

TECHNICAL DATA SHEET: ACMOScoat 82-9062

Range of application:

Semipermanent Release Agent for UP/EP resins

Properties:

Solution of active ingredients in a mixture of solvents

Physical and chemical properties:

Form:	liquid	
Appearance:	colourless	
Smell:	solvent	
Density at 20° C:	0,71 g/ml	DIN 51757
Active substances:	1,30	
Flashpoint:	< 21 °C	EN ISO 13736
Viscosity at 20° C:	< 15 sec	Flow cup 4mm DIN EN ISO 2431
Cold and heat stability:	stable for 48 h	[24 h / - 18°C and 24 h / + 37°C]

Stockage:

Storage temperature: between 10° C and 30° C

Maximum storage: approx. 6 months

Processing:

Do not store outdoors. Protect from heat and cold. Container is pressurized. Open with care. Allow products to reach room temperature before use. Do not leave container open.

Bremen, 31.08.2012



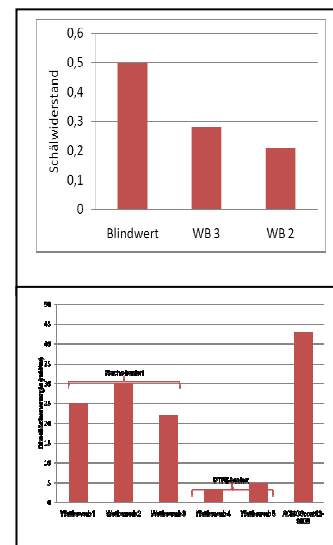
All information of this data sheet correspond to the formula. The values mentioned are standard guidelines and have been ascertained or calculated by stated measuring methods. They do not replace any specification. Errors excepted. Additional information can be found in the ACMOS EU safety data sheet.

ACMOSCoat 82-9062

Sprayable and wipeable, semipermanent release coating for reactive resins

Properties

- Good wetting on cold mould surfaces (min. 20 °C) and perfect release
- Negligible transfer of the release coating onto demoulded parts
- Parts get a high surface energy for better post treatment abilities
- Low mould build-up, strong adhering coating
- Polymerising temperatures from 50 - 200 °C
- High temperature resistant mould coating (max. 250 °C)
- Optional use in combination with Sealer ACMOScoat 82-9100



Processing

Moulds must be cleaned carefully from release agent, dirt and grease remainders before first use. We recommend to use ACMOSOL 130-22 mould cleaner after mechanical cleaning. A proper and resistant release film can only be created on clean mould surfaces. Upon first use three coats will be applied thin and homogenous with a clean and lint-free cloth onto the mould surface. Mould temperatures exceeding 60 °C require spray application. Keep a curing time of 5 – 10 minutes between the coats.

Finally please allow the coating to polymerize:

Mould temperature	20 °C	Polymerisation time:	approx. 30 minutes
	50 °C		approx. 15 minutes
	above 100 °C		approx. 3 minutes

Now the mould is ready for filling with Prepreg, SMC, BMC or other thermoactive resin systems. Upon decreasing release power please re-apply one or two layers of ACMOScoat 82-9062 onto the hot mould (so-called "Touch-Up") and give it another 3 – 30 minutes curing time, please see table above!

ATTENTION: containers are under protective gas. After first use please process the whole content within 2 weeks to prevent degradation of the active ingredients. Open for short time only and close tightly every time.

Storage

Ideal temperature: between 10 °C and 30 °C, dont leave container open. Shelf life: approx. 6 months.

Additional information can be found in the ACMOS EU safety data sheet.

Our Sales and Technical Department are always at your disposal to answer technical queries.

Bremen, 28.11.2011

All information given is accurate to the best of our knowledge but do not exempt from your own tests with regard to its aptitude for the intended purposes. Application, use and processing are done outside our control and must therefore be exclusively the responsibility of the end user.