CRESTAMOULD®
Matched Tooling Systems

Technical Data Sheet

Crestamould® B21 Sealer

Polyester-based sealing compound for polystyrene foam surfaces

Product Overview

Crestamould® B21 Sealer is a brushable sealing laminating resin for polystyrene foam surfaces. When used in conjunction with a CSM, this sealer provides a synergistic styrene resistant barrier between the polystyrene plug and styrenated tooling pastes. It has good adhesion to tooling pastes such as Crestamould T29.

Crestamould® B21 sealer's low styrene content significantly reduces the polystyrene surface erosion as seen with traditional styrene-containing resins. The sealer compound can be used to laminate CSM to provide a more structurally stable foundation for mould production.

General Liquid Properties

Colour	Creamy white/light grey
Density	1.28 - 1.35 g/cm^3
Consistency	Liquid
Viscosity (6.0)[1]	1900 - 2400 mPas
Viscosity (0.6)[2]	7500 - 9500 mPas
Gel time[3]	15 - 20 minutes
Shelf Life[4]	6 Months

Application

Crestamould B21 sealer is suitable for use on a vast range of polystyrene grades but we recommend testing on your chosen grade before use, to ensure that it is suitable for your application.

If separation has occurred, redisperse by thoroughly mixing the material until homogeneous. Ensure the polystyrene surface is clean before application.

Apply by brush. A resin to glass ratio of 3:1 should be used and no more than 2 layers of 450g CSM at a time to reduce the exotherm and risk of degrading the polystyrene plug. It is important to avoid excess accumulation (>3mm thickness) of material on the substrate surface. Allow 1.5-2 hours between the application of the sealer resin and subsequent lamination. These general properties are based on an ambient temperature of 24°C.

Packaging

Crestamould B21 Sealer is supplied in 25kg (55lb) pails and 5kg (11lb) tins.

Mixing

Before using thoroughly mix contents. DO NOT REMOVE ANY CRESTAMOULD B21 FROM CONTAINER BEFORE MIXING.

Storage

Crestamould® B21 Sealer should be stored between 5°C - 25°C (41°F - 77°F) in the original, unopened container in a dry, well ventilated place. Protect from freezing and direct sunlight. Avoid contact with oxidising agents. If stored outside of the recommended storage conditions shelf life will be significantly reduced.

Notes

1. RV1 Cone and Plate @6.0s^{-1} (25°C/77°F)
2. RV1 Cone and Plate @0.6s^{-1} (25°C/77°F)
3. Gel time measured with 100g mass with 2% MEKP catalyst
4. Shelf life is defined from date of manufacture when stored as recommended

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