



TD Seal HT Application Procedure

1. **Clean the surface** to remove any dust, oils, or contaminants.
2. **Repair flaws:** Fill larger voids using 3M 08115 panel bonding adhesive or equivalent
3. **Clean the surface again** with a product compatible with the printed material.
4. **Final wipe-down:** Use a 50/50 mixture of isopropyl alcohol (IPA) and distilled water.
5. **Stir TD Seal HT** thoroughly — **do not shake** to avoid introducing air bubbles.
6. **Catalyze:** Mix TD Seal HT with **1.5%–2% MEKP 925H** (or equivalent) and stir thoroughly. We use a dye in the MEKP to visually identify when it has been mixed properly.
7. **Prep the surface:** Blow off loose debris and wipe with a tack cloth.
8. **Spray application:**
 - Maintain a **spray distance of 6–8 inches** from the surface.
 - Use **air pressure of 20–25 psi**.
 - Gun tip **1.8mm**
9. ⚠ *Application by brush or roller is not recommended.*
10. **Apply 4 wet-on-wet passes**, each at **0.003 inches**, for a total build-up of **0.012 inches**.
11. **Inspect the surface:** If imperfections remain, spot-fill using a dabber.
12. **Apply an additional 0.012 inches** using 4 more wet-on-wet passes.
13. **Heat cure:** Maintain at **140°F for 30 minutes**. The coating will still be soft but hard enough to sand
14. **Sand and buff as needed** using the following grit sequence:
400, 600, 800, 1500, and 2000 (US standard).
15. **Polish** using compounds in sequence (we've used in the past):
 - 3M 36060
 - 3M 06064
 - 3M 06068

Currently we use

- 3D Hybrid Compound and Polish stages 1 to 3
- 3D ACA 500 Alpha Ceramic Alumina

16. Post-cure the tool at **250°F**. Shore D hardness rating 90

Using Mold Release

1. Apply one coat of mold release to the finished surface
2. Apply masking tape to areas where sealing tape will be used
3. Apply appropriate mold release, for the application, over the mold surface up to the edge of the tape
4. Remove masking tape and apply sealant tape