

Release Agent Mikon® 705 MC

Description:

Release Agent Mikon® 705 MC is a semi-permanent mould release agent. It is easy to use and has been developed to make the use of waxes unnecessary. Mikon® 705 has more slip than Mikon® 700 MC. This particular product renders constant wax- and polishing cycles unnecessary, since Release Agent Mikon® 705 MC's release film adheres excellent to the mould's surface. Post processing, such as gluing or vanishing can be done without further treatments to the casting, since there is no transfer of Release Agent Mikon® 705 MC to the moulded parts. Release Agent Mikon® 705 MC creates high gloss finished surfaces and minimizes release agent residues in the mould.

Application Fields:

Release Agent Mikon® 705 MC designated application fields include the processing of polyesters, thermosets, epoxy as well as phenolic resins.

Application:

Cleaning process:

Prior to the first application of Release Agent Mikon® 705 MC, ensure to thoroughly clean the moulds from dirt and former release agent residues. We recommend using Cleaner R-52. Proceed to clean the moulds with a fast-evaporating solvent to eliminate all residues of fat and wax.

Sealing process:

New moulds or moulds with a porous surface need to be treated with an appropriate sealer prior to their initial use. We recommend using our Sealer Mikon® 699 MC, which has been specifically adjusted to incorporate with our Mikon®-brand semi-permanent release agents.

Main Coating:

Apply Release Agent Mikon® 705 MC, by using a soaked, yet not dripping wet rag. Keep in mind, that only dry and clean cotton cloths will help obtaining the desired results. Start by applying the release agent to a small surface area of approx. 1 m². After approx. 15 – 20 seconds, use a second, dry rag to absorb the release agent excess and proceed 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. To complete the whole coating process, follow these guidelines and apply 3 to 4 layers of Release Agent Mikon® 705 MC to the mould. Allow each layer to cure for about 10 minutes. After the last layer has been applied, allow the release agent to cure for about 40 – 60 minutes.

Advice:

Curing time is dependant on the processing temperature. Higher temperatures will shorten; lower temperatures will extend the curing time required. Waiting too long before wiping up release agent extent will cause smearing effects. Avoid this effect by wiping up the release agent extents early enough. Check by affixing strips of duct tape to some areas of the mould. If the release film is of proper consistency, you should encounter only minimum resistance, removing the duct tape strips. Compare the required force with an untreated mould.

Information for regulations on safety and transportation are provided in the safety data sheet

Further information:

Product technical information and data is based on the best information available and does not constitute or imply a warranty or patent infringement of any kind. The user is responsible for testing product suitability prior to use in production.

Page: 1 of 2
Revision: 30.10.2009 JHE/cw
Print: 27.05.2010



Viernheimer Str. 70-76
D-69469 Weinheim
Postfach 10 07 29
D-69447 Weinheim

Geschäftsführer: Wilhelm Münch
Amtsgericht Mannheim HRB 431102

Tel +49 (0)6201/99 83-0
Fax +49 (0)6201/99 83-66
info@muench-chemie.com
www.muench-chemie.com

USt.-IDNr. DE 144497299
Steuer-Nr. 47020/10016

Bankverbindungen Weinheim:

Deutsche Bank AG
BLZ 670 700 24
Kto. 586 896 300
Swift Code/BIC: DEUT DE DB 670
IBAN: DE84 6707 0024 0586 8963 00

Volksbank eG
BLZ 670 923 00
Kto. 1 078 801
Swift Code/BIC: GENO DE 61 WNM
IBAN: DE40 6709 2300 0001 0788 01

Touch-Up Coating:

The first release film touch-up should be performed after about 5 to 6 demouldings, in order to prepare the mould for a high number of demoulding cycles. Since the release film wears out by use, touch-up coatings should be applied periodically. We highly recommend applying touch-up coatings even before the actual release agent efficiency decreases noticeably! If trials for example indicate, that 20 releases are possible until a touch-up coating is required, we suggest reapplying Release Agent Mikon® 705 MC after 15 cycles. If one working shift achieves 8 cycles, refresh the film each second shift. Complying with these procedures result in extended die life, allowing the moulds to stay longer in active production since the time between two intensive mould cleaning cycles can be stretched. These procedures also ensure a constant product quality.

Partial release film repairs:

Prior to repairing the release film of a particular area of the mould, also remove all of the release film 10 cm around affected area. Semi-permanent release agents require soft abrasion as well as a wiping with solvent. Poor cleanings drastically impair the release film adhesion on the affected areas. Treat these cleaned areas as if they were a new mould, so seal and ground them as stated in the instructions above. Continue by refreshing the film after each release from the 4th to the 6th cycle. Keep in mind, that the repaired areas are more damageable than others.

Partial release film refreshments:

Refreshing the mould's release film as a whole should be preferred over refreshing the release film only partially. You avoid having to refresh yet another particular area over another. Nevertheless, there may be certain parts of the mould, that require refreshments of the release film more often than others. It is therefore suggested to, for example, refresh the mould's release film each 15 cycles, while more stressed areas are to be refreshed each 5 cycles. Release Agent Mikon® 705 MC has been designed to incorporate and chemically bond fresh layers of itself in case of partial release film refreshments or repairs, which allows to reduce the curing time to about 10 minutes at room temperature.

Technical Data:

Composition:	resins in solvent
Appearance:	colourless liquid
Density [g/cm³]:	approx. 0.86
Flashpoint [°C]:	> 21

Packaging:

Box	6 x 0.39 kg
Can	3.9 kg
Can	7.8 kg

Storage:

Release Agent Mikon® 705 MC 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 12 months. The expiry date is stated beneath the production date on the labels of each container.

Information for regulations on safety and transportation are provided in the safety data sheet

Further information:

Product technical information and data is based on the best information available and does not constitute or imply a warranty or patent infringement of any kind. The user is responsible for testing product suitability prior to use in production.

Page: 2 of 2
 Revision: 30.10.2009 JHE/cw
 Print: 27.05.2010



Viernheimer Str. 70-76
 D-69469 Weinheim
 Postfach 10 07 29
 D-69447 Weinheim

Tel +49 (0)6201/99 83-0
 Fax +49 (0)6201/99 83-66
 info@muench-chemie.com
 www.muench-chemie.com

Bankverbindungen Weinheim:

Deutsche Bank AG
 BLZ 670 700 24
 Kto. 586 896 300
 Swift Code/BIC: DEUT DE DB 670
 IBAN: DE84 6707 0024 0586 8963 00

Volksbank eG
 BLZ 670 923 00
 Kto. 1 078 801
 Swift Code/BIC: GENO DE 61 WNM
 IBAN: DE40 6709 2300 0001 0788 01

Geschäftsführer: Wilhelm Münch
 Amtsgericht Mannheim HRB 431102

USt.-IDNr. DE 144497299
 Steuer-Nr. 47020/10016