



# FABRICATION OF ROOM TEMP FAST PROTOTYPE MOLDS & PATTERNS USING LUC-4102

APPLICATION GUIDE



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## RECOMMENDATIONS FOR THE USE OF ADTECH LUC-4102 FOR THE FABRICATION OF ROOM TEMPERATURE FAST PROTOTYPING MOLDS AND PATTERNS

### SUGGESTED APPLICATIONS

- Fast Replacement for Plaster Tooling
- Nesting Fixtures
- Room Temp Prototype Tooling
- Duplication Aids
- Models
- Patterns

### PROCEDURE

Polyester, Epoxy or LUC-4102 Fast Cast Urethane can be used as a surface coat. When LUC-4102 is used as a surface coat the demold time can be 1-2 hours.

1. Properly prepare your mold, model or pattern surface with a sealer followed with several coats of an appropriate mold release or parting agent such as ADTECH Mold Release MR #1.
  - Permeable surfaces such as wood, plaster and polyester faced patterns require a sealer such as ADTECH Mold Sealer MR #7 to prevent sticking of the surface.
  - Epoxy or metal surfaces require only release agents or parting agents.
2. Using a paint shaker, shake parts A and B of the LUC-4102.
3. Pour off into separate containers as much of each part needed to coat the pattern or surface to be duplicated.
4. The remainder of the parts A and B with any additional material needed to complete the mold or pattern, should then be thickened to a paste consistency. Micro Balloons or Aerosil may be used, (using approximately 50-64 fl.oz. per gallon).
5. Catalyze and mix ADTECH ES-201-PC Epoxy Surface Coat by weight according to the Product Data Bulletin instructions. Apply ES-201-PC to the model surface with a brush or spatula to a thickness of .020" to .030". Allow this surface coat to gel at room temperature until almost tack free.
6. Apply a second coat of ES-201-PC to the almost tack free surface at a thickness of .020" to .030".
7. When the second coat of ES-201-PC is almost tack free, mix the unthickened LUC-4102 and apply using a brush or spatula.
8. Parts A and B of the thickened LUC-4102 can then be mixed in a 5-gallon pail using a JIFFY mixer. It is then applied to an even coat using a 4" or 6" spreader.
9. Mix and apply the remaining coats of thickened LUC-4102 to the required thickness.
10. Demold is possible in 1-2 hours when using LUC-4102 as a surface coat.

### PLEASE REFERENCE THE FOLLOWING PRODUCT DATA BULLETINS

EPOXY SURFACE COATS: ES-201 PC  
FAST CAST URETHANE SURFACE COAT: LUC-4102  
MOLD RELEASE: Mold Release MR #1 / Mold Sealer MR #7

Fast Cast Urethane Molds/Revised 2/9/10  
Supercedes 2/10/05

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