



## TD Sand Application Notes

Thoroughly review TD Sand Safety Data Sheet and Technical Data Sheet before use.

1. Thoroughly mix container of TD Sand (using electric paint mixer, or paint stick according to container volume and convenience); draw 100 grams of the TD Sand material into a disposable cup and add 1.5 gm of MEKP 925H (or MEKP 9H) initiator; mix with paint stick or stirrer. Start a timer and note when mixture has notably thickened. This time will be the approximately pot life at your current environmental conditions.
2. For sanding, 180 to knock down any imperfections
3. Clean the tool surface to prepare for coating. Surface should be cleaned with a substrate compatible solvent using a wipe-on, wipe-off with clean rag procedure followed by blowing off with dry, oil-free compressed air and optionally can be brushed.
4. Spray tool surface with even coat approximately 0.005 inches thick (use mil gauge) per pass until 10 mils is achieved
5. Let gel for 15 minutes.
6. Spray tool surface with even coat approximately 0.005 inches thick (use mil gauge) per pass until 10 mils is achieved
7. Let gel for 15 minutes.
8. Spray tool surface with even coat approximately 0.005 inches thick (use mil gauge) per pass until 10 mils is achieved. Total thickness should be 30 mils
9. Wait two hours to flash/cure.
10. Sand with a DA, or block, using 180 grit paper.
11. Once surface is even, sand with 320 grit paper to remove 180 scratches, moving to 500 grit to remove 320 scratches.
12. Clean with compatible solvent and wipe with tack cloth.
13. Final Finishing:
  - a. Spray Urethane Clear – TD Sand should be sealed with chosen painting system sealer before applying urethane. Follow manufacturer's instructions for mixing and applying clear coat.
    - i. TD Seal HT can also be used as the final coat
  - b. TD Sand can be buffed to a higher finish. First sand the post-cured surface in the following sequence: 500, 800, 1500, and 2000 grit before buffing using rubbing compound equivalent to 3M 36060, followed by 3M 06064 and finally 3M 06068.



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If you have buffed the tool surface, wash with any substrate compatible general-purpose surfactant and solvent.

- c. Painting: Follow paint manufacturer's instructions for applying paint over any primer.