PRODUCTS
RAM COMPOSITE

TECHNICAL DATA

Print Date: 8/13/2012

87-08 BLUE Liquid MR 225

PRODUCT DESCRIPTION:

This product is a silicone free, heat stable, non-carbonizing release agent. The heat-cured film of MR225 Blue does not usually transfer nor migrate, so that painting, finishing, bonding or other secondary processing steps may be accomplished on molded parts without further treatment. MR225 Blue is thermally stable up to 900° F. Epoxies, phenolics, polyimides, polybismaleimides and polyester parts release freely from the mold on cures up to 900° F. Application instructions should be followed closely to obtain these results. MR225 Blue is designed for metal or non-metal tools. It is a clear liquid but may be colored on special order.

The blue dye will help with the liquid identification and application.

TYPICAL PHYSICAL CHARACTERISTICS (all tests at 77° F.)

Weight Per Gallon:	6.2 – 6.6 Pounds
Flash Point:	22° F.; Seta-flash Closed Cup
Shelf Life:	One year from date of shipment.
VOC per EPA Method 24:	6.23 lb/gallon or 747 gm/liter

APPLICATION SUGGESTIONS:

MR225 Blue may be applied over existing release agents by spray, brush or wipe-on. It works best when applied on a clean mold. Two coats applied in opposite directions give optimum results. Allow 15 minutes for solvent release before applying the second coat. When applying the second coat with a rag, make sure the rag is thoroughly saturated with MR225. Any dry spot on the rag could remove the first coat. After the second coat is applied, bake at 250° F. (120° C) for 60 minutes. New tools may require more than two coats. New tools should be heated to 250° F. before applying MR225. This will open the pores and allow the release agent to go into pores.

Removal Of Old Release Agent
Scrubbing with metal pads saturated with detergent is the best method for old release agent removal. Follow with a solvent wipe.

Resin Removal
Sanding is recommended for resin removal.

Transfer
Should MR225 transfer, use the metal pads, detergent and solvent wipe. Transfer usually indicates the MR225 was too heavily applied.