



**WATERWORKS**

## Departure – Solvent-Free Semi-Permanent Release Agent



A Chem-Trend Brand

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### Description

Departure release agent has been specifically formulated to meet the high performance requirements of the Advanced Composites industry by providing consistent, effortless releases with minimal buildup on the mold. Departure chemically bonds to the mold surface and with correct application minimizes transfer to the part or other processing equipment surfaces. Departure pre-saturated wipes are engineered to deliver release agent to the surface without risk of over-application. The applicator cloth holds the product well (eliminating rapid evaporation) and distributes a fine dispersion of droplets across the mold surface, providing easy control and complete coverage

### Departure Benefits

- Thermal stability: 260°C (500°F)
- Easy application by spraying or wiping
- Very low odor – solvent-free
- Non-flammable
- Eliminates porosity by improving resin flow

### Uses

Departure was specifically developed for releasing thermosets, thermoplastics and prepregs. Departure is suitable for all manufacturing processes used in molding and bonding advanced composite structures.

### How To Use

Before applying Departure:

All previous surface treatments, residues, waxes or oils should be removed using Fresh Start or another Zyvox® mold and part cleaner. The mold should be properly sealed with a Waterworks or Zyvox® mold sealer according to the technical data sheet.

1. Lightly mist the mold surface with a hand-sprayer or wipe-on a thin, even layer of Departure to the mold surface.
2. If the mold surface is below 80°C (180°F) - wait approximately 60 seconds and wipe off with a clean, dry wipe. Continue wiping until the material is evenly distributed. If the mold surface above 80°C (180°F) – do not wipe off. Apply in sections; overlap slightly when covering multiple areas.
3. Let cure for 15 minutes.

4. Apply a second coat of Departure in the same way, and wait for a minimum of 30 minutes before the layout of materials. **DO NOT RE-USE DISCARDED WIPES.**
5. For touch-ups, apply a single coat of Departure as above and allow 30 minutes for cure before using the mold.

### Safety Data

Material safety data sheets for all Zyvox® products are available at [www.zyvax.com](http://www.zyvax.com) and should be consulted prior to use of product.

### Storage & Shelf Life

Store product between 5°C and 30°C (41°F and 86°F). Shelf life is 18 months from the date of manufacture, in the original unopened container. When using pre-saturated wipes, make sure that the container lid closes securely in place so that evaporation does not occur to the remaining wipes.

### Use Life

Use life of product is 60 days from opening of container. Product must be kept in the original container and the lid replaced immediately after dispensing. Outside of the container, pre-saturated wipes should be used within 10 minutes. After opening, product should continue to be stored properly.

**WARNING:** *Never puncture any Zyvox® product container.*

*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*

