

ReleaSys™ 8000 Semi-Permanent Mold Release Agent

Description:

ReleaSys™ 8000 is a solvent-based, semi-permanent mold release agent designed to provide superior durability and surface adhesion in cold molding operations. Utilization of a proprietary catalyst system rapidly accelerates the cure process allowing fast reapplication internally. Properly applied, our product develops a durable, thin-film on the mold surface with minimal build-up. ReleaSys™ 8000 will not interfere with post-production finishing operation. Benefits of this product include:

- Exceptional durability and surface adhesion
- Ideal for unheated or chilled mold surfaces
- Fast Drying; Low Odor
- Clean, Non-oily, Non-migrating

Release Agent Applications:

ReleaSys™ 8000 is formulated to provide unmatched utility in low-temperature compression, injection and transfer molding with the following materials:

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|------------------------|--------------------------------------|
| • Organic Polymer | • Thermoplastics |
| • Thermosetting resins | • Elastomers (Natural and Synthetic) |
| • Fluoroelastomers | • EPDM |
| • Acrylics | • Epoxy |
| • Neoprene | • Melamine |

Recommended Application Procedure:

1. Clean mold surface thoroughly. Mechanical cleaning such as bead media blasting, followed by chemical cleaning, provides the best surface for application. Removal of all previous mold release agent and contamination is critical.
2. Pour ReleaSys™ 8000-B (catalyst) into ReleaSys 8000-A (polysiloxane resin/carrier solvent) and replace lid. Gently swirl ReleaSys™ 8000-A to disperse catalyst. Once mixed, the pot-life is 24-36 hrs.
3. ReleaSys™ 8000 can be applied by any spray equipment that can produce fine atomization and deposit a uniform, thin film. Apply a light coat to the surface, with smooth, consistent movement.

4. Allow ReleaSys™ 8000 to dry completely, then cure for approximately 2-3 hours. The cure can be accelerated with heating to less than 60 mins

Reapplication:

1. When release becomes hesitant, immediately reapply one coat of ReleaSys™ 8000 in the same manner as described previously. Spot touch-ups can also be done on known high wear or geometrically strained areas.

Physical Properties:

Primary Polymer:.....Proprietary Polymer
Appearance:.....Clear
Odor:.....Hydrocarbon
Specific Gravity:.....1.01 g/mL @ 25°C
Flash Point:.....<50°C

Storage and Handling:

ReleaSys™ 8000 should be stored in a well-ventilated area which is cool and dry. Do not expose to freezing temperatures. Prior to use, container should be lightly agitated.

ReleaSys™ 8000 should not be used at temperatures above 250 °C or near open flames. Chemical breakdown will occur which will result in the generation of toxic fumes. When spraying, avoid inhalation of mist and exposure to skin. Always wash hands after handling.

Shelf-Life

ReleaSys™ 8000-A and 8000-B have a shelf life of 12 months from the date of shipment unmixed. Upon mixing, consume product within 24 hours days.

ReleaSys™ Product Line:

Miller-Stephenson offers a selection of high performance, semi-permanent release systems to meet your mold process needs. All variants of the ReleaSys™ Series will deliver higher productivity, lower rejection rates, and higher quality products.

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