

## PRODUCT DATA

# Mono-Coat® 1904WRB

## Semi-Permanent Release Agent

Mono-Coat® 1904WRB is a water-based, ready-to-use semi-permanent release agent designed for rotational molding of all grades of polyethylene (XLPE, HDPE, MDPE, LDPE, LLDPE). It is specially formulated to provide excellent release from stainless steel and aluminum tooling while minimizing prerelease. Mono-Coat® 1904WRB provides high-temperature stability, excellent durability and multiple releases with virtually no transfer to the molded part.

### Typical Properties

Appearance	Off-white fluid
Density, lbs/gal; kg/l	8.33; 0.99
Flash Point, °F/°C	None to boil
Storage Stability, unopened	6 months

### Application

1. Mono-Coat® 1904WRB is effective even over existing mold release buildup. However, a completely clean tool is preferable in order to gain optimal performance.
2. Using a plastic, trigger spray bottle or clean, cotton cloth saturated with the product, apply Mono-Coat® 1904WRB over the entire tool including flanges and any parting lines. Because this product is water-based, "running" or "dripping" on the tool surface is normal.
3. Using a dry, cotton cloth, mop up any puddles that may form in collection areas.
4. Allow the coat to dry completely.  
Note: streaks and cloth marks in the film are normal.
5. Repeat this procedure two more times; however, do not allow the third coat to dry completely.
6. At the point when the third coat starts to dry, gently buff out the film with a clean, dry, cotton cloth until the surface finish is uniform.
7. The mold surface must be completely dry after this buffing step.
8. An oven cure prior to molding is not required. Load the tool with powder and begin molding.
9. Apply a light touch-up as needed. A dry bake cycle is not needed after touch-up.

### Storage

For best results, store between 55-80°/13-27°C. Keep from freezing. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures, allow product to warm to room temperature prior to use.

### Handling

We believe Mono-Coat® 1904WRB has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Material Safety Data Sheet.

### Packaging

Mono-Coat® 1904WRB is available in 1-gallon (3.8-liter), 5-gallon (20-liter) and 55-gallon (208-liter) containers.

While the technical information and suggestions for use contained herein are believed to be accurate and reliable, nothing stated in this bulletin is to be taken as a warranty either expressed or implied.

#### Further Information

Request information on our complete range of materials: custom-formulated release agents for polyurethane molding; tire lubes and bladder coatings; Mono-Coat® semi-permanent release coatings; aerosol formulations; mold cleaners and sealers; specialized coatings and application equipment.