

EZ-PART® #13

SILICONE MOLD RELEASE

EZ-Part #13 is a solvent based solution of silicone polymers that dry to form an effective mold release film. It is an effective release agent for epoxy, urethane, and polyester resins as well as for many types of rubbers and thermoplastic polymers. EZ-Part #14 can be used on most mold materials including wood, epoxy, steel and aluminum. It is formulated with corrosion protection additives to help prevent the rusting of steel molds and application equipment.

EZ-Part 13 is effective for both room temperature and elevated temperature applications. It has reduced mold build up on released molds compared to competitive materials. It withstands temperatures in excess of 180°C without degrading and is suitable for use with Automatic Pressure Gelation (APG) systems.

HANDLING PROPERTIES	<u>VALUE</u>	<u>TEST METHOD</u>
<u>EZ-PART #13</u>		
Appearance	Clear to hazy Liquid	Visual
Viscosity	~5 cps	ASTM D-2393
Density	0.85 g/cm ³	ASTM E-201
Flash Point	>30°C	ASTM D-92
Solids Content	15% – 20%	

Values are based on laboratory or average production results – not for specification purposes.

PROCESSING AND APPLICATION INSTRUCTIONS

Thoroughly clean the surface to be released prior to applying the EZ-Part #13. Ensure surface is clean and dry prior to applying the parting agent. In most applications, the EZ-Part #13 is applied by spraying or wiping directly onto molds. Molds should be dried for at least 15 minutes to ensure evaporation of solvent from the release film.

For urethane and epoxy foam molds and for most wood molds, it is desirable to seal the mold surface prior to application of the EZ-Part #13 release agent. Our Pro-Prep HPS high performance sealer is ideal for this sort of mold sealing application. Conventional lacquer sealers may also work for some applications.

Shake or stir the EZ-Part #13 briefly prior to use to ensure that it is uniform. Then apply by spray, brush, or by wiping on with a clean cloth. For most Spray applications, a single thin coating is sufficient, but applying 2 coatings from different directions may be helpful if the mold surface is intricate or had significant undercuts. Allow at least 1-2 minutes between spray coats. For brush or wipe-on application use a clean brush or a clean, lint free cloth. For best results, apply 2 thin layers rather than 1 thicker layers of the release agent.

If the parts or mold will be used multiple times, it is typically only necessary to apply a single thin new coat between uses. EZ-Part #13 is resistant to mold build up, but if any is observed, it can

Product Datasheet



typically be removed with a Ketone solvent. It is also possible to dilute the EZ-Part #13 with 1 part Mineral Spirits to 1 part of the EZ-Part #13 to apply thinner layers that will slow the rate of release buildup.

De-molded parts will require thorough cleaning prior to staining, painting, or bonding as the residual mold release will prevent other materials from adhering to the surface properly. Ketone solvents and some aqueous detergents are effective for removing release residues. Contact SP&S for cleaning suggestions suitable for your specific parts and application.

PACKAGING AVIALABLE

This product is available in a wide range of package sizes including quart, gallon, and 5-gallons pails.

STORAGE GUIDELINES

Store the EZ-Part® #13 in a clean, dry environment in its tightly closed original containers. Store at 41°F – 86°F (5°C - 30°C). Tightly re-seal containers after use. If the recommended storage conditions are observed the products will have a minimum shelf-life of 24 months from the date of shipment.

HANDLING PRECAUTIONS

Mandatory and recommended industrial hygiene procedures should be followed whenever these products are being handled and processed. For additional information please consult the corresponding material safety data sheets.

EZ-Part® #13 - DANGER! FLAMMABLE Keep away from eyes, skin, and clothing. Wash skin and clothing thoroughly after handling. Avoid breathing vapor or mist and use with adequate ventilation. Keep containers closed when not in use. Do NOT take internally.

FIRST AID

In case of contact: Skin – Immediately wash skin thoroughly with mild soap and water. Remove contaminated clothing and wash before reuse. Destroy contaminated shoes and other articles made of leather. Eyes – Immediately flush eyes with plenty of water for 15 minutes and get prompt medical attention. Inhalation - Remove person to fresh air. Administer oxygen or artificial respiration if necessary. Call a physician. Ingestion - Do not induce vomiting. Dilute with plenty of water and contact physician immediately. Never give anything by mouth to an unconscious person.

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