

Release Agent Mikon® 305

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Description:

Release Agent Mikon® 305 is a solvent-based universally applicable mould release agent for the processing of thermoset resins. Thanks to contained slip additives, it is especially suited when highly complex moulds are being used. The moulded parts exhibit a high gloss surface finish. Since Release Agent Mikon® 305 adheres strongly to the mould, the product allows for straightforward post-processing of moulded parts.

Application Fields:

Release Agent Mikon® 305 is generally suited for the processing of thermoset resins, such as polyester, epoxyd and phenolic resins. It has been proven to be particular effective in the processing of prepreg sheets. Depending on individual production conditions, we recommend additional use of our Sealer Mikon® 199 to enhance release performance.

Application:

Release Agent Mikon® 305 should only be used in well ventilated areas.

Cleaning:

Make sure that moulds have been thoroughly cleaned prior to the application of Release Agent Mikon® 305. Our Cleaners from the Mikon® product family will be sufficient. Depending on the degree of contamination, we recommend to further use a fast-evaporating solvent to ensure all residues of fat and wax have been eliminated.

Sealing:

New moulds or moulds with a porous surface need to be sealed with an appropriate mould sealer prior to the application of Release Agent Mikon® 305. We recommend using our Sealer Mikon® 199 which is ideally suited for the subsequent application of our classic semi-permanent mould release agents of the Mikon® product series.

Base coat:

Apply Release Agent Mikon® 305 with the help of a wet, yet not dripping clean lint-free cotton cloth. We recommend treating a small area of approx. 1 m² first. Excess of release agent is absorbed with a second clean cloth after approx. 15-20 s, accompanied by wiping in circular motion until a clear and dry film emerges. Proceed by treating the adjacent mould areas until all parts of the mould are evenly coated. According to our experience, best results will be obtained if treatment starts along the outer border of the mould, approaching the inside. In order to guarantee a smooth and homogenous base coat, we recommend applying 4-5 layers of Release Agent Mikon® 305, considering a curing time of approx. 5 min between each application. After application of the final layer, allow the product to cure for 5-15 min.

Mould touch-up:

An initial touch-up after 5-6 demouldings usually results in good conditioning of the mould. Since the release-active film wears during production, touch-ups are required frequently. The appropriate application interval has to be determined in on-site trials as it depends on individual production conditions. We strongly recommend to refresh the release film prior to an observed decrease in release performance, thereby allowing for a constant high product quality and enhanced mould lifetime.

Regulatory information on safety and transportation is provided in the material safety data sheet.

Technical product information and data is based on the best information available and does not constitute or imply a warranty or patent infringement of any kind. The user is responsible for testing product suitability prior to product use in production. The data mentioned above do not constitute viable parts of a specification, for which further, separate agreements are necessary.



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Release Agent Mikon® 305 can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. However, touch-up of the complete mould is recommended.

Partial release film repairs:

In case of a partial drastic decrease of release performance, the release film should be repaired in the affected area. In order to do so, remove the worn release film approx. 10 cm around the defect area by means of soft abrasion using an appropriate solvent. Ensure that the mould's surface is thoroughly cleaned prior to application of a fresh base coat in the respective area in order to guarantee sufficient adhesion of the compensating layer to the mould. Grounding is done as described above (Base coat). Even release of the moulded parts will be maintained if the repaired area is touched-up after each release for the first 4-6 demoulding cycles after the repair.

Technical Data

| | |
|------------------------------------|------------------------------|
| Composition: | mixture of resins in solvent |
| Appearance: | colourless liquid |
| Density [g/cm³]: | approx. 0.76 |
| Flashpoint [°C]: | < 0 |

Packaging:

| | |
|------|---------|
| Can | 22.8 kg |
| Drum | 152 kg |

Storage:

This product should be stored in tightly sealed containers and has to be protected from frost, heat and direct sunlight. If these rules are obeyed, the product can be stored for at least 24 months. The expiry date is stated beneath the production date on the labels of each container.

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