



MR #1 MOLD RELEASE

HIGH TEMP
ABRASION RESISTANT

PRODUCT BULLETIN

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Plastic Systems

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DESCRIPTION

MR #1 is a solvent based release system designed for use when non-transfer of release agent, high temperature stability, and abrasion resistance of the release film are important. MR #1 is a water thin liquid that is ready to use. The system is functional after cure. The film is micro-thin and stable.

MR #1 adheres to mold surface, provides multiple release with virtually no transfer. MR #1 reduces build up on molds when applied according to instructions. **Typical applications include: rubber molding, RTV silicone mold treatment, laminates and composite molding, rotation molding, general plastic molding, foundry cold-box molding and mold conditioning.**

APPLICATION

Cure of 200°F (93°C) or more

1. Thoroughly clean the mold with a suitable solvent or detergent to remove the previous release agent or other contamination. Wipe dry with a clean cloth or towel. Then wipe with naphtha and let dry.
2. MR #1 can be applied with either conventional spray equipment or by brush. When spraying, hold spray nozzle 6-10 inches from the mold surface and apply a light, even spray. When applying by brush, use long, even strokes to assure a consistent, uniform coating.
3. To pre-treat or condition the mold, apply MR #1 in a well-ventilated area. Apply at least three uniform, thin coats and allow 5-10 minutes between applications for air drying of each coat. A short baking of the conditioned mold (10-15 minutes) at 200°F (93°C), or the molding temperature (whichever is higher), will improve the durability of the MR #1 film and will provide maximum number of releases per application. *ROOM TEMPERATURE CURE: Allow the mold to remain at room temperature for two hours to cure thoroughly. Begin molding.
4. Reapply a light coat of MR #1 as required, to maintain desired release.

SHELF LIFE: 2 years in original unopened containers.

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