

<u>Problem</u>	<u>Cause</u>	<u>Solution</u>
Complete failure to obtain release	> Improperly cured ReleaSys	• Mechanical clean mold followed by chemical cleaning; reapply ReleaSys
	> Mold insufficiently cleaned prior to application preventing ReleaSys from bonding	• Thoroughly clean mold with bead blasting followed by cleaning with a solvent or high pH detergent. Reapply ReleaSys.
	> Phase-separation of ReleaSys as a result of over agitation or mixing	• Examine ReleaSys; If separation occurred replace with fresh material
Poor Release in strained molding areas	> Lack of slip due to mold geometry application angle	• Apply one or two extra coats of ReleaSys initially; Re-apply touch-up coats to these areas more frequently
Good release but build-up of ReleaSys on mold surface.	> Over-application of ReleaSys	• Thoroughly clean mold and re-apply ReleaSys in lighter coats; Adjust spray gun to dispense lower volume
Good release but parts exhibit blemishes or oily patches	> Over-application of ReleaSys	• Thoroughly clean mold and re-apply ReleaSys in lighter coats; Adjust spray gun to dispense lower volume
	> Insufficient cure time	• Apply lighter coats of ReleaSys and increase cure time allowed and/or increase cure temperature
Inability to achieve multiple releases	> Micro-porosity present in mold	• Clean mold; apply 4-5 coats of ReleaSys to seal mold surface allow for extended cure times on the first 2 coats.
	> Mold insufficiently cleaned prior to application preventing ReleaSys from bonding	• Mechanical clean mold followed by chemical cleaning; reapply ReleaSys
	> Improper application; non-uniform coverage	• Clean mold; apply light coats of ReleaSys with 50% overlapp between passes.
Poor release and/or small particles of molding material left on mold surface.	> Micro-porosity present in mold	• Clean mold; apply 4-5 coats of ReleaSys to seal mold surface allow for extended cure times on the first 2 coats.