



Stoner TraSys[®] 258

MOLD RELEASE COATING

Description

TraSys[®] 258 is a translucent, solvent-based dispersion. When applied to a mold, it exhibits outstanding release or antistick properties and has a very low coefficient of friction. It is clean, nonoily, nonstaining, chemically inert, and can function in temperatures to 260°C (500°F) or higher. TraSys[®] 818 is recommended for touch-up.

Uses

Release life with TraSys[®] 258 is excellent, and multiple release into the thousands is obtainable. Excellent performance has been observed with compression molding silicone elastomers.

Directions for Use

The recommended steps in coating a mold with TraSys[®] 258 are highlighted below. These steps can be accomplished in-house, if you are equipped with an oven that will reach 400°C (750°F) for the cleaning of the mold's surface and 360°C (680°F) for the curing of the coating. Molders desiring to use TraSys[®] 258, but lacking the proper equipment, should contact Stoner Coating & Release Systems for alternative coatings or recommended third party companies to do the coating.

Burn¹: Place mold in oven, and raise the *mold surface temperature*² to 370–400°C (700–750°F) for a period of 30 min. This will turn any excess rubber deposits to ash, but, more importantly, will burn any previous release out of the mold's pores, thereby thoroughly cleaning the mold.

Blast: After the mold has cooled, bead blast all surfaces to be coated. All dust must be blown off and surfaces wiped with a residue-free solvent using a clean rag. A recommended alternative would be to spray the bead blasted mold with residue-free solvent and blow dry with filtered air.

Spray: TraSys[®] 258 must be applied to room temperature surfaces. TraSys[®] 258 can be applied with a pressure fed tank sprayer, such as those manufactured by Binks or Devilbiss. Equipment must be rated for handling flammable liquids. Gun pressure should be regulated to a maximum of 20 psi and pot pressure of 2–4 psi for application. We recommend four light coats, once from each direction, to coat places that may have been shadowed from raised parts. The spray will go on wet, dry quickly, and turn white when all solvents have evaporated. This enables the operator to see any areas that may have been missed. Touch up as necessary for complete coverage. There is no problem with overlapping of the spray causing discoloration of the finished part as with some other mold releases.

Bake²: Place mold in oven set at 360–365°C (680–690°F). When the *mold surface temperature* reaches the required temperature range of 360°C (680°F) minimum—365°C (690°F) maximum, maintain this surface temperature for a minimum of 10 min. It is essential that the coated surfaces reach these temperatures. When these conditions have been reached, the oven should then be turned off and dampers opened to allow quicker cooling of the mold.

¹ Note: The burning off of foreign materials is only recommended for the initial coating of the mold or before any application of TraSys[®] 258 where contamination may have occurred. This step may not be required if no other release coatings or lubricants were used in conjunction with TraSys[®] 258.

² Temperature can be conveniently measured by attaching a thermocouple to the thickest mold plate. Measurement of air temperature, rather than surface temperature, may be misleading in determining whether the required temperature has been reached.

Typical Properties

Primary Polymer: Fluorochemical
Specific Gravity: 0.80
Odor: Alcohol
Color: White
Flash Point: 12°C (53°F)

Storage and Handling

Store containers in a cool, dry, well ventilated area away from heat, sparks, and flames. Keep container tightly closed. The solvents used in TraSys® 258 mold release coating may dissolve natural skin oils; therefore, contact with the skin should be avoided to prevent dry skin. Adequate ventilation must be provided in work areas where TraSys® 258 mold release coating is being used. Breathing vapors should be avoided. If spraying, care should be taken to avoid inhaling mist or vapors, just as sprayed paint inhalation should be avoided. Vapor from the solvent may develop slight pressure. Therefore, care should be exercised when opening containers. Containers should be closed promptly after removing part of the contents to avoid evaporation. If this product is exposed to extreme heat conditions from misuse or equipment failure, toxic decomposition products that include hydrogen fluoride can occur.

Hydrogen fluoride has an ACGIH threshold limit value of 3 parts per million parts of air as a ceiling limit, an OSHA permissible exposure limit (PEL) of 3 ppm of fluoride as an 8-hr time-weighted average, and 6 ppm of fluoride as a short-term exposure limit (STEL).

Do not smoke while handling this product.

Shelf Life

TraSys® 258 has a shelf life of 24 months from the date of manufacture. The date of manufacture and shelf life are posted on the container label.

Packaging

1-gal containers

Shipping Limitations

DOT/IMO/IATA	
Proper Shipping Name	Isopropanol Solution
Hazard Class	3
UN No.	1219
Packing Group	II
Label(s)	Flammable Liquid

For more information or technical assistance:

Call 800-227-5538:

Email: TimeSaver@StonerSolutions.com

Visit: Stonersolutions.com/TraSys

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