



#### ► DESCRIPTION

SK2TR450-8 is a water-based semi-permanent release agent enabling a straightforward processing of thermoset resins. Due to its well-balanced composition, release agent SK2TR450-8 provides superior release properties and excellent adhesion to the mould's surface. Downstream processing, such as gluing or varnishing, is possible without the need for any further treatments since SK2TR450-8 does not transfer to the moulded parts. The product provides a high gloss surface finish.

SK2TR450-8 is universally applicable on porous surfaces and releases all commonly used thermoset resins, such as polyester, epoxy and phenolic resins and PUR gelcoats. Especially if processing standards demand a high slip, SK2TR450-8 will be the perfect match.

The product is used in various manufacturing processes of parts made of composite materials.

#### ► APPLICATION

Cleaning:

It is recommended to thoroughly clean and dry mould surfaces prior to the application of release agent SK2TR450-8. Our cleaner SK2TR000-2 will be sufficient. However, release agent SK2TR450-8 is also suitable for touch-up coatings.

Base coat:

Green or freshly repaired moulds can directly be coated with release agent SK2TR450-8. Any initial mould sealing is not required.

Apply release agent SK2TR450-8 by wiping with a soaked, but not dripping, clean lint-free cloth. Commence by applying the release agent to a small surface area of approx. 1 m<sup>2</sup>. After about 30-60 s, when the film is still moist, use a second dry cloth to absorb excess of release agent SK2TR450-8 and proceed by wiping in circular motion until a clear and dry film emerges. In the case of occurring streaks or smears reduce the time before wiping off excess of release agent. We recommend beginning to wipe along the mould's outer border, approaching the inside. This procedure is repeated with the adjacent areas until all parts of the mould are evenly coated. In order to obtain a smooth and homogenous base coat, 2-3 layers of release agent SK2TR450-8 have to be applied. Allow each layer to cure for about 10 min. After the final layer has been applied, release agent SK2TR450-8 should be allowed to cure for about 15-30 min at 60 °C.

Mould touch-up:



# TECHNICAL DATA SHEET

## SK2TR450-8

### Semi-permanent release agent

Good conditioning of the mould will be achieved if the release agent film is refreshed 2-4 demoulding cycles after the initial base coating process. Since the release film wears during production touch-up coatings should be applied frequently.

Release agent SK2TR450-8 has been designed to incorporate and chemically bond touch-up layers of itself. Hence, curing time after touch-up reduces to approx. 15 min at room temperature. The required frequency of touch-ups for sufficient release depends on mould configuration and abrasion parameters and must be determined in individual on-site trials. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency. This will significantly reduce mould fouling due to build-ups and lead to extended mould service lives while ensuring a constant high quality of the moulded parts. Release agent SK2TR450-8 can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. Touch-up of the complete mould is preferred, though.

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the coating. In order to do so, the worn release film has to be removed completely 10 cm around the affected area with the help of soft abrasion, accompanied by wiping with solvent. Make sure that the mould's surface is thoroughly cleaned prior to application of a fresh base coat in the respective area in order to guarantee sufficient adhesion of the compensating layer to the mould.

Grounding is done as described above (Base coat). Even release of the moulded parts will be maintained if the repaired area is touched-up after each release for the first 4-6 demoulding cycles after the repair.

#### ► TECHNICAL DATA

Appearance:	Cream-colored liquid
Composition:	Aqueous emulsion of synthetic resins
Density [g/cm <sup>3</sup> ]:	Approx. 1
pH-value (20°C):	Approx. 4

#### ► SIZE

Packaging
Box of 15 Cans x 1 L
Can 5 L (5 kg)



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**SK2TR450-8**

**Semi-permanent release agent**

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▶ **STORAGE**

The product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 12 months.

▶ **NOTE**

Other packaging (30 and 200 litres) is available upon request.