Mono-Coat® RM-1910RP
Rotational Mold Primer

Description
Mono-Coat® RM-1910RP is formulated for priming, sealing and conditioning rotational molds. Appropriate substrates include steel, stainless steel and aluminum. When properly applied, Mono-Coat® RM-1910RP will increase the gloss level of the substrate, and will give improved application and release characteristics when used with the proper release agent. This mold primer is an excellent sealing material but should not be used as a mold release agent. The appropriate Mono-Coat® release agent should be applied on top of the primer after the material has been cured.

Typical Properties

Appearance	Clear-to-slightly yellow liquid
Density, lbs/gal; kg/l	6.98; 0.84
Flash Point	<40°F/4°C
Storage Stability, unopened	6 months

Application
1. Mechanically clean the mold as needed to remove existing layers of mold release and other surface contaminants (bead or dry ice blasting, for example.) The smoother the mold surface is after this step, the fewer the number of coats of Mono-Coat® RM-1910RP that will be needed to achieve the desired gloss level on the finished part.
2. Following the mechanical cleaning procedure, wash the mold thoroughly with clean water to remove any water-soluble contaminants remaining on the mold surface. Use liberal amounts of water then wipe dry with clean cloths.
3. After the water wash, apply a Chem-Trend mold cleaner to remove all traces of solvent-soluble components remaining on the mold surface. Use liberal quantities of mold cleaner in a well-ventilated area and wipe dry with clean cloths until the mold is clean.
4. The wiping cloth should be changed regularly to ensure that a clean, absorbent surface of the wiping cloth is always presented to the mold surface. This procedure prevents recontamination of the mold surface by the wiping cloths, which carry contaminants from the mold.
5. Next, apply the Mono-Coat® RM-1910RP by wiping using clean cotton cloths. For shiny/smooth molds, use a wipe-on/wipe-off technique. Wipe on an even coating and immediately wipe off with a separate, dry cotton cloth. For matte or textured surfaced molds, use a wipe-on/leave-on technique. The cloth should be wet but not saturated. The coating should be light enough to avoid runs and drips.
6. Allow 30 minutes between applications of each coat. The number of coats necessary will depend on the starting texture of the mold surface, the desired final surface finish and the technique used to apply the primer.
7. After the final coat, allow a minimum of 1 hour cure time at room temperature. The cure time may be reduced to 15 minutes by heating the mold with the applied Mono-Coat® RM-1910RP at a temperature of 120-140°F/49-60°C.
8. When the Mono-Coat® RM-1910RP has cured, apply Mono-Coat® mold release. Please refer to the proper Product Data/Application instruction sheet for mold release application details.

Cure Test for Mono-Coat® RM-1910RP
Under the best conditions, the Mono-Coat® RM-1910RP has been found to cure in as little as one hour. A simple test method for complete cure is as follows: Apply one drop each of water and a Chem-Trend mold cleaner onto a flange area which has been coated with the sealer. Wait a few seconds and wipe off with a clean tissue. If there is no evidence of the drops on the tool surface the sealer is completely cured.

Storage
Do not store at temperatures above 100°F/38°C. Keep container tightly sealed after each use to prevent evaporation and/or moisture contamination. Mono-Coat® RM-1910RP is flammable. Keep away from heat, sparks, flames and combustion sources during storage and use.

Handling
Wear solvent-resistant rubber gloves when applying the Mono-Coat® RM-1910RP. We believe Mono-Coat® 1909RB 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® RM-1910RP 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® 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.

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Chem-Trend L.P. | 1445 W. McPherson Park | Howell, Michigan 103015
Tel 517.546.4520 | U.S./Canada: 800-727-7730 | Fax: 517-548-5370 | ChemTrend.com