

# LOKRELEASE™ MOLD RELEASE TROUBLESHOOTING GUIDE



## APPLICATION

PROBLEM	CORRECTIVE ACTION
When applying the mold release, the carrier material does not evaporate.	<ol style="list-style-type: none"> <li>1. Check application temperature. If it is below the minimal bake temperature* of the mold release, increase the heat of the mold. *Consult TDS of mold release for this information</li> <li>2. Re-evaluate the volume of spray being applied and adjust as necessary. Ensure that volume applied is low enough to avoid overspray.</li> </ol>
After the initial application, certain areas of the mold begin to stick.	<ol style="list-style-type: none"> <li>1. This is normal with complex molds. Retouch areas or cavities where problems occur and continue molding.</li> </ol>
When applying a water-based mold release, drops of the material "jump" on the surface of the mold and leave a white residue.	<ol style="list-style-type: none"> <li>1. Wipe excess mold release with a dry rag.</li> <li>2. Optimize the atomization of the mold release by adjusting the controls of the spray gun.</li> <li>3. Ensure the spray gun has a small nozzle of 0.6-0.8mm and atomization creates a fine mist; material should not drip when sprayed vertically on a porous surface such as cardboard.</li> </ol>
Parts begin to stick in the mold. Certain cavities stick more often than others.	<ol style="list-style-type: none"> <li>1. Establish a frequency of a partial application to troublesome sections.</li> <li>2. Establish a frequency of full application throughout the mold.</li> </ol>
When applying the mold release, a large cloud of material is observed.	<ol style="list-style-type: none"> <li>1. Determine the consumption of mold release per application. Average consumption of mold release on a 16 cavity mold should be around 20 to 30 grams per application.</li> <li>2. Reduce spray pressure if needed.</li> <li>3. Check to see if spray gun has any defects. If a problem is found, fix spray gun or replace entirely.</li> </ol>
Parts in the posterior cavities become jammed.	<ol style="list-style-type: none"> <li>1. Use an HVLP (high volume, low pressure) spray gun with an extension nozzle at 90° to avoid shadowing effect.</li> </ol>

## PROCESS

PROBLEM	CORRECTIVE ACTION
Parts cannot be release from the mold or it takes significant force to release parts.	<ol style="list-style-type: none"> <li>1. Clean the mold using grit blasting, dry ice blasting, etc.</li> <li>2. Check the design of the part, mold, and runners.</li> <li>3. If problem is not solved, a different mold release may be required for this mold. Consult with LORD technical service at <a href="mailto:customer_support@lord.com">customer_support@lord.com</a> or call +1 877 ASK LORD (275 5673).</li> </ol>
Rubber parts have cracks or flow lines.	<ol style="list-style-type: none"> <li>1. Reduce the amount of mold release sprayed per application.</li> <li>2. If you are using a silicone based mold release, you may need to consider switching to a PTFE option for this part.</li> </ol>

## CLEANING

PROBLEM	CORRECTIVE ACTION
Pieces continue to stick to the mold despite correct application of mold release and proper application frequency.	<ol style="list-style-type: none"> <li>1. Clean the mold entirely and set periodic cleaning frequency on each mold.</li> </ol>