

# Product Bulletin

# CASS POLYMERS

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MR #1  
MOLD RELEASE

0302

## DESCRIPTION

MR #1 is a solvent based release system designed for use when non-transfer of release agent, high temperature stability, and abrasion resistance of the release film are important. MR #1 is a water thin liquid that is ready to use. The system is functional after cure. The film is micro-thin and stable.

MR #1 adheres to mold surface, provides multiple release with virtually no transfer. MR #1 reduces build up on molds when applied according to instructions.

## USES

-Rubber molding:	Injection, compression, or transfer
-RTV silicone mold treatment:	Extends life of RTV silicone molds
-Laminates/Composite molding:	All types
-Rotation molding:	All types
-General plastic molding:	Compression, injection, potting/casting
-Foundry cold-box molding:	Isocyanate-base binders
-Mold conditioning:	Reduces or eliminates use of other external release agents and prolongs run time before mold cleaning.

## APPLICATION

### Cure of 200°F (93°C) or more

1. Thoroughly clean the mold with a suitable solvent or detergent to remove the previous release agent or other contamination. Wipe dry with a clean cloth or towel. Then wipe with naphtha and let dry.
2. MR #1 can be applied with either conventional spray equipment or by brush. When spraying, hold spray nozzle 6-10 inches from the mold surface and apply a light, even spray. When applying by brush, use long, even strokes to assure a consistent, uniform coating.
3. To pretreat or condition the mold, apply MR #1 in a well-ventilated area. Apply at least three uniform, thin coats and allow 5-10 minutes between applications for air drying of each coat. A short baking of the conditioned mold (10-15 minutes) at 200°F (93°C), or the molding temperature (whichever is higher), will improve the durability of the MR #1 film and will provide maximum number of releases per application. **\*ROOM TEMPERATURE CURE:** Allow the mold to remain at room temperature for two hours to cure thoroughly. Begin molding.
4. Reapply a light coat of MR #1 as required, to maintain desired release.

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