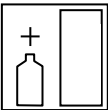


Technical Data Sheet
Creator PS-P
 Polyester tooling paste

DESCRIPTION			
<p>The Creator PS-P polyester tooling paste is a two-component polyester-based compound for forming new 3D models and designs around cores made of EPS, MDF or plywood. Creator PS-P is intended for application on modelling cores with a dedicated applicator for polyester tooling pastes. It can also be applied by hand. The latter method may result in many air bubbles from the blending of the product's components. Creator PS-P allows hassle-free application without running down steep or upright surfaces. It is also perfectly machinable with CNC machine tools. When cured, the product's surface can be easily coated with finishing products, including the Creator PH polyester putty or the Creator FPD polyester primer.</p> <p>Creator PS-P can be CNC-machined to a perfect, design-compliant surface finish of your models. A side effect of milling the polyester tooling paste is chips and low amounts of generated dust, which greatly improves the convenience of processing. NOTE: The shape and size of chips and the amount of dust generated by machining will depend on the machining parameters (i.e. feed, depth of cut, and tool speed) and the type of cutter, and it will vary with the time from application of the polyester tooling paste</p>			
SUBSTRATES			
styrofoam	Styrofoam is previously impregnated with a special Novol barrier Creator BR ; Polyester tooling paste is applied on the Creator BR barrier not earlier than 24 hours after applying the barrier on the foamed polystyrene. In order to ensure adequate rigidity and dimensional stability, it is recommended to make a laminate before applying the Creator PS-P tooling paste.		
composites	dry sand with P80 and remove dust		
plywood	dry sand with P80 and remove dust		
wood	remove dust		
CAUTION			
Creator PS-P should not be applied directly on one-component acrylic or nitrocellulose products			
MIXING RATIO			
	Creator PS-P CETOX 50 Red	Ratio by weight	Ratio by volume
		100g 1,1 – 1,5g	100ml 0,8 – 1,1ml
APPLICATION LIFE AFTER MIXING WITH THE HARDENER			
From 4 to 6 h at 20°C with 1.25 % hardener			
APPLICATION			
<p>This product is intended for application with a dedicated polyester tooling paste applicator which doses the hardener and mixes the product components properly. The applicator requires a compressed air supply via a 19-mm diameter hose with a minimum operating pressure of 14 bars. The overall compressed air hose length between the applicator mixer and the applicator nozzle should not exceed 8 m. The optimum pressure setting of the applicator is 2 bars.</p> <p>Depending on the model size, apply Creator PS-P in single patches not bigger than 2 m². Keep expansion gaps up to 3 cm wide between the single patches. Fill the expansion gaps with Creator PS after 14 to 24 hours. Carefully process all types of depressions in the model being built. All corners the thickness of which may exceed 3 cm when applying this product are exposed to a high temperature peak, resulting in potential defects (e.g. damage to the model core or superficial cracks). It is recommended to apply the product in two layers, each 2 cm thick, in these areas. The second layer can be applied when the first reaches its initial curing level, which takes approximately 12 h. An alternative solution is to make expansion gaps at the corners and fill them after 14 to 24 h.</p>			
PROPERTIES		Creator PS-P	
Density		0,78 – 0,83 g/cm ³	
Colour		green	
Shrinkage		below 1,3 %	
Tensile strength		9 MPa	

Maximum Elongation at Break	7 %
Shore Hardness	D 60
Curing time	12 – 24 hours
Recommended parameters of roughing (double-bit cutter)	- feed speed 30-50 mm/s - spindle speed 9000-12000 obr/min
UWAGA: CAUTION: Resistance tests have been carried out according to the standards PN EN-ISO 527 and PN-ISO 8256+AC with Cetox 50 Red as hardener	
COVERED BY	
In order to achieve accurate levelled surface, the Creator PS-P needs to be milled with CNC machine prior to application of polyester primer Creator FPD . In case of additional surface defects (air bubbles, shortages of paste) these should be filled with a dedicated polyester putty Creator PH .	
APPLICATION CONDITIONS	
The minimum application temperature is +15 ^o C, the maximum application temperature is +30 ^o C, air humidity from 30 to 70 %.	
COMPLEMENTARY PRODUCTS	
Hardener – cyclohexanone peroxide (e.g. Cetox 50 Red).	
EQUIPMENT CLEANING	
THIN 850 acrylic thinner or NC solvent.	
PACKAGING	
Delivery form depends on the individual agreement with every customer.	
STORAGE CONDITIONS	
Store in tightly closed containers in cool, well-ventilated rooms, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
Creator PS-P	6 months / 20°C
Cetox 50 Red	6 months / 20°C
In original packaging	
SAFETY	
<p>The dust from machining this product is flammable. Processing of this product and its completion must follow proper occupational, safety and fire protection regulations. Do not use any sources of open flames or heat at the processing site. Remove processing waste (including the dust from machining) frequently.</p> <p>Remove the remaining chips and dust after finishing the processing for the day. Store this waste in bags made of natural fibres or in separate, electrically bonded steel drums.</p> <p>See the Technical Data Sheet for more information.</p>	
NOTES	
Intended for professional use only.	

OTHER INFORMATION

Registration number: 000024104

The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.

MIXING RATIO BY WEIGHT / WOLUME

When density ~ 0,82 g/cm³ and for 100g Creator PS-P

Hardener [g]	Utwardzacz [ml]
1,0	0,8
1,1	0,8
1,2	0,9
1,3	1,0
1,4	1,1
1,5	1,1