



PRODUCT DATA

Mono-Coat® E150-N-ODS

Semi-Permanent Release Agent

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 mos.

Recommended Use

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 overspraying.

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 Material Safety Data Sheet. Since Mono-Coat® E150 N-ODS is a flammable material, caution should be taken when handling this product.

Packaging

Mono-Coat® E150 N-ODS is 1-gallon (4-liter), 5-gallon (20-liter) and 55-gallon (208-liter) containers

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.

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.