

## ReleaSys™ 8900 Semi-Permanent Mold Release Agent

### Description:

ReleaSys™ 8900 is a solvent-based, semi-permanent mold release agent designed to provide superior durability and high slip across a broad range of moldable substrates. Properly applied, our product develops a durable, thin-film on the mold surface with minimal build-up. ReleaSys™ 8900 will not interfere with post-production finishing operation. Benefits of this product include:

- Exceptional durability and surface adhesion
- Ideal for complex molds
- Improves quality and consistency of molded parts
- Fast evaporation and cure time
- Clean, Non-oily, Non-migrating

### Release Agent Applications:

ReleaSys™ 8900 is formulated to provide unmatched utility in compression, injection and transfer molding with the following materials

- Organic Polymer
- Thermosetting resins
- Fluoroelastomers
- Acrylics
- Neoprene
- Thermoplastics
- Elastomers (Natural and Synthetic)
- EPDM
- Epoxy
- 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. ReleaSys™ 8900 can be applied by any spray equipment that can produce fine atomization and deposit a uniform, thin film. Apply light coats, approximately 8-10 inches from the surface. Surface wiping can be done as well, no additional polishing is required.
3. Allow ReleaSys™ 8900 to dry completely, then cure for approximately 3-5 minutes at normal operating temperatures (minimum 50 °C). Multiple light coats can be applied, and will increase durability and maximizes number of releases.

4. Overapplication can result in lower release efficiency and transfer. General molding requires no more than two coats to achieve optimal performance. If overapplication is detect, light buff the surface with a microfiber cloth to remove unadhered material.

### Reapplication:

1. When release becomes hesitant, immediately reapply one coat of ReleaSys™ 8900 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:.....Thermoset Polysiloxane  
Appearance:.....Clear  
Odor:.....Slight  
Specific Gravity:.....0.69 g/mL @ 25°C  
Flash Point.....-14.8 °F

### Storage and Handling:

ReleaSys™ 8900 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™ 8900 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™ 8900 has a shelf life of 12 months from the date of shipment

### ReleaSys™ Product Line:

Miller-Stephenson's 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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