

# Mono-Coat® 1930RB

## Semi-Permanent Release Agent

Mono-Coat® 1930RB is a solvent-based release system that provides minimal transfer of the release agent to molded parts, high-temperature stability and abrasion resistance of the release film and virtually no buildup on molds when applied according to instructions.

### Typical Properties

Appearance	Clear fluid
Density, lbs/gal; kg/l	6.51; 0.78
Flash Point	54°F/12°C
Storage Stability, unopened	12 months

### Recommended Uses

**Rotational Molding:** Designed for superior release of crosslinked polyethylenes.

**Rubber Molding:** Ideal for low durometer/high flow rubber stocks other than silicone rubber.

### Application

Mono-Coat® 1930RB can be applied to either a hot or a cold mold. For best results, Mono-Coat® 1930RB 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. To pre-treat or condition the clean mold, apply Mono-Coat® 1930RB 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® 1930RB film and will provide the maximum number of releases per application.
3. If spraying, use conventional spray equipment and hold spray tip 4-10"/10-25 cm from surface. Use a light even spray. If wiping the mold, use a clean, lint-free, cotton cloth. Only a thin, wet film is required and because Mono-Coat® 1930RB dries rapidly, care should be taken to avoid reapplying

release agent over areas already covered. As with spray application, apply at least three, uniform, thin coats and allow 5-10 minutes between applications. Cure as recommended above. Begin molding.

4. Reapply a light coat of the Mono-Coat® 1930RB 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® 1930RB 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® 1930RB is available in 1-gallon, 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.