

Mono-Coat® E312

Semi-Permanent Release Agent

Mono-Coat® E312 is a semi-permanent, solvent-base release system especially formulated for molding operations when a high degree of slip is the primary requirement. Mono-Coat® E312 is ideal for molding operations when low transfer of release agent, high-temperature stability, abrasion resistance of the release film, and multiple releases are important.

Typical Properties

Appearance	Clear fluid
Density, lbs/gal; kg/l	6.52; 0.78
Flash Point, °F/°C	54/12
Storage Stability, unopened	12 months

Recommended Use

Use on parting lines on rotational molds and rubber molding operations involved with mandrel forming.

Application

Mono-Coat® E312 can be applied to either a hot or a cold mold (ambient to 370°F/188°C). For best results, the Mono-Coat® should be cured on the mold at 200°F/93°C or the molding temperature (whichever is higher) to achieve the maximum number of releases per application.

1. Thoroughly clean the mold with a suitable solvent or detergent to remove the previous release agent or other contamination. Wipe dry with a clean cloth or towel. Then wipe with a clean solvent or naphtha and let air dry.
2. If spray application is preferred, use conventional spray equipment and hold spray tip 4-10"/10-25 cm from surface. Mono-Coat® E312 may also be wiped on the mold with soft, clean cotton cloths.
3. Use a light, even spray when using spray methods. When wiping, apply thin even coats.
4. To pre-treat or condition the clean mold, apply Mono-Coat® E312 in a well-ventilated area. Apply at least three, uniform, thin coats and allow 5-10 minutes between applications for air drying of each coat. A short baking of the conditioned mold (10-15 minutes) at 200°F/93°C or the molding temperature (whichever is higher) will improve the

durability of the Mono-Coat® film and will provide the maximum number of releases per application. Begin molding.

5. Reapply a light coat of the Mono-Coat® when required, to maintain desired release. To prevent buildup, avoid overapplication.

Storage

Do not store at temperatures above 100°F/38°C. Keep container tightly sealed to prevent evaporation and/or moisture contamination. If stored in cold temperatures, allow product to warm to room temperature prior to use.

Handling

We believe Mono-Coat® E312 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® E312 is available in 1-gallon (4-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.