

## McLube 1711L

### DRY, COLORLESS RELEASE AND ANTISTICK COATING FOR HOT MOLD SURFACES

#### PRODUCT DESCRIPTION

McLube 1711L is a solvent based, dispersion of solid active ingredient exhibiting low friction and excellent antistick / release characteristics. The product, recommended particularly for application to heated surfaces, furnishes a dry colorless coating, which is effective for releasing rubber and plastic compounds and providing multiple release cycles without transfer to molded parts and with no buildup on the mold. The coating is identical to that obtained with McLube 1700L which is recommended for application to surfaces below 150<sup>0</sup>F. McLube 1711L is particularly effective for release of silicone and fluoroelastomers.

#### TYPICAL PRODUCT DATA

Color and Appearance.....	White, translucent dispersion
Dispersion medium.....	Solvent mixture-heptane, ethanol butyl acetate, propyl cellosolve
Specific Gravity.....	0.83
Weight per gallon (lbs).....	7.6

#### KEY PERFORMANCE PROPERTIES

- Effective for all types of rubber and plastics compounds
- Particularly recommended for silicone and fluoroelastomers
- Clean, dry, colorless, and non-oily
- Contains no oil, grease, stearates, waxes or silicones
- Requires no curing step
- Will not transfer to molded part
- Will not lead to build-up on the mold
- Will not interfere with post-furnishing operations
- Will not cause knit lines on molded parts
- Gives multiple releases per application
- Chemically and thermally stable
- Usable to 500<sup>0</sup>F
- Leads to increase productivity and reduced scrap rate

Cont'd.....2

## **USES**

Release coating for a wide variety of elastomers and plastics

- Particularly effective for Silicone Rubber & Fluoroelastomer compounds
- Natural rubber, SBR, EPDM, TPE, polyurethanes, etc.
- Polyesters, nylons, ionomers, phenolic, vinyls, acetates, melamines, etc.

Release coating useful on many types of molds

- Metallic, Epoxy, Elastomeric, Urethane, Ceramic, etc.

Release coating useful for a broad range of processes

- Injection, Compression, Transfer, Reaction Injection Molding
- Potting, Laminating, Encapsulating, Masking
- Filament Winding

## **MOLD PREPARATION**

To ensure optimum release results, mold surfaces must be cleaned thoroughly and dried prior to molding. All traces of previously used release agents should be removed. A solvent such as acetone, or toluene can be employed for mold cleaning. It is important to exercise care in handling of flammable solvents such as acetone and toluene. If measurable buildup of resin and / or old release agents has occurred, it may be necessary to abrade the mold surface to remove the contamination. A subsequent solvent wash is then recommended.

## **APPLICATION METHODS**

McLube 1711L is intended for use as received. Since McLube 1711L is a dispersion of solid particles, which settle on standing, the product must be mixed prior to and periodically during use. Conventional application methods can be used – spraying, dipping, wiping, and brushing. On a fresh mold, application of two coats is suggested, allowing for solvent to evaporate prior to applying the second coat. For the first few cycles, coating the mold each cycle is suggested. Subsequent to this break-in period, several cycles should be obtainable for each application of release coating.

## **SAFETY AND HANDLING**

The precaution to be observed in handling McLube 1711L are those related to the solvent mixture, in the product. These solvents are flammable, and thus, the product should be kept away from heat, sparks and flames. Adequate ventilation should be employed, especially in enclosed areas. The active ingredient is essentially nontoxic, but heating it above 550<sup>0</sup>F, may cause formation of potentially harmful substances. Smoking should not be permitted while using McLube 1711L, and contamination of tobacco products should be avoided.

## **PACKING**

McLube-1711L is available in 400 ml Aerosol Spray Can.