



Mono-Coat® E150 N-ODS

Semi-Permanent Release Agent

Description

Mono-Coat® E150 N-ODS is a semi-permanent, solvent-based release system especially for molding operations that require a high degree of slip. This formulation provides low transfer of the release agent, high-temperature stability and abrasion resistance of the release film, multiple releases and contains no Ozone Depleting Substances (ODS). The product has excellent film-forming characteristics on both hot and cold mold surfaces.

Typical Properties

Appearance	Clear liquid
Density, lbs/gal; kg/l	6.47; 0.78
Flash Point, °F/°C	52/11
Storage Stability	12 months

Recommended Uses

Rubber Molding

Compression, transfer, and injection of typically difficult-to-mold compounds such as those based on peroxide cured EPDM and fluoroelastomers.

Composite/Laminate Molding

Any based on epoxy and phenolic resins.

Application

Mono-Coat® E150 N-ODS can be applied to either a hot or a cold mold (ambient to 370°F/188°C). For best results, Mono-Coat® E150 N-ODS 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 suitable solvent and let air dry.
2. If spray application is preferred, use conventional spray equipment and hold spray tip 4-10"/10-25 cm from mold surface. Mono-Coat® E150 N-ODS may also be wiped on the mold. If wiping, we recommend using soft, clean cotton cloths to avoid contamination.
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® E150 N-ODS in a well-ventilated area. Apply at least three, uniform, thin coats and allow 5-10 minutes between applications. Heating 10-15 minutes at 200°F/93°C or the molding temperature, whichever is higher, will improve the durability of the Mono-Coat® E150 N-ODS film and provide the maximum number of releases per application. Begin molding.
5. Reapply a light coat of Mono-Coat® E150 N-ODS, when required, to maintain desired release. To prevent buildup, avoid over spraying.

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® E150 N-ODS has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Safety Data Sheet.

Packaging

Mono-Coat® E150 N-ODS is available in a variety of package sizes. Please contact Chem-Trend customer service for details.

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.

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.