

## ReleaSys™ DF DryFilm Mold Release Agent

### Description:

ReleaSys™ DF is a solvent-based, dryfilm mold release agent designed to provide superior surface adhesion and wear resistance. Miller-Stephenson's exclusive surface activation technology and fluoropolymer resins allow for unmatched durability and maximal releases per application. ReleaSys™ DF is formulated specifically for cold molding operations which require a dryfilm release agent. ReleaSys™ DF is a very easy and forgiving release system providing release of nearly any substrate off any molding surface. ReleaSys™ DF will not interfere with post-production finishing operation. Benefits of this product include:

- DryFilm Release System
- Surface Activation Technology
- Unmatched surface adhesion and durability
- Ideal complex molds or abrasive substrates
- Clean, Non-oily, Non-migrating

### Release Agent Applications:

Our specialized chemistry can be used to release the following materials:

- |             |                  |
|-------------|------------------|
| • Plastics  | • Rubbers        |
| • Resins    | • Phenolics      |
| • Acrylics  | • Polycarbonates |
| • Urethanes | • Polystyrene    |
| • Nylons    | • Elastomers     |

### 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. Lightly agitate ReleaSys™ DF prior to and during use. Apply approximately 6-8 inches away from a non-heated mold surface and apply a light coat of ReleaSys™ DF. NOTE: Material will apply wet and transparent, but will dry to a fine-white coat.
3. Allow solvent to dry completely before molding any parts.

4. Although it is not necessary to heat ReleaSys™ DF, performance can be enhanced if a heating cycle is completed prior to operation. This will ensure the most effective coating for durability and cycle life

### Reapplication:

1. When release becomes hesitant, reapply one coat of ReleaSys™ DF in the same manner as described previously.

### Physical Properties:

Primary Polymer:.....Fluoropolymer  
Appearance:.....Opaque/Yellow  
Odor:.....Alcohol  
Specific Gravity:.....0.96 g/mL @ 25°C  
Flash Point.....>50°C

### Storage and Handling:

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

### 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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