Stoner TraSys® 818
MOLD RELEASE COATING

Description

TraSys® 818 fluorochemical mold release coating is a water-based dispersion for hot mold applications. When properly applied to a mold, it exhibits outstanding durability and antistick properties and has a very low coefficient of friction. It is clean, nonoily, nonstaining, chemically inert, and can function in high temperatures.

TraSys® 818 mold release coating has unique properties, making it an excellent release agent for molded rubber, molded fluoropolymer, molded plastic, and epoxy and plastic laminates. Unlike oily release agents, when properly applied, it does not interfere with post-finishing operations.

TraSys® 818 comes pre-diluted and is ready for use. Proper application results in superior release, and multiple releases are normal.

Uses

TraSys® 818 is ideal for compression, transfer, and injection molding of most rubber compounds, including silicone.

TraSys® 818 is an ideal touch-up for molds coated with TraSys® 258 and TraSys® 4600 systems.

Directions for Application

TraSys® 818 must be agitated before spraying. TraSys® 818 mold release coating should be sprayed on hot, clean, and dry surfaces. Properly applied, the coating will not be affected by water or most other materials that may come in contact with it.

Recommended Procedure

1. Clean mold thoroughly, using glass or plastic bead media or high pH detergent, to remove all prior mold release and other sources of contamination.
2. Use low-pressure spray equipment that provides a fine mist. After agitation, apply lightly to a hot mold, making certain that all areas of the mold are entirely coated.
3. Although it is not necessary to bake TraSys® 818, in some cases increased performance has been achieved by baking TraSys® 818 onto the mold's surface for 5 min at normal operating temperature (a minimum of 132 °C [270 °F]). Subsequent touch-up applications can also be baked on according to this procedure. This will give a bond between mold and coating that will ensure the most effective coating for durability and cycle life.

Note: Many companies attempt to schedule touch-up applications prior to shift change, or before break periods, allowing TraSys® 818 to bake without losing productivity from the mold.

Typical Properties

Primary Polymer:	Fluorochemical
Specific Gravity:	1.0
Odor:	Slight
Color:	White
Flash Point:	None

Storage and Handling

TraSys® 818 should be stored in a cool, dry, well ventilated area. Do NOT expose to freezing temperatures. Product is perishable if frozen. The product cannot be recovered and used if frozen.

Containers should be agitated before use and often during use. Drums will require a low rpm agitator to prevent phase separation in the storage container.

Breathing of vapors should be avoided. If spraying, care should be taken to avoid inhaling mist or vapors, just as sprayed paint inhalation should be avoided.

Care should be taken not to expose TraSys® 818 mold release coating to open flame or intense heat. Temperatures above 260 °C (500 °F) may cause chemical breakdown, resulting in toxic fumes. Always wash hands after handling TraSys® 818 mold release coating.

If this product is exposed to extreme heat conditions from misuse or equipment failure, toxic decomposition products that include hydrogen fluoride can occur. Hydrogen fluoride has an ACGIH threshold limit value of 3 parts per million parts of air as a ceiling limit, an OSHA permissible exposure limit (PEL) of 3 ppm of fluoride as an 8-hr time-weighted average, and 6 ppm of fluoride as a short-term exposure limit (STEL).
Do not smoke while handling this product.

Shelf Life

TraSys® 818 has a shelf life of 1 year from the date of manufacture. The date of manufacture and shelf life are posted on the container label.

Packaging

TraSys® 818 is available in 1-, 5-, and 55-gal containers. Larger volume orders may be packaged in specialty containers.

Shipping Limitations

None.

For more information or technical assistance:

Call 800-227-5538: **Email:** TimeSaver@StonerSolutions.com **Visit:** Stonersolutions.com/TraSys