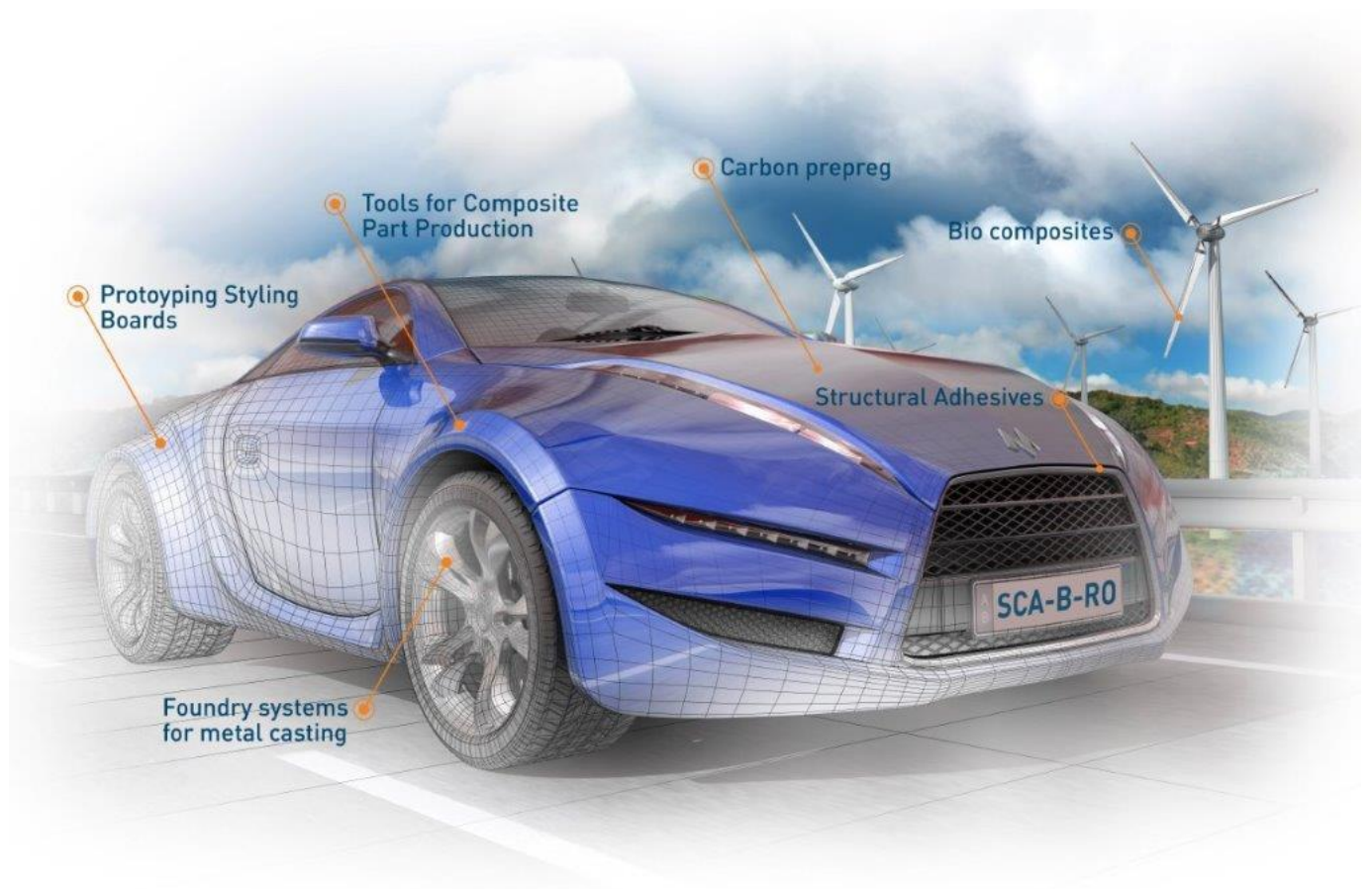




TECHNICAL DATASHEET

Release Agent W-64+



MALLENBOUW | COMPOSITEN | LIJMEN

Release Agent Mikon® W-64+

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Description:

Release Agent Mikon® W-64+ is a water-based semi-permanent release agent enabling a straightforward processing of thermoset resins. Due to its well-balanced composition, Release Agent Mikon® W-64+ provides superior release properties and excellent adhesion to the mould's surface. Downstream processing, such as gluing or varnishing, is possible without the need for any further treatments since Release Agent Mikon® W-64+ does not transfer to the moulded parts. The product provides a high gloss surface finish. When Release Agent Mikon® W-64+ is used in production there is no need for any initial mould sealing. The release film is temperature stable up to 450°C (842°F).

