



USERS GUIDE FOR APPLICATION OF ZYVAX 100% NON-VOC, WATERBASED **BREEZ SEALER BN201**

DESCRIPTION

SEALER BN201 is a **NON-VOC** high modulus, clear, flexible film with superior substrate adhesion that forms a protective shield on the mould or tool surface. As a conditioner, **SEALER BN201** is designed to treat both the chemical and physical bonding sites found on every “raw” mould surface. In addition, **SEALER BN201** provides the base needed to extend the life of the release coating and will allow optimal performance from the release coating.

Why BreeZ?

In comparison with other existing waterbased sealers the BreeZ Sealer BN201 is unique and exceptional with a curing time of only 15 minutes between coats at room temperature (20 C° / 50% RH); However we recommend a short post-curing at higher temperature after final coat. The BreeZ release system is based on a new, stronger waterbased polymer specified and tested for production of blades to the Windpower Industry Worldwide. Both Sealer and release has same working- & application-procedures – only difference is an immediate wiping-off of the Sealer (no waiting needed). **As always, mentioned curingtimes are minimum times, and should be adjusted to Environment (high humidity(+55% RH) = less evaporation of water = longer curing).**

USES:

- **SEALER BN201** overcomes micro-porosity in mould surfaces.
- **SEALER BN201** eliminates the break-in time for new moulds and/or tools.
- **SEALER BN201** restores a uniform surface when used over a mould repair or patch.
- **SEALER BN201** protects the surface of the mould from styrene emission and abrasion, therefore extending the useful life of the mould.

Mould type:

Metal moulds

Polyester, gelcoat, epoxy, aluminium

Epoxy tooling block, Bondo, oxidized gelcoat mould

“Green” or patched moulds (after proper curing-24 hours minimum)

Number of coats of Sealer BN201:

4

4

8 or more

6

HOW TO USE

1. Apply **SEALER BN201** to a small area of the mold using a Bounty® paper towel, clean lint free cloth or wet mop.
2. While still wet, gently wipe dry using a separate clean Bounty® paper towel, lint free cloth or dry mop.
3. Make sure entire mould surface is coated in this manner, slightly over-lapping the last coated area if you are applying in sections. Be certain that all contours are adequately coated.
Allow a minimum of 15 minutes cure time before application of the next coat.
4. Apply a second coat of **SEALER BN201** in the same way, and wait for a minimum of 15 minutes.
5. Study chart above and apply appropriate number of coats.
6. After the final coat, **CURING** at elevating temperature is required. (15min. at 100 C. / 1H at 70 C. / 4H at 50C./ 24H)