Technical Data Sheet

CM Mask 2-101

PRODUCT DESCRIPTION CM Mask 2-101 is a UV / Visible light curable masking material that provides excellent surface protection during aggressive turbine component processes such as Air Plasma Spray coatings, acid stripping, and machining. This hard, high adhesion mask is ideal for protecting nickel based alloys commonly used in the manufacture of hot engine components such as blades, vanes, rotors, transitions, etc. CM Mask 2-101 contains no nonreactive solvents and cures when exposed to light. After processing, it is easily removed by incineration at temperatures above 650°C{1200°F}.

UNCURED PROPERTIES

COMPOSITION	Urethane Acrylate / Monomer Blend
VISCOSITY	60,000 cP
APPEARANCE	Green Thixotropic Gel
SPECIFIC GRAVITY	1.1 -1.2 at 25^0 C.
FLASH POINT	200^0 F.
TOXICITY	Refer to Material Safety Data Sheet
SHELF LIFE	One Year

CURED PROPERTIES

DUROMETER	Shore D 85
WATER ABSORPTION	< 1% (24 hour immersion)
TEMPERATURE RANGE	-45^0 C. – 145^0 C.

CURING INFORMATION

UV Intensity	Thickness	Time to Cure
100 mW/cm^2	2 mm	30 seconds

THESE ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE PRODUCT SPECIFICATIONS.

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Storage – This is light sensitive material. Containers must remain covered when not in use. Minimize exposure of uncured material to daylight, artifical light, and UV light during storage and handling. Store uncured product in its original, closed container in a dry location. Unless otherwise indicated on the product label, optimal storage temperatures are 10 to 30°C, (50 to 86°F). Any material removed from the original container must not be returned to the container as it could be contaminated. Composition Materials cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

Handling and Clean-Up – For safe handling information, consult this product's Material Safety Data Sheet (MSDS) prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

Using the Product – Prior to dispensing, ensure that each surface coming in contact with this product is clean and free of grease, mold release, or other contaminants. Dispense directly from the package, or utilize appropriate dispensing equipment that is compatible with light-curable adhesives and coatings. Fluid lines and dispense tips must be 100% light blocking. Curing stations should be equipped with air exhaust systems to evacuate vapors and heat generated during the curing process. After curing, this product must be allowed to cool to ambient temperature before testing the product's performance.

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