

## Release Agent Mikon® W-30

### Description:

Release Agent Mikon® W-30 is a water-based semi-permanent mould release agent, easy to handle and provides excellent slip properties. The product has been developed to replace the use of waxes during the production. This particular product renders constant wax- and polishing applications unnecessary, since Release Agent Mikon® W-30's release film adheres excellent to the mould's surface. Post processing, such as gluing or varnishing can be done without further treatments to the casting, since there is no transfer of Release Agent Mikon® W-30 to the moulded parts. Release Agent Mikon® W-30 creates high gloss finished surfaces and minimizes release agent residues in the mould.

### Application Fields:

Release Agent Mikon® W-30 designated application fields include the processing of thermoset resins, such as polyester-, epoxy- and phenolic-resins. If processing standards demand high slip effects, Release Agent Mikon® W-30 is be the perfect match.

### Application:

Cleaning process:

Prior to the first application of Release Agent Mikon® W-30, 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 fat and wax residues.

Grounding process:

Apply Release Agent Mikon® W-30, by using a soaked, but not dripping wet rag. Keep in mind, that only dry and clean cotton cloths will lead to appropriate results. Commence by applying the release agent to a small surface area of approx. 1 m<sup>2</sup>. After about 60 – 120 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 grounding process, follow these guidelines and apply 2 - 3 layers of Release Agent Mikon® W-30 to the mould. Allow each layer to cure for about 10 minutes. After the final layer has been applied, allow the release agent to cure for about 15 minutes.

Advice:

Curing time is depending on the processing temperature. Higher temperatures will shorten; lower ones 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 this effect by affixing strips of duct tape to different areas of the mould. If the release film is of proper consistency, you should encounter only minimum resistance when trying to remove the duct tape strips. Compare the required force to 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.

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#### Refreshments:

The first release film refreshment should be performed after grounding and during production, after 2 to 4 cycles, in order to achieve a good conditioning of the mould. Since the release film wears out by use, refreshments should be made periodically. We highly recommend performing refreshments before release film efficiency decreases! If trials for example indicate, that 20 releases are possible until a refreshment is required, it is suggested to reapply Release Agent Mikon® W-30 each 15 cycles, or, if a shift achieves 8 cycles, refresh the film each second shift. Complying with these procedures result in extended mould life, allowing the moulds to stay longer in active production since the time between two intensive mould cleaning cycles can be extended. 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 for the first 4 to 6 cycles. 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® W-30 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 15 minutes at room temperature.

### Technical Data:

<b>Composition:</b>	aqueous emulsion of synthetic resins
<b>Appearance:</b>	white liquid
<b>Density [g/cm<sup>3</sup>]:</b>	approx. 1
<b>pH-value (20°C):</b>	approx. 6.5

### Packaging:

Can	1 kg
Can	5 kg
Can	30 kg

### Storage:

Release Agent Mikon® W-30 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 6 months. The expiry date is stated beneath the production date on the labels of each container.

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