



PT1554 Aluminum Filled High Temperature Surface Coat

DESCRIPTION

PT1554 is a smooth viscosity aluminum filled epoxy tooling surface coat intended for intermediate high temperature service in a variety of applications. It provides excellent performance in the most demanding industrial applications. It is particularly well suited for tooling that is used in frequent cycling high temperature exposure, where it resists cracking and surface crazing that can be caused by this type of temperature fluctuation.

PT1554 resin and hardener mix together very easily, forming a lower viscosity thixotropic material that spreads well and covers corners and projections on the surface nicely. Because of its very creamy, moderately low viscosity, PT1554 works well in applications where fine detail must be duplicated.

PT1554 is an ideal general purpose heat resistant tooling surface coat for uses such as vacuum form tools, blow molds, press dies, low production bonding tools and any other application where stability and high performance up to 325°F is required.

PRODUCT SPECIFICATIONS

	PT1554 Part A	PT1554 Part B	ASTM Method
Color	Gray	Amber	Visual
Viscosity,	304,000 cps	1,100 cps	D2392
Specific Gravity, gms./cc	1.48	1.07	D1475
Mix Ratio	100 : 12 By Weight		PTM&W
Pot Life, 4 fl.oz. Mass @ 77°F	25 - 30 minutes		D2471

HANDLING and CURING

PT1554 A/B will gel hard at normal ambient temperatures. For elevated temperature service, the surface coat should be allowed to gel at room temperature, and then oven post cured according to the schedule required by the laminating system being used.

PACKAGING WEIGHTS

	Gallon Kit	Pail Kit
PT1554 Part A	10 lb.	50 lb.
PT1554 Part B	1.2 lb.	6 lb.
Kit	11.2 lb.	56 lb.

TYPICAL MECHANICAL PROPERTIES

		PT1554 A/B	ASTM Method
Mix Ratio,	By Weight	100 : 12	PTM&W
Color		Gray	Visual
Mixed Viscosity, centipoise		106,000 cps	D2393
Pot Life, 4 fl. Oz. Mass, @77°F		25 - 30 minutes	D2471
Cured Hardness, Shore D		90 Shore D	D2240
Shrinkage, inch/inch, Mold Number 0, Volume: .017 Gallon		0.0042	D2566
Specific Gravity, grams, cc		1.42	D1475
Density,	lb./cu. Inch lb. / gallon	.0514 11.9	D792
Specific Volume, cu. in./lb.		19.5	
Tensile Strength, psi		9,850 psi	D638
Elongation at Break, %		2.54 %	
Tensile modulus, psi		649,120 psi	
Flexural Strength, psi		19,828 psi	D790
Flexural Modulus, psi		712,343 psi	
Compressive Strength, psi		16,110 psi	D695
Glass Transition Temperature, DMA: T _g (Peak)		260°F	D4065
Coefficient of Thermal Expansion, Range 50°C to 100°C		3.26 x 10 ⁻⁵ in./in./ °F	D696

SAFETY and HANDLING

PTM&W epoxy products are made from raw materials carefully chosen to minimize or even eliminate toxic chemicals, and therefore offer the user high performance products with minimum hazard potential when properly used. Generally, the PTM&W epoxy resins and hardeners will present no handling problems if users exercise care to protect the skin and eyes, and if good ventilation is provided in the work areas. However, breathing of mist or vapors may cause allergenic respiratory reaction, especially in highly sensitive individuals. As such, avoid contact with eyes and skin, and avoid breathing vapors. Wear protective rubber apron, clothing, nitrile rubber gloves, face shield or other items as required to prevent contact with the skin. In case of skin contact, immediately wash with soap and water, followed by a rinse of the area with vinegar, and then a further wash with soap and water. The vinegar will neutralize the hardener and lessen the chances of long term effects. Use goggles, a face shield, safety glasses or other items as required to prevent contact with the eyes. If material gets into the eyes, immediately flush with water for at least 15 minutes and call a physician. Generally, keep the work area as uncluttered and clean as possible, and clean up any minor spills immediately to prevent accidental skin contact at a later time. Keep tools clean and properly stored. Dispose of trash and empty containers properly. Do not use any of these types of products until Material Safety Data Sheets have been read and understood.

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