



A1 MILLTEC

DESCRIPTION

A1 MillTec is a water based Acrylic mineral composition and developed as a milling media for the manufacturing of plugs, direct moulds and tooling boards. This 3 component system is familiar to our other A1 systems and all existing A1 additives are compatible with A1 Milltec.

A1 MillTec can be used over rough milled EPS forms or other substrates to provide a machinable surface coating at any thickness required. It is suitable for hand working, pouring or spraying with a 1-component spray equipment.

A1 MillTec consist of a formulated liquid, powder and a lightweight filler.

FEATURES

- Good adhesion to a variety of substrates
- Excellent dimensional stability
- Easy to mix system with variable filler ratios
- Low exotherm on set (40°C)
- Water clean-up for tools
- Zero shrinkage
- Free of solvents
- Will accept a variety of coatings
- Shelf life: 1 year
- Packaging: Kit (10 + 5) kg and (40 + 20) kg. LW Filler on demand: (1, 5 and 10 kg)

TECHNICAL INFORMATION

	LW Filler content	0%	2%	5%	8%
Set time	minutes	15-20	15-20	20-25	25-30
Density (wet)	kg/lt.	1,75	1,45	1,21	1,03
Density (dry1)	kg/lt.	1,72	1,44	1,18	0,98
Density (dry2)	kg/lt.	1,71	1,42	1,16	0,95
Hardness (dry1)	Shore D	80	60	45	35
Hardness (dry2)	Shore D	82	63	49	38
Final Expansion (max.)	%	0,4	0,3	0,3	0,3

Dry1 = after 24 hours at 21°C

Dry2 = after 7 days at 21°C

APPLICATION INSTRUCTIONS

- The mixing ratio of the liquid/powder is **1:2** by weight and can be mixed with our A1 mixing blades.
- Working time is between 20-25 minutes, which can be extended by adding A1 Retarder. >>

This information is offered in good faith but without guarantee as conditions and methods of use and application of the product are beyond our control. We recommend that the prospective user determines the suitability of our materials and suggestions before adopting them on a commercial scale. For Health and Safety information please refer to the material Safety Data Sheet.



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- The lightweight filler can be added after mixing the powder and liquid.
- Depending on the preferred Specific Gravity, hardness and milling tools, the quantity of lightweight filler can be up to 10% by weight.
- See A1 Additives datasheet for more information.
- Pigments can be added, maximum 2% on total weight of powder and liquid.
- Small entrapped air bubbles can be filled or repaired afterwards.

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