



PRODUCT DATA SHEET FOR # 135T: TOTAL POLYMER RELEASE AGENT

PRODUCT DESCRIPTION

135T is a non-wax, non-silicone polymer based Release agent fortified with high temp polymers for high heat stability and accelerated exothermic heat releases in newer composites. It provides Multiple Releases for all Poly Ester Molds, Compression Molding, Vacuum Bagging and Resin Transfer Molding - RTM.

APPLICATION

This procedure can be used on New Molds, Reconditioned molds, tooling plugs or Release System Change Over. Some of these molds may have been sanded, compounded or polished.

CLEANING:

STEP 1: Pre-clean the mold with # 135-80, Polymer Cleaner & Wax Remover. Soak cloth with the product, apply it to surface, agitate and wipe while wet. Clean small areas at a time and continue in this manner and treat the entire mold.

STEP 2: Apply a 2nd thin and even coat of 135-80. Allow to dry and wipe gently. If there is a heavy wax build up, repeat the cleaning with # 135-80 till you are fully satisfied and mold is clean.

SEALING POROSITY:

STEP 3: For sealing porosity and to assure a better release, apply 4 coats of # 86, Seal Kote. Please allow each coat to dry thoroughly before applying the next coat. Wipe lightly between each coat so that you are leveling the material and not removing.

APPLYING THE MOLD RELEASE AGENT:

STEP 4: Apply 4 consecutive coats of # 135T, Semi-permanent Polymer Release Agent and allow each coat to dry a minimum of 10 minutes. **DO NOT WIPE.**

135T may be sprayed. If it is sprayed, wipe it lightly over the sprayed film to get a uniform coverage. To get best results use Turkish or terry cloth towels when applying # 135T. Apply it in a circular motion overlapping previous areas. Work product thoroughly over the mold creating a thin even coat. Check for uniform coverage.

STEP 5: Apply an extra coat of # 135T on all radiuses, corners and wells. Allow it to dry for 15 minutes and then wipe lightly to get an even coat.

STEP 6: Laminate or cast your first part.

STEP 7: Release the part. After this first release, reapply one more coat of #135T. Continue with multiple releases and reapply # 135T, as needed when the pull becomes a little hard.

NOTE: WE CANNOT STRESS ENOUGH THE IMPORTANCE OF THE MOLD BEING CLEAN PRIOR TO APPLYING THE RELEASE COAT. IN ADDITION, MAKE SURE EACH AND FINAL COAT IS DRY AND CURED PRIOR TO CASTING OR WIPING. WE RECOMMEND THAT EACH COAT OF WAX OR 135T BE THIN SO IT WILL DRY BETTER.

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| TYPICAL PHYSICAL CHARACTERISTICS |
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| Weight: | 7.25 lbs per gallon |
| Flash Point: | 45° F |
| Shelf life: | 1 year from date of shipment |
| V.O.C.: | 708.25 grams per liter |

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