

Product Bulletin

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MR #10
HIGH GLOSS MOLD RELEASE

REV: 0302

PRODUCT DESCRIPTION:

MR #10 is a semi-permanent, multiple-cycle release coating, specially formulated for processing reinforced polyester resins using epoxy, polyester or metal molds. It is a single component system of complex moisture-cure, film-forming polymers in a volatile solvent base. It contains no chlorinated hydrocarbons.

On application, it rapidly cures at ambient temperatures, using atmospheric moisture to cross-link and chemically bond to the mold surface to form a micro-thin release film that is hard, durable, and thermally stable at elevated temperatures.

Multiple processing cycles are possible from a single application with no transfer, migration, or "fish-eyes".

PRODUCT FEATURES:

- * Excellent release of polyester, epoxy and urethane resins.
- * High gloss finish on molded parts. No "fish-eyes".
- * Easy application - rapid room temperature cure.
- * Single-component convenience, no mixing or pot-life.
- * Multiple-release capability.
- * No mold build-up, no transfer, or migration.
- * No silicones or waxes.
- * Thermally stable up to 900°F (482°C).
- * No chlorinated solvents.

APPLICATION AREAS:

The high gloss finish produced by MR #10 makes it the product of choice for releasing gel-coats used in the marine and sanitary-ware manufacturing industries. It also effectively releases epoxies, phenolics, and other resin systems. It is particularly useful in closed-mold processes employing compression, injection, or transfer operations, and those using vacuum assistance.

TYPICAL PROPERTIES:

Appearance..... Clear, thin liquid
Odor..... Typical petroleum solvent
Carrier..... Blend of aliphatic and aromatic naphthas
Weight/Gallon..... 6.70 lb/gal
Flash Point 90°-100°F (32°-38°C)
Cure Time Full cure at ambient temperatures: 60-90°F (16-33°C)

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HANDLING & STORAGE:

This product contains flammable/combustible solvents. Do not store at elevated temperatures. Product is moisture-sensitive. Keep container tightly closed when not in use. When stored in original unopened containers in a cool dry place, the product will retain its activity for over twelve (12) months.

PROCESSING GUIDELINES:

Mold Preparation: For best results, the mold surface must be clean, completely dry, and free of prior release agents, sealers, or other contaminants.

Use a mold cleaner to remove wax, with a separate clean cloth to remove the wax as it dissolves. Avoid simply spreading the wax around the mold surface.

For extended mold protection and enhanced release performance, the use of MR #7 mold sealer and conditioner, is recommended.

MR #10 can be applied at ambient temperatures, 60-90°F (16-33°C), by wiping, brushing, or spraying.

Apply a thin, wet, continuous coat to a small area of the mold surface, and allow to dry to a light haze, gently wipe with a clean, lint-free cloth. Continue this procedure until the entire mold has been treated, then repeat until a total of 3-4 coats has been applied. The mold is now ready for use.

On new molds, apply a touch-up coat after each of the first 2 - 3 releases to condition the mold.

Release performance is dependent on maintaining a continuous film on the mold surface. Abrasion during processing cycles will gradually disrupt the film and cause a noticeable reduction in ease of release. When this occurs, simply apply a single coat of the release agent, using the above procedure, and continue operations. Re-application of mold sealer is only necessary if the mold is stripped or damaged.