



T.R. Industries

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TR-900 / TR-900FD SERIES

SEMI-PERMANENT RELEASE

NEW OR RECONDITIONED MOLD PREP GUIDE

POLYESTER MOLDED PARTS

- STEP 1.-** Remove all contaminates and previously used releases from mold surface with the **TR-905 SOLVENT CLEANER**. Saturate cloth with the 905 Solvent and wipe onto sections or areas of the mold. Allow sufficient time while area is still wet to follow and wipe dry with a clean cotton cloth. Turn and change cloth frequently to absorb and pick-up contaminates. REPEAT if necessary until MOLD SURFACE is thoroughly cleaned and wiped dry. On NEW or RECONDITIONED MOLDS that have been buffed with a polishing or buffing compound, first water wash to remove the buffing compound residue and wipe completely dry. Then clean thoroughly with the 905 SOLVENT CLEANER as mentioned above. Refer to product data sheet.
- STEP 2.-** Apply 1-2 coats of **TR-910** sealer (2 coats for uniform coverage or if porosity may be present). Allow 15-20 minutes cure between coats and 30 minutes after final coat, preferably longer if schedule permits. See product data sheet for application.
- STEP 3.-** Apply 2 coats of **TR-900** Release (4 coats if TR-910 sealer is omitted). Allow 5-10 minutes cure between applications and after final coat. Wet or dampen a clean lint-free cotton cloth with the release and apply an even wet coat on a small area of the mold surface (approx. 2'x2'). Avoid heavy application or cloth that is heavily soaked or dripping wet. While surface is still wet, gently wipe dry with a separate clean, dry cotton cloth. Turn or change cloth as needed to ensure a uniform, dry surface. No hard or excessive wiping is advised. When applying, start at one end of the mold and over-lap slightly each small previously applied area until mold is complete. Apply the 2nd or subsequent coats in the same manner. See product data sheet for additional information. Recommend trial of the **TR-920** or **TR-930** as replacement for the **TR-900** where MOLD GEOMETRY requires some horizontal pull when demolding and added slip action is required.
- STEP 4.-** Apply the **TR-900** Series Release again after the first 2 pulls or releases. Then proceed with your multiple Release and apply as needed setting up a schedule you have achieved or determined when re-application is required. Any minor scratches or abrasion marks will have to be treated again at first notice. Apply another coat of Release on affected area. Any patched or repaired areas should be taken through all steps and sufficient over lap of area to provide uniform release & coverage. Allow TR-910 Sealer longer cure (1-2 Hours at room temperature) on patched or repaired areas.

NOTE: ALWAYS USE A LINT-FREE ALL COTTON CLOTH (PREFERABLY WHITE) WHEN APPLYING THE SOLVENT CLEANER 905, SEALER 910 & 900 SERIES RELEASE. No SYNTHETIC CLOTH BLENDS AND USE SEPARATE RAGS FOR THE CLEANER, SEALER & RELEASE. AVOID ANY CONTAMINATION OF RAGS AND/OR RELEASE CONTAINER. THE CONTAINER MUST BE KEPT CLOSED WHEN NOT IN USE. MATERIAL IS MOISTURE SENSITIVE AND WILL EXHIBIT PREMATURE REACTION IF CONTAINER IS LEFT OPEN EXCESSIVELY. AVOID CONTAMINATION WHEN REFILLING PREVIOUSLY USED CONTAINERS OR TRANSFERRING TO OTHER CONTAINERS.

