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TR-930 MULTI-PULL LIQUID SEMI-PERMANENT RELEASE

DESCRIPTION:

TR-930 is a high-temp multiple capability semi-permanent release coating which cures under atmospheric condition, bonding a durable thin, clear release coating to the mold surface. Multiple releases per application for polyester, epoxy, polyimides, BMC, SMC, and various other advanced resins in fiberglass or graphite composite molding processes, thermoplastic rotational and rubber molding.

PRODUCT FEATURES:

- ★ Excellent hi-temp properties (Thermally Stable to 750°F)(400°C)
- ★ Multiple release per application
- ★ Ease of application and fast cure time
- ★ No pre-release or transfer
- ★ Wipes to high gloss finish.
- ★ Easily recoats without build-up

SUGGESTED USES: An effective multiple release agent for the FRP and related molders.

- ★ Open mold hand or spray lay-up
- ★ Compression molding
- ★ Injection molded parts
- ★ Vacuum bag
- ★ Resin transfer molding (RTM)

APPLICATION: HIGH GLOSS POLYESTER

Always use and apply with a clean, lint free all cotton cloth (no synthetic blends). Clean mold surface thoroughly of all previous release agents and sealers using TR-905 mold prep solvent. Surface should be completely dry and free of any contaminates. Apply TR-930 by wiping a thin wet coat onto a small area (approx. 3x3 ft.) of the mold surface starting at an end point of the mold. While the release film is still wet, wipe gently with another clean dry cotton cloth, turning and changing cloths as required for proper drying. Avoid excessive hard rubbing or wiping of the treated surface which ensures a more uniform and effective film deposit. Apply each application overlapping the previous small area until the entire mold surface is complete. Repeat this for 3-4 coats to the entire mold surface. Cure time of the release film at room temp. (75°F) is approximately 10-15 minutes (5 minutes at 250°F). A touch-up coat is recommended for the first 2-3 initial releases to maximize mold conditioning and durability. When spraying, use a dry air source or airless spray, applying in a thin continuous smooth film, avoiding excess flooding or runs. Wipe with a clean dry cotton cloth as noted in wipe application.

NON-GLOSS OR EPOXY APPLICATIONS: Apply 3-4 thin wet coats allowing solvents to flash. Wait additional 10-15 minutes after solvent evaporation before applying subsequent coats. Surface should be dry and not tacky.

PHYSICAL PROPERTIES:

Solvent Carrier: Blend of Aliphatic and Aromatic Naphthas

Specific Gravity: 0.76

Wt./Gal.: 6.3 lbs./Gal.

Coverage: Approx. 1200 Sq. Ft./Gal.

Cure Time: Approx. 10-20 min. at room temp. (75°F) or 5 min. at 250°F

Appearance: Clear thin liquid with characteristic odor.

Cure Method: Chemical reaction with atmospheric moisture following solvent evaporation.

NOTE: Recommend use of the TR-910 SEALER on new or green and repaired molds or for more porous or rough mold surfaces and maximum performance of the TR-930 RELEASE.

STORAGE AND PRECAUTIONS: TR- 930 contains flammable solvents. Keep away from spark, open flame or other sources of ignition. Store in a cool dry place and keep in original unopened 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 case, 5 gallon pail 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, however, no warranty is expressed or implied. Each user is encouraged to prepare a test part for his particular application.