

LORD® LokRelease™ 200 Mold Release

BEST PRACTICES

Water based release agent designed for use in molding processes with elastomers, including EPDM, Natural Rubber, Nitrile and Neoprene. It is a fast curing, non-transferable product that provides a semi-permanent coating for an easier part removal after vulcanization.

BENEFITS:

- Increases the number of molding cycles between application of the product
- Allows the rubber to flow during the filling of the mold cavity
- Easier to remove rubber excess from finished parts
- Improves appearance of the molded part
- No dilution required
- Environmentally friendly

INSTRUCTIONS:

- 1** Preparation of the Mold: Clean the mold perfectly within your normal process.
If the mold is not clean enough and LORD LokRelease 200 is applied over a dirty surface, this can create a white layer that could cause several defects on the molded parts.
- 2** Product Application: Start heating the mold. Once it reaches 212°F, apply the first of the release agent using a low spraying pressure over the whole surface of the cavities (inferior, superior and middle mold).
Let it cure for 5 minutes at this same temperature. Do a second and third layer with the corresponding curing time of 5 minutes in between.
- 3** Use: When the mold reaches the desired temperature (302°F, 320°F, 356°F), start the molding process.
- 4** Product Retouch: LORD LokRelease 200 typically achieves between 5 to 13 molding cycles without any retouch, depending on the complexity of the mold and the geometry of the part that will be molded. Some applications have seen 15+ molding cycles without retouch.
A product retouch will be necessary in the following situations:
 - a. When the part removal starts to become difficult.
 - b. When the appearance of the rubber changes its texture or brightness, because these aspects are the ones that allow the correct release of the molded parts, the complete filling of the mold cavities and makes it easier to remove rubber excess from finished parts.



Finished part with the correct brightness and texture



Finished part with opacity and wrong texture that requires retouch

- 5** Cleaning: If necessary, the product could be eliminated from the surface of the mold through a blasting process using plastic particles.

If you would like to know more, please contact Customer.Support@LORD.com for other applications using our mold releases.