

McLube 1805A

SEMI-PERMANENT MOLD RELEASE

PRODUCT DESCRIPTION

McLube 1805A is a solvent dispersion; semi-permanent release coating designed to provide maximum release cycles per application with no transfer. A coating of McLube 1805A will provide a durable, dry, bonded, colorless film that has excellent high temperature stability, mold flow and abrasion resistance. The coating provides excellent release for all types of rubber and especially for peroxide cured elastomers.

TYPICAL PRODUCT DATA

Color and Appearance.....	Clear, colorless solution
Solvent.....	Solvent blend – heptane, isopropanol
Specific Gravity	0.73

KEY PERFORMANCE PROPERTIES OF RELEASE COATING

- Effective for all types of rubber exclusively for fluoroelastomers
- Clean, dry, colorless, and non-oily
- Contains no oil, grease, stearates, waxes or silicones
- Will not transfer to molded part
- Will not lead to build-up on the mold
- Will not interfere with post-furnishing operations
- Will not cause knit lines on molded parts
- Gives multiple releases per application
- Chemically and thermally stable
- Leads to increase productivity and reduced scrap rate

USES

Release coating for a wide variety of elastomers

- Effective for Fluoroelastomers compounds
- Natural rubber, CR, SBR, EPDM, TPE, HNBR, FKM, ECO, CPE, NBR, etc
- Peroxide cured systems
- Rubber to metal bonding products

Release coating useful for a broad range of processes

- Injection, Compression, Transfer, Reaction Injection Molding

Composite/Plastics - phenolic, epoxy, graphite, nylon, ABS etc.

May also be used on metal as well as nonmetallic molds

APPLICATION METHODS

The surface to be coated should be cleaned and free from grease, dust and residue from cleaning solvents. The product is intended to use as received without further dilution. Suitable methods of application include spraying, dipping, flooding and brushing.

A thin, even coating should be applied to the surface. After allowing the solvent to evaporate completely, a second coat should be applied, preferably in the opposite direction to the first.

For optimum results, the dry coating should be cured for 15 minutes at 150⁰ C or for five minutes at 175⁰C or higher. Fully cured coatings may also be obtained by using higher temperatures for shorter periods of time. Naturally, where operating temperatures are high enough in the molding process, application at ambient temperature followed by raising the temperature to operating conditions should be sufficient to cure the coating. Product can be reapplied at molding temperatures without a baking step.

SAFETY AND HANDLING

The material safety data sheet, which accompanies initial shipment of the product, should be reviewed before using McLube 1805A.

The precautions to be observed in handling McLube 1805A are those related to the solvent blend – heptane, isopropanol in the product. These solvents are flammable, and thus, the product should be kept away from the heat, sparks and flames. Adequate ventilation should be employed, especially in enclosed areas.

AVAILABILITY

McLube 1805A is available in 400 ml Aerosol Cans.

The information herein is believed to be reliable, but it the user's responsibility to determine suitability of use; since we cannot know conditions of use, we make no warranties and assume no liability concerning use of the information. Nothing herein should be taken as an inducement to infringe any patent.