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TR-930HS **MULTI-PULL** **LIQUID SEMI-PERMANENT RELEASE**

DESCRIPTION:

TR-930HS is a high slip low odor fast curing multiple capability semi-permanent mold release for use molding various polymers (polyester, epoxy, polyamide, SMC, BMC, etc.). Excellent for difficult to release closed mold processes, filament winding and non gel-coat polyester applications.

PRODUCT FEATURES:

- ★ High temperature properties up to 750°F (400°C)
- ★ High slip - multiple releases per application
- ★ Easy “wipe on – leave on” or spray application
- ★ No pre-release or transfer
- ★ Durable high gloss coating
- ★ Easily recoats without build-up

USES:

- ★ Open mold hand or spray lay-up
- ★ Compression & Prepreg molding
- ★ Injection molded parts
- ★ Vacuum bag/RTM
- ★ Filament winding/Rotational Molding

APPLICATION:

Clean mold surface thoroughly of all previous sealers and release agents using TR-905 mold prep solvent. Light abrasive compounding may be necessary to remove the various types of release agents or sealers previously used. After compounding, first water wash and wipe dry to remove compound residue. Then completely clean the mold surface with TR-905 mold prep solvent.

Apply a thin wet film to mold surfaces either by wipe or spray. Use an ALL-COTTON cloth when wiping to avoid possible binders in other fabrics dissolving from solvent carriers. Use an airless spray unit or a dry air source when spraying holding spray nozzle approximately 8-10 inches from mold surface. Start at one end of a mold working small areas or sections to the other end ensuring a thin wet film is applied to entire mold surface. Secondary polish step is not required. If desired gloss is reduced after application, lightly polish with 100% cotton cloth after final coat.

For initial break-in, apply 3-5 coats. Allow 5-10 minutes between each application and 10-15 minutes after final application for solvent release and cure. Recoat for the first 2-3 initial pulls or de-molding to aid full conditioning and mold life. Recoat will vary depending upon mold design or materials. Apply again at first sign of release difficulties. Use the TR-910 sealer if mold surface is porous, less smooth, or to provide improved initial release on new or green and repaired molds.

PHYSICAL PROPERTIES:

Solvent Carrier: Blend of hydrocarbon naphtha

Specific Gravity: 0.725

Wt/Gal.: 6.04 lbs./Gal

Shelf Life: 1 year from date of manufacture

Cure Time: Approx. 5-10min. between coats and 10-15min after final coat at room temp (75°F)

Appearance: Clear colorless with characteristic odor

Cure Method: Chemical reaction with atmospheric moisture following solvent evaporation

NOTE: Do not apply subsequent coats until complete solvent evaporation of prior coat.

STORAGE AND PRECAUTIONS:

TR-930HS contains flammable solvents. Keep away from spark, open flame or other sources of ignition. Store in a cool dry place and keep in original un-opened container. Product will react with atmospheric moisture and container should be kept tightly closed when not in use. Avoid creating static discharge, do not use microfiber cloth.

PACKAGING:

Available in gallon 4x1/cases, 5 gallon and 55 gallon drum. Please contact your local TR distributor or call direct.

FOR INDUSTRIAL USE ONLY

The information contained herein is based on tests considered to be reliable and accurate. Because of the wide variance of associated materials and conditions, no warranty is expressed or implied. Each user is encouraged to prepare a test part for their particular application.