

LORD® LokRelease™ 338 Silicone-Free Mold Release

Technical Data Sheet

LORD® LokRelease™ 338 mold release is a silicone-free release agent designed for use in molding sticky fluoropolymer rubber types such as FKM and FFKM. It may also be used to release plastics and all other rubber types. This water-based mold release has a very low surface energy and provides an anti-stick coating for fast, easy part removal from molds.

LORD LokRelease 338 mold release is a non-permanent, low build-up release agent that allows multiple releases with high performance.

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.

Typical Properties*	
Appearance	Yellow Liquid
Density lb/gal (g/cm ³)	8.35 (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.

Dispensing – Use stainless steel or plastic equipment if dispensing or storing material in a new container. Clean equipment with water before repackaging LORD LokRelease 338 mold release.

Mixing – Dilution of 1:1 with deionized water is recommended. Mold release may be diluted further if needed to prevent excessive application.

Applying – LORD LokRelease 338 mold release should be applied to mold surfaces preheated above 250°F (121°C) in order for the water to flash off quickly. The mold surface should be preheated to the cure temperature before application to ensure even coating and drying.

Apply mold release using a fine mist spray. Apply one to three light coats on hot mold surface, allowing time for each coat to dry. Heavy application that causes pooling or puddling of LORD LokRelease 338 mold release coating in the mold should be avoided. As with any mold release, excessive application may cause molding defects.

Drying – Small hand molds, platen-heated molds, or lower molding temperatures may require additional dry time.

Heavy, uneven application of mold release may be more susceptible to sweep, poor elastomer knit, and heavy transfer to the molded product.

If spot sticking occurs after molding, the mold can be “touched-up” by spraying LORD LokRelease 338 mold release directly on the sticking area and allowing time to dry.

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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