Application Fields:

Release Agent Mikon® W-64+ is universally applicable on porous surfaces and releases all commonly used thermoset resins, such as polyester, epoxy and phenolic resins and PUR gelcoats. Especially if processing standards demand a high slip, Release Agent Mikon® W-64+ will be the perfect match.

Application:

Cleaning:

It is recommended to thoroughly clean and dry mould surfaces prior to the application of Release Agent Mikon® W-64+. Our Cleaner Mikon® R-52 will be sufficient. However, Release Agent Mikon® W-64+ is also suitable for touch-up coatings.

Base coat:

Green or freshly repaired moulds can directly be coated with Release Agent Mikon® W-64+. Any initial mould sealing is not required.

Apply Release Agent Mikon® W-64+ by wiping with a soaked, but not dripping, clean lint-free cloth. Commence by applying the release agent to a small surface area of approx. 1 m². After about 30-60 s, when the film is still moist, use a second dry cloth to absorb excess of Release Agent Mikon® W-64+ and proceed by wiping in circular motion until a clear and dry film emerges. In the case of occurring streaks or smears reduce the time before wiping off excess of release agent. We recommend beginning to wipe along the mould's outer border, approaching the inside. This procedure is repeated with the adjacent areas until all parts of the mould are evenly coated. In order to obtain a smooth and homogenous base coat, 2-3 layers of Release Agent Mikon® W-64+ have to be applied. Allow each layer to cure for about 10 min. After the final layer has been applied, Release Agent Mikon® W-64+ should be allowed to cure for about 15-30 min at 60 °C.

Mould touch-up:

Good conditioning of the mould will be achieved if the release agent film is refreshed 2-4 demoulding cycles after the initial base coating process. Since the release film wears during production touch-up coatings should be applied frequently. Release Agent Mikon® W-64+ has been designed to incorporate and chemically bond touch-up layers of itself. Hence, curing time after touch-up reduces to approx. 15 min at room temperature. The required frequency of touch-ups for sufficient release depends on mould configuration and abrasion parameters and must be determined in individual on-site trials. We highly recommend to apply the touch-up prior to an observed decrease in release efficiency. This will significantly reduce mould fouling due to build-ups and lead to extended mould service lives while ensuring a constant high quality of the moulded parts.

Release Agent Mikon® W-64+ can also be touched-up partially, refreshing the release agent film only on those mould areas experiencing higher wear. Touch-up of the complete mould is preferred, though.

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.



Viernheimer Str. 70-76
 D-69469 Weinheim
 Postfach 10 07 29
 D-69447 Weinheim

Tel +49 (0)6201/99 83-0
 Fax +49 (0)6201/99 83-66
 info@muench-chemie.com
 www.muench-chemie.com

Bankverbindungen Weinheim:

Deutsche Bank AG
 BLZ 670 700 24
 Kto. 586 896 300
 Swift Code/BIC: DEUT DE DB 670
 IBAN: DE84 6707 0024 0586 8963 00

Volksbank eG
 BLZ 670 923 00
 Kto. 1 078 801
 Swift Code/BIC: GENO DE 61 WNM
 IBAN: DE40 6709 2300 0001 0788 01

Partial release film repairs:

Occasionally, a partial, drastic decrease in release performance might occur, requiring partial repair of the coating. In order to do so, the worn release film has to be removed completely 10 cm around the affected area with the help of soft abrasion, accompanied by wiping with solvent. Make sure 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:	aqueous emulsion of synthetic resins
Appearance:	cream-coloured liquid
Density [g/cm³]:	approx. 1
pH-value (20°C):	approx. 4

Packaging:

Can 5 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 12 months. The expiry date is stated beneath the production date on the labels of each container.

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Zertifizierungsstelle: TÜV RHEINLAND

Viernheimer Str. 70-76
D-69469 Weinheim
Postfach 10 07 29
D-69447 Weinheim

Geschäftsführer: Wilhelm Münch, Michael Münch
Amtsgericht Mannheim HRB 431102

Tel +49 (0)6201/99 83-0
Fax +49 (0)6201/99 83-66
info@muench-chemie.com
www.muench-chemie.com

USt.-IDNr. DE 144497299
Steuer-Nr. 47020/10016

Bankverbindungen Weinheim:

Deutsche Bank AG
BLZ 670 700 24
Kto. 586 896 300
Swift Code/BIC: DEUT DE DB 670
IBAN: DE84 6707 0024 0586 8963 00

Volksbank eG
BLZ 670 923 00
Kto. 1 078 801
Swift Code/BIC: GENO DE 61 WNM
IBAN: DE40 6709 2300 0001 0788 01