



## Mono-Coat<sup>®</sup> 1919D Semi-Permanent Release Agent

### Description

Mono-Coat<sup>®</sup> 1919D is a semi-permanent, solvent-based release system especially for molding operations that require a high degree of slip. This formulation provides low transfer of the release agent, high-temperature stability and abrasion resistance of the release film, multiple releases and contains no Ozone Depleting Substances (ODS). The product has excellent film-forming characteristics on both hot and cold mold surfaces.

### Typical Properties

Appearance	Clear liquid
Density, lbs/gal; kg/l	6.47; 0.78
Flash Point, °F/°C	52/11
Storage Stability	12 months

### Recommended Use

Rubber Molding: Compression, transfer, and injection of typically difficult-to-mold compounds.

### Application

Mono-Coat<sup>®</sup> 1919D can be applied to either a hot or a cold mold (ambient to 370°F/188°C). For best results, Mono-Coat<sup>®</sup> 1919D should be cured on the mold at 200°F/93°C or the molding temperature, whichever is higher, to achieve the maximum number of releases per application.

1. Mono-Coat<sup>®</sup> 1919D should be applied to a clean mold. We recommend an initial bead blasting followed by a solvent wipe.
2. To pre-treat or condition a clean mold, apply at least three, light, even coats; allow a few seconds between each coat for solvent to evaporate. For best results, apply pretreatment coats at normal operating temperature. Use conventional air spray equipment and hold the spray tip approximately 12 inches/31cm from the mold surface.
3. Allowing a 15 minute final cure at 200°F/93°C or the molding temperature, whichever is higher, will improve the durability of Mono-Coat<sup>®</sup> 1919D film and will provide the maximum number of releases per application. Begin molding.
4. Reapply a light coat of Mono-Coat<sup>®</sup> 1919D, when required, to maintain desired release. To prevent buildup, avoid over-spraying.

### Storage

For best results, store between 55-80°F/13-27°C. Do not store at temperatures above 100°F/38°C. Keep container tightly sealed to prevent evaporation and/or moisture contamination. If stored in cold temperatures, allow product to warm to room temperature prior to use.

### Handling

We believe Mono-Coat<sup>®</sup> 1919D has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Safety Data Sheet.

### Packaging

Mono-Coat<sup>®</sup> 1919D is available in a variety of package sizes. Please contact Chem-Trend customer service for details.

#### Further Information

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

*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.*