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TR-900/900FD/920/930
SEMI-PERMANENT RELEASE
NEW OR RECONDITIONED MOLD PREP GUIDE
POLYESTER MOLDED PARTS

STEP 1:

Remove all contaminates and previously used releases from mold surface with the **TR-905 MOLD PREP CLEANER**. Saturate cloth with the 905 Solvent and wipe onto sections or areas of the mold. Allow sufficient time while area is still wet to follow and wipe dry with a clean cotton cloth. Turn and change cloth frequently to absorb and pick-up contaminate. REPEAT if necessary until MOLD SURFACE is thoroughly cleaned and wiped dry. On NEW or RECONDITIONED MOLDS that have been buffed with a polishing or buffing compound, first water wash to remove the buffing compound residue and wipe completely dry. Then clean thoroughly with the 905 solvent cleaner as mentioned above. Refer to product data sheet.

STEP 2:

Apply 2-3 coats of **TR-910/910FD SEALER** to cleaned mold surface. Allow minimum of 15-20 minutes cure between coats and 30 minutes after final coat, preferably longer if schedule permits. Apply to a small area (approx. 3'x3') in a thin, wet continuous film. While still wet, gently wipe with a second clean, lint free cotton cloth to spread wet coating leaving a thin uniform film allowing solvent to evaporate leaving a high gloss finish on mold. No hard or excessive wiping is advised. Start at one end of mold surface and continue until entire mold has been sealed. Apply a second coat to ensure uniform coverage or for more porous surfaces. For maximum high temperature molding performance cure sealer at 250°F for 1 hour or allow longer ambient temperature cure of 2-3 hours. When spraying, use a dry air source or airless spray, applying in a thin continuous smooth film, avoiding excess flooding or runs. Keep spray tip approximately 10-15 inches from mold surface. While still wet, gently wipe dry with a clean lint free cotton cloth as noted in wipe application. See product data sheet for additional information.

STEP 3:

Apply 3-4 coats of **TR-900/900FD/920/930 Release** (5-6 coats if TR-910 sealer is omitted). Allow 10-15 minutes cure between applications and 30 minutes after final coat. Wet or dampen a clean lint-free cotton cloth with the release and apply an even wet coat on a small area of the mold surface (approx. 2' x 2'). Avoid heavy application or cloth that is heavily soaked or dripping wet. While surface is still wet, gently wipe dry with a separate clean, dry cotton cloth. Turn or change cloth as needed to ensure a uniform, dry surface. No hard or excessive wiping is advised. When applying, start at one end of the mold and over-lap slightly each small previously applied area until mold is complete. Apply subsequent coats in the same manner. See product data sheet for additional information. Recommend trial of the TR-920 or TR-930 as replacement for the TR-900 where MOLD GEOMETRY requires some horizontal pull when de-molding and added slip action is required.

STEP 4:

Apply the **TR-900/900FD/920/930 Series Release** again after the first 2 pulls or releases. Then process with your multiple release and apply as needed setting up a schedule you have achieved or determined when re-application is required. Any minor scratches or abrasion marks will have to be treated again at first notice. Apply another coat of Release on affected area. Any patched or repaired areas should be taken through all steps and sufficient overlap of area to provide uniform release and coverage. Allow TR-910 Sealer longer cure (1-2 Hours at room temperature) on patched or repaired areas.

NOTE: ALWAYS USE A LINT-FREE ALL COTTON CLOTH (PREFERABLY WHITE) WHEN APPLYING 905 SOLVENT CLEANER, 910 SEALER AND 900 SERIES RELEASE. NO SYNTHETIC CLOTH BLENDS. USE SEPARATE RAGS FOR CLEANER, SEALER & RELEASE. AVOID ANY CONTAMINATION OF RAGS AND/OR RELEASE CONTAINER. THE CONTAINER MUST BE KEPT CLOSED WHEN NOT IN USE. MATERIAL IS MOISTURE SENSITIVE AND WILL EXHIBIT PREMATURE REACTION IF CONTAINER IS LEFT OPEN EXCESSIVELY. AVOID CONTAMINATION WHEN REFILLING PREVIOUSLY USED CONTAINERS OR TRANSFERRING TO OTHER CONTAINERS.