

Mono-Coat® 1909RB

Semi-Permanent Release Agent

Mono-Coat® 1909RB is a semi-permanent, solvent-based, ready-to-use release system designed for molding operations when high temperature stability and abrasion resistance of the release film are important.

Mono-Coat® 1909RB adheres to mold surfaces and provides multiple releases with minimal transfer to molded parts. This product leaves virtually no buildup on the molds when applied according to instructions.

Typical Properties

Appearance	Clear fluid
Density, lbs/gal; kg/l	6.41; 0.769
Flash Point, °F/°C	54/12
Storage Stability, unopened	12 mos.

Recommended Uses:

Rotational Molding – All types, i.e. XLPE, HDPE, MDPE, LDPE, LLDPE

Rubber molding – Natural, SBR, nitrile, other polymers except silicone (injection, compression, transfer)

Application

Mono-Coat® 1909RB can be applied to either a hot or a cold mold (ambient to 370°F/188°C). For best results, Mono-Coat® 1909RB 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 Chem-Trend mold cleaner 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. This product is acceptable for use on aluminum, magnesium, and zinc molds and exhaust systems.
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® 1909RB 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 Mono-Coat® 1909RB and will provide the maximum number of releases per application. Begin molding.

5. Reapply a light coat of Mono-Coat® 1909RB when required, to maintain desired release. To prevent buildup, avoid over-application.

Storage

Do not store at temperatures above 100°F/38°C. Keep container tightly sealed to prevent evaporation and/or moisture contamination.

Handling

We believe Mono-Coat® 1909RB 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® 1909RB is available in 1-gallon (4-liter), 5-gallon (20-liter), 30-gallon 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.