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TR-940

MULTI-PULL SPRAY FAST

LIQUID SEMI-PERMANENT RELEASE

DESCRIPTION:

A spray-on self leveling release which dries uniformly to a gloss finish without polishing. Easily sprays to a gloss of the original mold surface while providing multiple releases with minimal mold build-up. No wiping dry is required or necessary.

PRODUCT FEATURES:

- ★ Rapid dry to gloss finish
- ★ Self-leveling to provide uniform film
- ★ No wiping or polishing required
- ★ Maximizes mold use and production
- ★ Ease of application with complete coverage
- ★ Thermal Stability up to 750°F (400°C)

SUGGESTED USES:

Excellent release for large (marine, transportation, swimming pools, etc.) gel-coated polyester molding applications requiring high gloss finish.

APPLICATION:

Before spraying, remove dry contaminants or dusts from the mold surface with a dry, clean air source. Spray using a HVLP (high volume low pressure) Binks Mach1 type, or equivalent spray equipment. Recommend setting air atomization at 35-50 psi and pot pressure of 3-6 psi with Binks fluid nozzle 92 (1.2mm) or 93 (1.3mm) and air nozzle 93P or 95P. Spray at a distance of 8-12 inches from the mold surface. Make any fine spray adjustments to the spray equipment as needed to deposit a thin uniform wet film. Avoid a heavy or excessive wet film or spraying too close to the surface. Apply to entire Mold Surface and follow again in a cross direction or perpendicular pattern on each coat. Spray on 5-6 coats, one immediately after another with no need to allow for cure time. On new molds especially, if not adequately post-cured, 7-8 coats are advised. Allow a minimum of 30 minutes cure time after final coat. After multiple releases or pulls become more difficult, TOUCH-UP with one coat, and allow 30-minute cure time. More frequent touch-up or recoat may be necessary on complex designs or critical areas of a particular type of shape or design that leads to more abrasion during the removal of part from the mold.

NOTE:

The mold surface must be clean of any contaminants, oil, or prior release agents that may affect improper surface wetting and bonding which then becomes less effective. Clean mold surface with TR-905 solvent prep cleaner or suitable alternatives. For any mold polishing or heavy build-up removal, use TR-311 Super Duty, TR-310 Fine Finish II Plus or TR-308 Fine Finish buffing compounds.

PHYSICAL PROPERTIES:

Solvent Carrier: Blend of Aliphatic hydrocarbons
Specific Gravity: 0.73 (±.01)
Wt./Gal.: 6.08 (±.05)
Shelf Life: 1 year from date of manufacture
Flash Point: 50°F (10°C) TCC
Cure Time: Approx. 30 Minutes at Room Temp. (70-75°F)
Appearance: Clear thin liquid with hydrocarbon odor
Cure Method: Chemical reaction following solvent evaporation

STORAGE AND PRECAUTIONS:

TR-940 contains flammable solvents. 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.

PACKAGING:

Available in gallon 4x1 case, 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, however, no warranty is expressed or implied. Each user is encouraged to prepare a test part for his particular application.