



Stoner TraSys® 817

MOLD RELEASE COATING

Description

TraSys® 817 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® 817 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® 817 comes prediluted and is ready for use. Proper application results in superior release, and multiple release is normal.

Uses

TraSys® 817 is ideal for compression, transfer, and injection molding of most rubber compounds, including silicone.

TraSys® 817 is an ideal touch-up for molds coated with TraSys® 158, 158W, and 155 TraSys® systems.

Directions for Use

TraSys® 817 must be agitated before spraying. TraSys® 817 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® 817, in some cases, increased performance has been achieved by baking TraSys® 817 onto the mold's surface for 5 min at normal operating temperatures (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® 817 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® 817 should be stored in a cool, dry, well ventilated area. Do not expose to freezing temperatures. Freezing will affect the physical condition, but will not damage the release effectiveness. Thaw at room temperature, and mix well before using.

Containers in use 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 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® 817 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® 817 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® 817 has a shelf life of 1 year from the date of shipment.

Packaging

TraSys® 817 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:

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