

DuPont™ TraSys® 428

Mold Release Coating

Description

TraSys® 428 mold release coating is a water-based dispersion for hot mold applications. When properly applied to a mold, it exhibits outstanding durability and antistick properties and has a very low coefficient of friction. It is clean, nonoily, nonstaining, chemically inert, and can function in high temperatures.

TraSys® 428 mold release coating has unique properties, making it an excellent release agent for molded rubber, molded fluoropolymer, molded plastic, and epoxy and plastic laminates. Unlike oily release agents, when properly applied, it does not interfere with post-finishing operations.

TraSys® 428 comes pre-diluted and is ready for use. Proper application results in superior release, and multiple release is normal.

Uses

TraSys® 428 is ideal for compression, transfer, and injection molding of organic rubber compounds, functioning in molding temperatures exceeding 193°C (380°F). It also is ideal where part finish is critical, such as in the manufacture of O-rings and seals. It is not recommended for the molding of silicone elastomers.

Directions for Use

TraSys® 428 must be agitated before spraying. TraSys® 428 mold release coating should be sprayed on hot, clean, and dry surfaces. Properly applied, the coating will not be affected by water or most other materials that may come in contact with it.

Recommended Procedure

1. Clean mold thoroughly, using glass or plastic bead media or high pH detergent, to remove all prior mold release and other sources of contamination.
2. Use low-pressure spray equipment that provides a fine mist. After agitation, apply lightly to a hot mold, making certain that all areas of the mold are entirely coated.
3. Allow TraSys® 428 mold release to bake onto the mold's surface for 5 min at normal operating temperature (a minimum of 132°C [270°F]). Subsequent touch-up applications should also be baked on according to this procedure. This will give a bond between mold and coating that will ensure the most effective coating for durability and cycle life.

Note: Many companies attempt to schedule touch-up applications prior to shift change or before break periods, allowing TraSys® 428 to bake without losing productivity from the mold.

Typical Properties

Primary Polymer:	Thermoset Polysiloxanes
Specific Gravity:	1.0
Odor:	Slight
Color:	White
Flash Point:	None



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Storage and Handling

TraSys® 428 should be stored in a cool, dry, well ventilated area. Do not expose to freezing temperatures. Freezing will affect the physical condition, but will not damage the release effectiveness. Thaw at room temperature, and mix well before using.

Containers in use should be agitated before use and often during use. Drums will require a low rpm agitator to prevent phase separation in the storage container.

Breathing vapors should be avoided. If spraying, care should be taken to avoid inhaling mist or vapors, just as sprayed paint inhalation should be avoided.

Care should be taken not to expose TraSys® 428 mold release coating to open flame or intense heat. Temperatures above 260°C (500°F) may cause chemical breakdown, resulting in toxic fumes. Always wash hands after handling TraSys® 428 mold release coating.

Shelf Life

TraSys® 428 has a shelf life of 1 year from the date of manufacture. The date of manufacture and shelf life are posted on the container label.

Packaging

TraSys® 428 is available in 1-, 5-, and 55-gal containers. Larger volume orders may be packaged in specialty containers.

Shipping Limitations

None

For more information or technical assistance, call: (800) 441-9503
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