



Product Information

www.miller-stephenson.com

ReleaSys™ 8500 Semi-Permanent Mold Release Agent

Description:

ReleaSys™ 8500 is a highly versatile water-based, semi-permanent mold release agent designed to exhibit superior durability, surface adhesion, and minimization of slip-stick. Properly applied, our product develops a long lasting thin-film on the mold surface with minimal mold build-up. ReleaSys™ 8500 will not interfere with post-production finishing operation. Benefits of this product include:

- Exceptional release agent durability
- Clean, Non-oily, Non-migrating
- Ideal for lower complexity molds
- Improves quality and consistency of molded parts
- Minimizes mold build-up and fouling

Release Agent Applications:

ReleaSys™ 8500 is formulated to provide unmatched utility in injection and transfer molding with the following materials

- Plastics
- Fluoroelastomers
- Acrylics
- Elastomers
- EPDM
- Epoxy

Recommended Application Procedure:

1. Clean mold surface thoroughly. Mechanical cleaning such as plastic bead media blasting, followed by chemical cleaning, provides the best surface for application. Removal of all previous mold release agent and contamination is critical.
2. ReleaSys™ 8500 can be applied by any spray equipment that can produce fine atomization and deposit a uniform, thin film. Apply lightly to a hot mold approximately 6-8 inches from the surface.
3. Allow ReleaSys™ 8500 to cure for approximately 3-5 minutes at normal operating temperatures (minimum 132 °C). Multiple light coats can be applied, however this is not normally necessary.

Reapplication:

1. When release becomes hesitant, immediately reapply one coat of ReleaSys™ 8500 in the same manner as described previously. Spot touch-ups can also be done on known high wear or geometrically strained areas.

Physical Properties:

Primary Polymer:.....Thermoset Polysiloxane
 Appearance:.....White Emulsion
 Odor:.....None
 Specific Gravity:.....1.0 g/mL @ 25°C
 Flash Point:.....None

Storage and Handling:

ReleaSys™ 8500 should be stored in a well ventilated area which is cool and dry. Do not expose to freezing temperatures. Prior to use, container should be lightly agitated; avoid high shear/high rpm mixing.

ReleaSys™ 8500 should not be used at temperatures above 250 °C or near open flames. Chemical breakdown will occur which will result in the generation of toxic fumes. When spraying, avoid inhalation of mist and exposure to skin. Always wash hands after handling.

Shelf-Life

ReleaSys™ 8500 has a shelf life of 6 months from the date of shipment

ReleaSys™ Product Line:

Miller-Stephenson's offers a selection of high performance water-based, semi-permanent release systems to meet your mold process needs. All variants of the ReleaSys™ Series will deliver higher productivity, lower rejection rates, and higher quality products.

ReleaSys™ Series	Slip	Durability	Releases per Application
8500	●●●	●●●	●●●
8800	●●●●	●●●●	●●●●
8200	●●	●●●●	●●●●

1591-7K

For further technical information call 800.992.2424 or 203.743.4447
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