



Product Information

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ReleaSys™ 8900S Semi-Permanent Release Agent

Description:

ReleaSys™ 8900S is a solvent-based, semi-permanent mold release agent designed to provide superior durability and ease of release across a broad range of moldable substrates. ReleaSys™ 8900S utilizes a proprietary siloxane resin copolymer which provides tenacious adhesion to mold surfaces providing extended reapplication intervals. The cured product yields a highly lubricious, micro-thin film on the mold surface which does not affect post-molding painting, bonding or fusing. This product is ideally suited for polyurethanes, plastics, and composite materials. Properly applied, our product develops a durable, thin-film on the mold surface with no build-up. Benefits of this product include:

- Exceptional durability and surface adhesion
- Ideal for complex molds
- Ideal for room temperature application
- Fast evaporation and rapid cure time
- Zero build-up and excellent thermal stability
- Clean, Non-oily, Non-migrating

Release Agent Applications:

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

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|------------------------|------------------|
| • Polyurethanes | • Thermoplastics |
| • Thermosetting resins | • Elastomers |
| • Fluoroelastomers | • EPDM |
| • Urethanes | • 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. ReleaSys™ 8900S can be applied by hand wiping application or spray application to a room temperature or heated mold surface.
3. **Hand wiping:** Lightly apply a single coat to ideally a heated mold surface. Do not overlap your passes over the mold. Work quickly to coat the mold, apply only the lightest of pressure to the surface.
4. **Initial Application after cleaning:** Allow the product to cure for 5-10 minutes between coats. Typically, 1-3 coats can be applied, care must be taken not to overapply the mold release.
5. Allow 15-20 minutes for full cure after final addition or heat cycle your mold to accelerate the process
6. If heavy application is observed after curing, lightly buff the surface to remove excess film build-up.
7. **Spray application:** Apply a light coat, approximately 8-10 inches from the surface. Be sure to make even, light passes of over the mold surface. Application of wet film, which dries on the surface of mold is critical.

8. Allow ReleaSys™ 8900S to dry completely, then cure for approximately 5-10 minutes at room temperature. Multiple light coats can be applied but is not usually necessary.
9. Overapplication can result in lower release efficiency and sticking. General molding requires no more than two coats to achieve optimal performance. If overapplication is detected, lightly buff the surface with a microfiber cloth to remove unadhered material.
10. Regardless of application method, maximum release will be obtained as the mold becomes conditioned to ReleaSys™ 8900S

Reapplication:

1. When release becomes hesitant, immediately reapply one coat of ReleaSys™ 8900S in the same manner as described previously. Spot touch-ups can also be done on known high wear or geometrically strained areas. Light buffing can be done prior to reapplication to clear the surface of contaminants.

Physical Properties:

Primary Polymer:.....Polysiloxane Resin
Appearance:.....Clear
Odor:.....Hydrocarbon
Specific Gravity:.....0.79 g/mL @ 25°C
Flash Point:.....80.6 °F

Storage and Handling:

ReleaSys™ 8900S 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.

Special Caution: Moisture-Sensitive, keep container tightly closed when not in use

ReleaSys™ 8900S should not be used at temperatures above 310 °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™ 8900S 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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