



### TYPICAL PROPERTIES

- Appearance and odor = Milky white, opaque liquid
- pH = 10
- VOC (EPA 24) = 0 lbs/gal
- Density = 8.3 lbs/gal
- Flashpoint = None

# FoundryGeneral® Mold Release EM

## Mold Release Emulsion

### Description

FoundryGeneral® Mold Release EM is an emulsified blend of silicones which provides excellent release characteristics for cold box core-making processes. These include DMEA or TEA cured phenolic urethane and carbon dioxide. FoundryGeneral® Mold Release EM offers excellent releases on aluminum, urethane, and metal core boxes. Since it is a water emulsion, FoundryGeneral® Mold Release EM has a very low VOC level. There are no solvent carriers of any type to contend with when using this product. FoundryGeneral® Mold Release EM is concentrated and is suitable for dilution with water to obtain the desired emulsion. The frequency of application will depend upon core complexity or part design, application technique and condition of the tooling. FoundryGeneral® Mold Release EM is the product of choice for ALL Cold Box processes except SO<sub>2</sub> and CO<sub>2</sub>

### Recommended Application

1

FoundryGeneral® Mold Release EM is used as received.

FoundryGeneral® Mold Release EM is used as received. Cycle the machine to approximately 70% of the cycles

2

Apply FoundryGeneral® Mold Release EM to both the cope and the drag.

3

Blow off the cope and drag with plant air.

This will enhance film formation of the active ingredients.

4

Cycle the machine until sticking is experienced.

Record the number of cycles.

5

Reapply FoundryGeneral® Mold Release EM.

It can be applied either by spraying, brushing or wiping. Whatever technique is used, it is recommended that a uniform coat be applied to insure consistent release capabilities.

6

Cycle the machine to approximately 70% of the cycles.

The frequency of application will depend upon core complexity or part design, application technique and condition of the tooling.

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### **Benefits**

- Water based
- Nonflammable
- Zero VOC
- Provides multiple releases

### **Material Compatibility**

Do not freeze or expose to extreme heat. Avoid materials that react with water.

### **Health & Safety**

Refer to SDS for complete health and safety information.

### **Storage**

With proper storage, shelf life is 1 year from date of manufacture. Please refer to SDS for complete storage information.

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