

## ReleaSys™ 85

### Semi-Permanent Mold Release Agent

#### Description:

ReleaSys™ 85 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. The aerosolized formula ensures proper application is achieved without the need for spray equipment. ReleaSys™ 85 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
- RoHS2 and RoHS3 Compliant

#### Release Agent Applications:

ReleaSys™ 85 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. Shake can lightly and hold approximately 6-8 inches away from the heated mold surface. Apply a light coat or release agent. NOTE: ReleaSys™ 85 must be applied to molds at temperatures greater than 212°F/100°C.
3. Allow ReleaSys™ 85 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:

When release becomes hesitant, immediately reapply one coat of ReleaSys™ 85 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 @ 77°F/25°C
Flash Point	None

#### Storage and Handling:

ReleaSys™ 85 should be stored in a well ventilated area which is cool and dry. Prior to use, can should be lightly agitated.

ReleaSys™ 85 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™ 85 has a shelf-life of 6 months from the date of shipment.

**Safety Data Sheet (SDS) is available upon request.**

#### ReleaSys™ Product Line:

Miller-Stephenson 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
85	●●●●●	●●●●●	●●●●●
88	●●●●●	●●●●●	●●●●●
89	●●●●●	●●●●●	●●●●●
82	●●●●●	●●●●●	●●●●●

**LIMITATION OF LIABILITY AND REMEDIES:** Manufacturer warrants that, at the time of shipment by the Manufacturer, this product is free from defect in material and manufacture. If the product is proved to be defective, the exclusive remedy, at Manufacturer's option, shall be refund of the purchase price or replacement of the defective product, provided written notice of the defect is given no later than one year after the date of shipment by the Manufacturer. Manufacturer shall not otherwise be liable for loss or damages whether direct, indirect, incidental or consequential, regardless of the legal theory asserted, including negligence and strict liability. **Manufacturer expressly disclaims all implied warranties, including the implied warranty of merchantability and the implied warranty of fitness for a particular purpose. There are no warranties which extend beyond the description on the face hereof.**