



## PTM&W Industries, Inc.

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# PA0864 & PA0868 Mold Release

## DESCRIPTION

PA0864 and PA0868 are mold releases designed specifically for releasing thermosetting urethane elastomers from either epoxy or metal tooling in production applications. These releases are specially formulated to provide glossy surface finishes and easy release with minimal buildup on the molds. What makes PA0864 and PA0868 unique is that either release can be removed from the urethane part with soap and water clean up. It is unnecessary to solvent clean or mechanically abrade the molded surface before painting or bonding.

PA0864 and PA0868 contain the same active ingredients in the same amounts. The difference in the products is that PA0864 is made with a high flash point (non-flammable) solvent, to be used on hot molds or where flammable solvents cannot be used. PA0868 is made with Hexane solvent, for fast evaporation and short mold cycles.

Neither product is satisfactory for releasing epoxy parts. These releases have not been tested for releasing urethane foam parts.

## PRODUCT SPECIFICATIONS

	PA0864	PA0868	Test Method
Color	Clear	Clear	Visual
Viscosity	Water Thin	Water Thin	ASTM D2393
Specific Gravity, gms./cc	.081	.069	ASTM 1475
Flash Point	280°F	-28°C	ASTM D56

## DIRECTIONS FOR USE

The mold surface should be cleaned of any previously applied mold release. Either PA0864 or PA0868 can be applied by wiping on with a clean lint-free rag, brushing or spraying. Either product can be applied to molds which are at room temperature or elevated temperature. If PA0864 is applied to a cold mold, adequate time should be allowed for the solvents to flash off before the molding process is begun. Care should be taken when applying PA0868 to a hot mold because the solvent can boil off and leave areas of the mold surface inadequately released.

After the urethane elastomer part is removed from the mold, it should be thoroughly washed with soap (some people use dishwashing soap) and warm water. Use of a Scotch-Brite pad is recommended. Rinse with clean water and allow to dry. The part is then ready for painting or bonding.

## SAFETY

PA0868 is extremely flammable. Keep away from sparks and open flame. Use adequate ventilation with either product. The solvents in PA0864 and PA0868 can dry the skin and thereby cause irritation. Minimize skin contact by wearing solvent proof gloves and wash with soap and water if contact occurs.

PA0864 & PA0868 Bulletin / InDesign / 091714-C2

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