

# Mono-Coat® 1906RB

## Semi-Permanent Release Agent

Mono-Coat® 1906RB is a semi-permanent, general use solvent-based release system for rotation molding applications. Mono-Coat® 1906RB provides high-temperature stability as well as abrasion resistance on the release film. It also adheres to the mold surface and provides multiple releases with minimum transfer to molded parts. Mono-Coat® 1906RB leaves virtually no buildup on the mold when applied according to instructions.

### Typical Properties

Appearance	Clear colorless fluid
Density, lbs/gal; kg/l	6.00; 0.72
Flash Point, °F/°C	19.0/-7.2
Storage Stability, unopened	12 months

### Application – Highly Polished Molds

1. Thoroughly clean the area to be treated to remove any previous release agent or other buildup. Then wipe with a clean solvent or naphtha and let air dry.
2. Saturate (not dripping) a clean, 100% cotton cloth and wipe on a smooth continuous film. Apply to no more than a few square feet at a time.
4. When the film begins to evaporate at the edge (See **Notes:** below), wipe the surface with a second clean, dry, cotton cloth. Use a circular motion from the outside, working inwards until film is left dry and clear.
5. Continue working in this way until the entire mold surface has been coated.
6. Repeat this procedure 4 times, making a total of 5 coats, allowing 15 minutes between each coat.
7. Allow 30 minutes after the last coat for full cure at room temperature\*. Proceed with production.

### Application – Regular Finish Molds

1. Clean the mold as in the previous section
2. Apply a small amount of product to a clean, 100% cotton cloth and wipe onto the mold surface to form a glossy continuous film.
3. As soon as the wiping action appears not to be forming a film, add more Mono-Coat® 1906RB to the cloth, to ensure it wets the surface of the mold as described in step #2 above.
4. Continue working in this way until the entire mold surface has been coated.
5. Repeat this procedure 2 times, making a total of 3 coats, allowing 15 minutes between each coat.

6. Allow 30 minutes after the last coat for full cure at room temperature\*. Proceed with production

\* The mold can be mounted on the machine and put through a normal heat cycle instead.

### Notes:

Time will vary with room and mold temperature. Always wait and wipe off as the solvent begins to evaporate at the edges of the treated area.

### Touch-Up Coats:

Once in production the release film will begin to wear. Rather than applying a touch-up coat once the parts begin to stick, it is better to do preventative maintenance. For example, if trials determine that 20 releases are obtainable between touch-up coats, it is better to reapply a touch-up coat after every 15 cycles or at the end of every second shift if you are, for example, turning the molds 8 times per shift. The above described action will keep the molds in production longer and help establish a routine of quality preventative maintenance.

### Safety Data:

Material Safety Data Sheets are available for all Mono-Coat® products and should be consulted prior to use of the product.

### Packaging:

Mono-Coat® 1906RB is available in 1-gallon (3.8-liter), 5-gallon (20-liter) and 55-gallon (208-liter) containers. It is important that the materials be left in the factory containers as the product is susceptible to moisture contamination if the container is left open or the material is stored in the wrong type of container.

While the technical information and suggestions for use contained herein are believed to be accurate and reliable, nothing stated in this bulletin is to be taken as a warranty either expressed or implied.

#### Further Information

Request information on our complete range of materials: custom-formulated release agents for polyurethane molding; tire lubes and bladder coatings; Mono-Coat® semi-permanent release coatings; aerosol formulations; mold cleaners and sealers; specialized coatings and application equipment.