



TECHNICAL DATA SHEET S20019

Room 9,11 Floor, Chuangxin Building Block 1#, No.1, Technology Road, Technology
Chuangxin Park, West of Dayabay, Huizhou City, Guangdong, P.R. China
TEL (86 752) 5533798 FAX (86 752) 5533798-811

Description:

Tacusil™ S20019 is a release agent where a non-transferring release is necessary. This semi-permanent, non-migratory release system chemically bonds to the mold surface to form a micro thin film which is stable at temperatures exceeding most molding processes Tacusil™ S20019 can be used for the release of epoxies, polyester resins, thermoplastics, adhesives, and rotationally molded plastics.

Special Features:

- ❖ Fast drying
- ❖ Non-contaminating transfer
- ❖ High thermal stability
- ❖ Non-CFC
- ❖ No mold build-up

Typical Properties:

All properties given are at 25°C unless otherwise noted.

| <i>Property:</i> | <i>Value:</i> | <i>Unit:</i> |
|--------------------------------|-----------------------|--------------|
| Chemical Type | Solvent Based Polymer | |
| Appearance | Clear Liquid | |
| Cure | Room temperature cure | |
| Cured Thermal Stability | ≤400 | ° C |
| Specific Gravity | 0.715 to 0.725 | LMS |

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INSTRUCTIONS:

1. Tacusil™ S20019 can be applied to mold surfaces at room temperature up to 60°C by spraying, brushing or wiping with a clean lint-free, cloth. When spraying ensure a dry air source is used or use an airless spray system. Always use in a well ventilated area.
2. Wipe or spray on a smooth, thin, continuous, wet film. Avoid wiping or spraying over the same area that was just coated until the solvent has evaporated. If spraying, hold nozzle 20 to 30cm from mold surface. It is suggested that small areas be coated, working progressively from one side of the mold to the other.
3. Initially, apply 2 to 3 base coats allowing 5 minutes between coats for solvent evaporation .
4. Allow the final coat to cure for 30 minutes at 22°C.
5. Maximum releases will be obtained as the mold surface becomes conditioned to Tacusil™ S20019 Performance can be enhanced by re-coating once, after the first few initial pulls.
6. NOTE: Tacusil™ S20019 is moisture sensitive, keep container tightly closed when not in use. The product should always be used in a well ventilated area.
7. Precaution: Users of closed mold systems (rotomolding) must be certain that solvent evaporation is complete and that all solvent vapors have been ventilated from the mold cavity prior to closing the mold. An oil-free compressed air source can be used to assist in evaporation of solvents and ventilation of the mold cavity.

STORAGE:

The product is classified as flammable and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.

Material removed from containers may be contaminated during use.

Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

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