



## DESCRIPTION

SK2TR450-7 is a fast-evaporating semi-permanent mould release agent providing superior lubrication in the processing of thermoset resins. The product dispenses with the need for any mould sealing, thereby allowing for significant time savings. Since release agent SK2TR450-7 adheres strongly to the mould's surface, there is no transfer of release agent to the moulded parts which therefore can be post-processed without any further treatments. The product provides high gloss finished surfaces. When SK2TR450-7 is used, build-up in the mold is kept to a minimum. Thermal stability of this product reaches 450°C, however the application temperature range is between 10°C - 80°C. SK2TR450-7 is a multi-purpose product used in the processing thermoset resins, polyester, epoxy as well as phenolic resins. Thanks to its excellent lubrication properties, release agent SK2TR450-7 is the product of choice when highly complex moulds with various undercuts are being used.

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

## APPLICATION

Cleaning process:

We recommend to thoroughly clean mould surfaces prior to the application of release agent SK2TR450-7. Using our cleaner SK2TR000-2 will be sufficient. Additional cleaning using a fast-evaporating solvent is advisable to ensure all residues of fat and wax are eliminated

Base Coating:

Application of release agent SK2TR450-7 can be done without prior sealing of mould. Usually, a soaked, yet not dripping wet clean lint-free cotton cloth is used to apply the release agent. We recommend starting to treat a small manageable surface area first. After approx. 10 – 15 seconds, when the film is still moist, release agent excess is absorbed with the second clean cloth following by wiping in circular motion until a clear and dry film emerges. We suggest beginning to wipe along the outer border, approaching the inside. Repeat this procedure with the adjacent areas until all parts of the mould are evenly coated. Application of a minimum of 2 layers of release agent SK2TR450-7 is recommended in order to guarantee smooth and homogenous grounding. Make sure that the solvent evaporates completely between each layer. After the final layer has been applied, allow the release agent to cure for about 30 – 60 minutes. Curing time can be reduced by increasing the temperature of the mould (approx. 50°C, 15-30 min.).

Mould touch-up:

The first touch-up should be performed after about 5 - 6 releases, in order prepare the mould for a high number of release cycles. Since the release film wears out by use, refreshment coatings should be applied frequently. Release agent SK2TR450-7 has been designed to incorporate and chemically bond touch-up layers of itself. Hence, curing time after touch-up reduces to approx. 10 min at room temperature. The appropriate frequency of touch-ups for a constant high release performance depends on individual production conditions and has to be determined in on-site trials. We highly recommend applying touch-up prior to an observed decrease in release efficiency. This procedure 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 SK2TR450-7 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:

In the case of a partial, drastic decrease in release performance, the release coating should be partially repaired. Prior to doing 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. Ensure 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). The repaired area should be touched-up after each release for the first 4-6 demoulding cycles after the repair in order to maintain best overall release performance.



TECHNICAL DATA	VALUE
Appearance:	Colourless liquid
Composition:	Mixture of resins in solvents
Density [g/cm <sup>3</sup> ]:	Approx. 0. 8
Max. used T:	450°C
Flashpoint:	0°C

PACKAGING TYPE	NET WEIGHT
Box	15 Cans x 1 L
Canister	Can 5 L

#### 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 24 months.