

## **ST - 3**

### **Semi-permanent water-based release agent**

#### **Description**

ST-3 is a semi-permanent water-based release agent.

Provides excellent release properties, and is particularly recommended in case of tricky operations of molding both of the rubber elastomers, both thermoplastic and thermosetting resins.

ST-3, when applied to a surface pre-heated forms a film inert, capable of a high thermal stability and with properties of multi detachment for both synthetic and natural polymers.

#### **Benefits**

- \* Water based and non-flammable \* very low VOC
- \* Effective with many types of compounds \* High thermal stability > 250 ° C
- Disconnections \* multiple \* Increase the efficiency
- \* Fast curing \* Minimum mold fouling
- \* No transfer of material \* Easy detachment

#### **Typical Physical Characteristics**

- \* Appearance white emulsion
- \* Flash point non-flammable
- \* Specific Gravity 1.00 + / -0.02
- \* Odor Slight
- \* Solvents water
- \* Coverage 10m<sup>2</sup> / lt. (Per application)

#### **Mode of use**

#### **Preparation of molds**

To get the full effect of the product, the molds have to be thoroughly cleaned and free of all traces of release agents used previously.

#### **New molds:**

Surfaces must be clean and dry. It should also remove all remaining traces of the previous release agents.

**Old molds:**

Clean the mold by abrasion followed by washing with solvent. This procedure will remove any residue of previous polymers or contamination.

**Application**

Apply ST-3SU molds preheated to a temperature between 60 ° C and 200 ° C with the traditional sitemi Airless Spray and Air Spray.

**Methodology recommended for the application of the product:****Note:**

- 1) In the case of new molds or in poor condition, always apply the product for at least 6 times.
- 2) Do not apply excessive amounts in order to avoid the formation of accumulations.
- 3) Follow the indicated time for crosslinking before starting the production.
- 4) If the mold can not be cleaned before application, give an extra hand after each of the first two printed.
- 5) For each hand observe the curing times indicated in the table before starting the production.

**Retouching:**

The patina of "touch-up" should be applied in areas where we see a gap variable. This will improve the effectiveness of the separation and reduce the possibility of a build-up of release agent. The frequency depends on the type of polymer, the configuration of the stampoe by the parameters of abrasion.

**Curing the final product:**

Depending on the temperature of the mold, it must wait for the product lattices in the following time: 4 minutes at 150 ° C, 10 minutes 100 ° C or 30 minutes at 60 ° C. The frequency of the retouching, depends on the type of polymer, the configuration of the mold and by the parameters of abrasion.

**Packaging**

Plastic drums of 10, 25 and 60 kg

**Storage**

Shelf life: 6 months from date of shipment when stored in sealed containers below 40 ° C