



DUNAPOX™ BLUE SEA 125

Rev. N°2 - Date 2016/07/25

Description

Two-component epoxy system	
Sealer/Primer	
Designed to work at high temperatures	
Hardening at room temperature	Medium/Slow
Hardening in oven	Medium
Viscosity:	Gel
Sandable	
100% Reactive	

Typical Uses

Sealing and priming of tooling/modeling boards. Primed surfaces can be sanded to obtain desired surface finishing.

Suggested Materials

BLUE CORINTHO® boards
CORAFOAM® boards
Epoxy boards

Typical characteristics - Resin

Component			Resin
Name			DUNAPOX™ BLUE SEA 125
Density (25°C/77°F)	ASTM D891	lb/ft ³ (g/ml)	102.4-104.3 (1,64-1,67)
Viscosity (25°C/77°F)	ASTM D2196	P (mPa s)	520-620 (52.000-62.000)
Storage temperature		°F (°C)	50-95 (10-35)
Shelf Life		Months	12
Appearance			Blue Gel

Typical characteristics - Hardener

Component			Hardener
Name			DUNAPOX™ H 156
Density (25°C/77°F)	ASTM D891	lb/ft ³ (g/ml)	62.4-63.7 (1,00-1,02)
Viscosity (25°C/77°F)	ASTM D2196	P (mPa s)	0.6-0.9 (60-90)
Storage temperature		°F (°C)	50-95 (10-35)
Shelf Life		Months	12
Appearance			Brown

Mixing Ratio

Mixing ratio by weight RES/HAR	parts	100/18
--------------------------------	-------	--------

Characteristics of the system

Colour			Blue
Density (25°C/77°F)		lb/ft ³ (g/ml)	96.1-98.6 (1,54-1,58)
Minimum application temperature		°F (°C)	+50 (+10)
Gel time (25°C/77°F)	film	h min' sec"	4h-5h
Gel time (60°C/140°F)	film	h min' sec"	45'-60'



DUNAPOX™ BLUE SEA 125

Rev. N°2 - Date 2016/07/25

Handling time (25°C/77°F)	h min' sec''	12h-15h
Complete hardening	days	10-15
Suggested thickness	In (mm)	0.007 (0.2)
Coverage rate	lb/ft ² (g/m ²)	0.061 (300) when diluted with 10% acetone
Operating temperature	°F (°C)	Max. +400 (+205)

Mixing

Strictly observe the mixing ratio; any variation may seriously compromise the characteristics of the final product. Avoid excessive turbulence during mixing, with consequent undesirable inclusions of air.

It is possible to mix/distribute by hand with a spatula, trowel, notched trowel, brush, roller or spray.

When spraying the product, we recommend to dilute RESIN + HARDENER mixture with acetone to reduce viscosity. Adding 10 parts by weight of acetone to 100 parts of mixture makes the system easily sprayable with most equipment.

Storage

Wherever possible apply products in ventilated areas, wearing gloves, protective eyewear, barrier creams and suitable protective clothes. Avoid contact with unhardened materials.

In case of accidental contact with the skin, wash yourself with lukewarm water and soap for at least 10 minutes. Do not wash affected areas with solvents as this may increase contamination.

Lifetime of products is referred to materials stored in sealed containers in dry rooms, at recommended temperatures and protected from direct sunlight.

Expiry is printed on packaging

Moisture and/or storage in humid conditions may affect the characteristics of the components.

Remarks

For usage information, personal protective equipment, transport, storage and disposal of waste it is essential to refer to the Material Safety Data Sheets.

Values shown are determined from laboratory tests and obtained under controlled conditions; they outline typical characteristics and they do not constitute anyhow a sales specification; they are based on DUNA-USA Inc.'s current knowledge and experience of the products when properly stored, handled and applied in accordance with our recommendations.

This technical Data Sheet cancels and replaces any other previous issue.

DUNA-USA Inc. does not accept any responsibility for incorrect use of its products as it cannot ensure the correct methods of application have been followed; we therefore specifically disclaim any liability for consequential or incidental damages of any kind, including lost profits.

DUNA-USA Inc reserves the right to change the data in this information sheet without any prior notice.