

LORD® LokRelease™ 238 B Aqueous Mold Release

Technical Data Sheet

LORD® LokRelease™ 238 B aqueous mold release is a modified PDMS-based, fast-curing release agent designed for use with molded elastomers, including EPDM, natural rubber, nitrile, neoprene, fluorocarbon elastomers and other sulfur-cured or peroxide-cured elastomers. It can be used when molding elastomers up to 400°F (204°C).

LORD LokRelease 238 B mold release is a semi-permanent release agent that provides an anti-stick coating for fast, easy part removal from molds.

Features and Benefits:

Process Enhancer – provides quick, easy part release; produces low build-up, allowing more production time between mold cleanings; improves molding efficiency in many processes including injection, compression and transfer molding.

	Pure Elastomer	Elastomer-to-Metal
Injection	✓	✓
Compression	✓	✓
Transfer	✓	✓

Improved Appearance – reduces defects caused by sticking.

Environmentally Recommended – water-based coating provides multiple release cycles per application.

EU REACH Compliant – product compliant with EU REACH regulation.

Typical Properties*	
Appearance	White Liquid
Density lb/gal (g/cm ³)	8.34 (1)
Dispersing Medium	Water

*Data is typical and not to be used for specification purposes.

Application:

Surface Preparation – Remove mold release residue and other contaminants from surface of the mold prior to application to improve adhesion and durability. Gentle abrasive (plastic) bead or dry ice blasting methods may be used.

Product Preparation – LORD LokRelease 238 B mold release can be diluted to a maximum dilution ratio of 1:6, mold release to deionized water. A starting dilution ratio of 1:2 with deionized water is recommended.

Applying – LORD LokRelease 238 B mold release must be applied to mold surfaces preheated above 250°F (121°C) in order for the water to flash off quickly. The mold surface must be preheated to the cure temperature before application to ensure even coating.

Apply three light coats on hot mold surface, allowing time for each coat to dry between applications. An additional light coat for each of the first three to five molding cycles helps to build up the mold release and “season” the mold.

Applying more mold release after one molding cycle may not improve performance and heavy application should be avoided. Excessive application causes pooling or puddling of LORD LokRelease 238 B mold release in the mold which can result in an uneven coating. Use the minimum amount to achieve release.

Drying/Curing – Cure mold release coatings according to the Time vs. Temperature chart. Measuring the mold surface to determine actual surface temperature will ensure correct determination of cure time.

Small hand molds, platen-heated molds, or lower molding temperatures may require additional cure time. Heavy application of aqueous mold release can cool the mold surface, resulting in an uneven coating.

A heavy, uneven coating may not cure sufficiently and may be more susceptible to sweep, poor elastomer knit, and heavy transfer to the molded product. If poor knit lines occur, reduce application amount or dilute LORD LokRelease 238 B mold release with deionized water.

If spot sticking occurs after molding, mold release coating can be “touched-up” by spraying LORD LokRelease 238 B mold release directly on the sticking area and allowing time to cure.

Cleanup – If necessary, mold release coating can be removed from mold surface by gentle abrasive (plastic) bead or dry ice blasting.

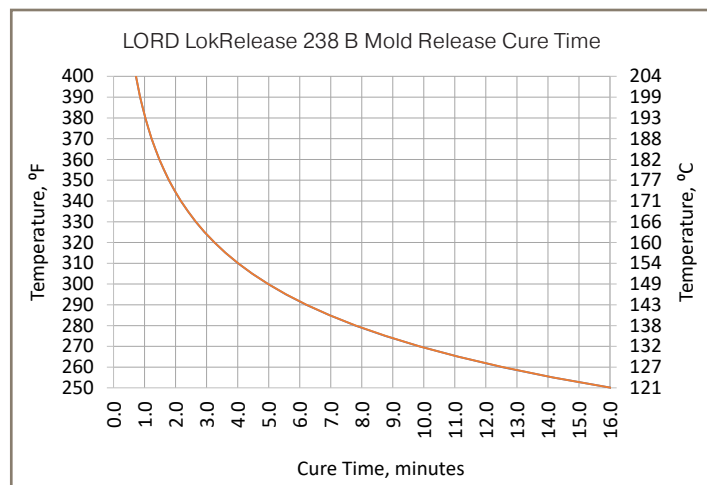
Shelf Life/Storage:

Shelf life is one year from date of manufacture when stored at room temperature [$<80^{\circ}\text{F}$ ($<27^{\circ}\text{C}$)] in original, unopened container. Do not freeze product. Keep container closed when not in use.

Cautionary Information:

Before using this or any Parker Lord product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.



Values stated in this document represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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