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Aqua Release 470

WATER-BASED SEMI-PERMANENT RELEASE-AGENT

DESCRIPTION:

Aqua Release 470 is a water-based, semi-permanent release agent in the field of thermoset-processing. **Aqua Release 470** is suitable for molds made of metal and thermoset resins, especially for porous mould surfaces and when abrasive reinforcing materials are in use.

APPLICATION:

Aqua Release 470 is used for pre-treatment of molds in processing of, for example: epoxy-, polyester-, vinyl- ester-, phenolic- and DCPD-resins. **Aqua Release 470** is mainly used in processing techniques like BMC and SMC.

APPLICATION NOTES:

At first the mould has to be cleaned. A suitable cleaning-agent is *Mold Cleaner #3*.
Subsequently, distribute **Aqua Release 470** on the mould-surface, in an even layer, by spraying or by rubbing, using an uncoloured, lint-free cloth. In both cases the mould temperature should be between 50°C and 70°C. Now **Aqua Release 470** needs a moderate time-period for curing. Curing is finished, when the appearance of the release-agent-film is opaque and no longer wet, shiny. New moulds should be treated this way three to five times. The curing time between these application-cycles should be at least 15 minutes.
The mould is now ready for series-production.
Multiple demouldings with high surface quality are possible now. If the demould performance decreases, you have to apply one new layer of **Aqua Release 470**.

TECHNICAL DATA:

Physical characteristics:

weight:	1,0 kg/l ±0,1 (at 25°C= 77°F)
solvent:	water
operating temperature:	T_{room} up to +150°C (=300°F)

Aqua Release 470 does not contain aromatic-hydrocarbons or toxic solvents.

Shelf life: 12 months after date of production