Technical Data

RBR100

SEMI-PERMANENT RUBBER RELEASE AGENT

Ambersil RBR100 is a specially formulated release coating for use in a wide variety of rubber moulding applications. When the coating is applied correctly to a pre-heated mould surface to form a thin, inert and thermally stable coating, multiple releases of all natural and synthetic polymers (except silicone elastomers) can be expected.

ADVANTAGES

- Fast curing
- Lower mould build-up
- Non-flammable
- Easier release
- Reduced reject rates
- Maximum multiple release
- Releases all rubber compounds except silicone elastomers

MOULD PREPARATION

New Moulds: Mould surfaces must be thoroughly cleaned and dried. All traces of previous release agents and moulding residues must be cleaned away. Ambersil Polyester Mould Cleaner is recommended for cleaning away these release agent residues.

Old Moulds: Some form of abrasion will probably be required (eg. grit, sand or glass beading) followed by a solvent wash with Ambersil Polyester Mould Cleaner.

APPLICATION

Ambersil **RBR100** can be applied by any of the following methods.

- Conventional Air Spray
- HVLP Spray
- Airless Spray

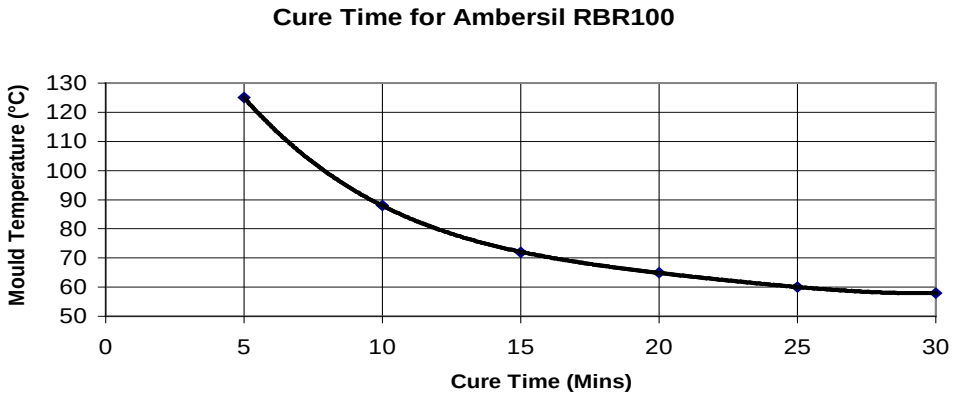
Ambersil **RBR100** is suitable for application directly onto heated moulds at temperatures up to 204°C (400°F) and moulds preheated to a minimum of 60°C (140°F).

Using a finely atomised spray pattern. Ambersil **RBR100** should be applied at a distance of 8-12" from the mould surface. Cure times can be calculated from the graph below. See (Figure 1 overleaf).

For hot (120-200°C) moulds, new or porous moulds apply a minimum of 6 coats for warm (60-120°C) moulds a minimum of 4 coats should be applied with special attention paid to avoiding emulsion accumulation and run marks due to over application.

Allow sufficient time for **RBR100** to cure prior to production.

Touch Up of the release coating.



A light touch up coating should be applied on areas where poorer release is noticed. This will effectively reduce the possibility of release agent or polymer build up. As with the initial application allow time for the coating to cure before resuming production. The frequency of touch up will depend on several factors including polymer type, mould design and any abrasion that may occur during part demould.

CHEMICAL & PHYSICAL PROPERTIES

Appearance	:	Milky liquid
Odour	:	Slight
S.G.	:	0.970 - 1.000 @ (20°C)
Flammability	:	N/Applicable
Flashpoint	:	N/Applicable
Boiling Point	:	100°C
Evaporation Rate	:	< 0.1 Reference : BuAc = 1pH:value concentrated
Solution	:	4.0 +/- 0.1
Solubility	:	Miscible with water. Insoluble in most organic solvents
Packaging	:	0.5L sample pack, 5L cans, 25L Available on request
Flammability	:	Non Flammable product

STORAGE

The product may be stored at normal ambient temperatures and has a shelf life of not less than 12 months with correct storage.

HEALTH AND SAFETY

Health and Safety sheet available separately.

TECHNICAL SERVICE

Ambersil provides a technical support service and maintains a constant programme of research and development. We are able to assist customers by specific product development to meet particular requirements.

MISREPRESENTATION ACT 1967 TRADE DESCRIPTIONS ACT 1968

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