



## ROM 300

### AQUEOUS BASED AND SEMI-PERMANENT ROTATIONAL MOULDING RELEASE AGENT



**ROM 300** is a release coating formulated for use in a wide variety of rotational moulding applications. When the coating is applied correctly to a pre-heated mould surface to form a thin, inert and thermally stable coating, multiple releases of many grades of polyethylene and polypropylene can be expected.

#### FEATURES

- Fast curing
- Non-flammable
- Reduced reject rates
- Remove line breaks
- Releases most grades of polyethylene and polypropylene
- Contains corrosion inhibitor to help prevent 'flash rusting' on mould tools
- Lower mould build-up
- Easier release
- Maximum multiple release

#### MOULD PREPARATION

**New Moulds:** Mould surfaces must be thoroughly cleaned and dried. All traces of previous release agents and moulding residues must be cleaned away. Ambersil Polyester Mould Cleaner is recommended for cleaning away these release agent residues.

**Old Moulds:** All traces of previous release agents and moulding residues must be cleaned away taking care to ensure that any deep cavities, corners and undercuts are free of residues and signs of oxidation.

#### APPLICATION

Ambersil **ROM 300** can be applied by any of the following methods.

- Conventional Air Spray
- HVLP Spray
- Airless Spray

Ambersil **ROM 300** is suitable for application directly onto heated moulds at temperatures up to 204°C (400°F) and moulds preheated to a minimum of 60°C (140°F).

Using a finely atomised spray pattern. Ambersil **ROM 300** should be applied at a distance of 8-12" from the mould surface.

For hot (120-200°C) moulds, new or porous moulds apply a minimum of 6 coats. For warm (60-120°C) moulds a minimum of 4 coats should be

applied with special attention paid to avoiding emulsion accumulation and run marks due to over application.

Allow sufficient time for **ROM 300** to cure prior to production.

At 60°C the release coating will dry in a few seconds and will be fully cured in 25 minutes. At 95°C this cure time is reduced to 10 mins; whilst at 150°C, ROM 300 dries instantly and needs only 4 minutes to fully cure.

#### **Touch Up of the release coating.**

A light touch up coating should be applied on areas where poorer release is noticed. This will effectively reduce the possibility of release agent or polymer build up. As with the initial application allow time for the coating to cure before resuming production. The frequency of touch up will depend on several factors including polymer type, mould design and any abrasion that may occur during part demould.

#### **CHEMICAL & PHYSICAL PROPERTIES**

Appearance	: Milky liquid
Odour	: Slight
S.G.	: 0.970 - 1.000 @ (20°C)
Flammability	: N/Applicable
Flashpoint	: N/Applicable
Boiling Point	: 100°C
Evaporation Rate	: < 0.1 Reference : BuAc = 1 pH:value Concentrated
Solution	: 4.0 +/- 0.1
Solubility	: Miscible with water. Insoluble in most organic solvents

#### **PACKAGING**

5L, 25L & 200L

#### **STORAGE**

The product may be stored at normal ambient temperatures and has a shelf life of not less than 12 months with correct storage.

#### **HEALTH AND SAFETY**

Health and Safety sheet available separately.

#### **MISREPRESENTATION ACT 1967**

#### **TRADE DESCRIPTIONS ACT 1968**

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