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MOLD RELEASE MR 205

MR 205 is a heat stable, non-carbonizing, non-oily film in a solvent blend designed for optimum surface wetting. MR 205 is effective in providing a durable parting film which releases epoxies, melamines, methacrylates, phenolics, plastisols, polyesters, polyurethanes, silane molding compounds, silicone glass, laminates, glues, and other plastics and products which are sometimes difficult to release. MR 205 will neither discolor the molded parts nor support combustion.

MR 205 can be applied by brushing, spraying, wiping or dipping. The mold surface should be cleaned before application. The best parting is obtained when applied in a very thin film. Excess application should be avoided since thick films of MR 205 do not give good release but may even cause sticking. The resultant sticking is often solved by rubbing out the dry release film until a thin film is obtained by washing the mold with a suitable solvent such as trichlor, zylene, toluol, or V M & P naptha.

After application, MR 205 should be allowed to dry until completely free of solvent. On hot molds this will take place immediately. Although not essential, a heat cure produces better release and durability of the parting film. A single application may remain effective through numerous molding cycles. For permanence, the mold should be given a short cure at 200° F - 400°F prior to use.

Contains no dimethyl silicone fluid.

On new molds with porous surfaces, several applications may be required to break in the mold. Use only the minimum amount.

Should dilution be desired, thin with a solvent such as V M & P. naptha, toluene or trichlor.

CAUTION: MR 205 is not pre-baked and may sometimes interfere with painting or cementing of the molded parts. If tests show that this problem exists, the surface may be prepared by sanding, sand blasting, or buffing with steel wool.

A NON DIMETHYL SILICONE RELEASE AGENT FOR MANY TYPES AND SHAPES OF PLASTIC PARTS.

EPOXIES
CROSS LINKED POLYETHYLENE
PHENOLICS
MELAMINES
POLYESTERS
POLYPROPYLENE

PAINTABILITY

Because MR 205 contains no DiMethyl Silicone fluid, MR 205 will not interfere with painting or cementing of plastic parts.

ALL PROCESSES OF MOLDING

ROTOCAST
INJECTION
BLOW MOLDING
CASTING
VACUUM
RIM

OPTIMUM SURFACE WETTING

A specially balanced formula that enhances the flow properties of MR-205.

APPLICATION

1. Mold surface should be cleaned before applying.
2. Spray, brush, wipe or dip apply MR 205. Best parting is obtained when a thin film is applied.

CAUTION: Excess application may cause sticking, use sparingly.

3. Prebake release agent at 200 - 400° F for 5 minutes before using. On new molds several applications may be required to break in the mold. Once a mold is broken in, pre-baking is not necessary.

Should dilution be required use V M & P Naptha, Toluene, or Trichlor.