply a second coat of Repro Surface Coat.
- After the second coat has reached a tack-free state, mix an appropriate amount of Repro Laminating Resin using a 1:1 mix ratio by weight or volume. You will need approximately four times the volume of Laminating Resin than the amount of Surface Coat that was used for the first two layers.

Instructions continued

- Apply a thin layer of the mixed Repro Laminating Resin over the tack-free second layer of Surface Coat using a throwaway brush.
- Quickly mix the 1/4" fiberglass strand into the remaining Repro Laminating Resin until you achieve a paste-like consistency. A good starting point is 100 parts mixed resin to 15-20 parts fiberglass strand by weight.
- Apply this paste mixture with a spatula or gloved-hand directly over the wet layer of Repro Laminating Resin. Attempt to create a consistent thickness of 1/8" to 1/4". Moderate pressure should be used to prevent air voids between the fiberglass paste mixture and the surface coat. Ensure that the paste mixture conforms well to corners to increase tool strength.

■ POT LIFE

Repro Surface Coat - 13 minutes

Repro Laminating Resin - 15 minutes

Demold Time for Completed Tool - 3 to 4 hours

■ WARNINGS

FOR INDUSTRIAL USE ONLY.

KEEP OUT OF REACH OF CHILDREN.

A-Side contains POLYOL. B-Side contains ISOCYANATE.

Combustible liquid. Irritating to eyes, skin and respiratory tract.

PRECAUTIONS: Keep away from heat, sparks and open flame. Avoid contact with eyes, skin and clothing. Avoid breathing vapors. Wear suitable protective clothing, gloves and eye/face protection. Keep container closed.

FIRST AID: If splashed in eyes, flush with water for at least 15 minutes and get medical attention. Wash skin with soap and plenty of water. If inhaled, remove victim to fresh air. If swallowed, do not induce vomiting. Call physician immediately.

IN CASE OF FIRE: Extinguish with dry chemical, carbon dioxide, foam, or water spray.

See Safety Data Sheet.

Emergency 24-hour number: (800) 424-9300

MOISTURE SENSITIVITY

IMPORTANT: Because all urethanes are sensitive to moisture, the user must keep Repro container lids closed when not in use. Repeated opening and closing of the container may introduce moisture and negatively affect performance of the product. We recommend that Freeman 302 Urethane Protectant be sprayed into the opened A and B container before resealing the unused material.

IMPORTANT NOTICE TO PURCHASER

Seller and manufacturer's only obligation shall be to replace such quantity of the product proved defective, and shall not be liable for any injury, loss, damage, directly or consequentially arising from the use or inability to use product. Users shall determine suitability of the product for intended use and assumes all risk and liabilities whatsoever in connection therewith. The foregoing may not be altered except by the seller's and manufacturer's officers signed agreement.