

RAM COMPOSITE PRODUCTS

TECHNICAL DATA

Date: Mar 10, 2010

Product # 87-X26

Description: MOLD RELEASE 225

Line: Mold Release 225

This product is a silicone free, heat stable, non-carbonizing release agent. The heat-cured film of MR225 does not usually transfer nor migrate, so that painting, finishing, bonding or other secondary processing steps may be accomplished on molded parts without further treatment. MR225 is thermally stable up to 900° F. Epoxies, phenolics, polyimides, polybismaleimides and polyester parts release freely from the mold on cures up to 900° F. Application instructions should be followed closely to obtain these results. MR225 is designed for metal or non-metal tools.

87-08 MR BLUE has a blue color. 87-X26 and 87-X102A has a clear color.

Specifications			
Physical Properties:			
Weight Per Gallon (Theoretical):	6.33 lbs./gallon		
Flash Point:	20		
Other Information			
Shelf Life, 77 Degrees F, Days	365		
Test	Min	Max	
COLOR (VISUAL AGAINST STD)			PASS
WEIGHT PER GALLON	6.2	6.6	
WEIGHT SOLIDS EPA	3.3	3.5	

COMMENTS:

APPLICATION SUGGESTIONS FOR 87-X26:

Mold Release 225 may be applied over existing release agents by spray, brush or wipe-on. It works best when applied on a clean mold. Two coats applied in opposite directions give optimum results. Allow 15 minutes for solvent release before applying the second coat. When applying the second coat with a rag, make sure the rag is thoroughly saturated with Mold Release 225. Any dry spot on the rag could remove the first coat. After the second coat is applied, bake at 250° F. (120° C) for 60 minutes. New tools may require more than two coats. New tools should be heated to 250° F. before applying Mold Release 225. This will open the pores and allow the release agent to go into pores.

Removal of Old Release Agent

Scrubbing with metal pads saturated with detergent is the best method for old release agent removal. Follow with a solvent wipe.

Resin Removal

Sanding is recommended for resin removal.

Transfer

Should Mold Release 225 transfer, use the metal pads, detergent and solvent wipe. Transfer usually indicates the Mold Release 225 was too heavily applied.

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