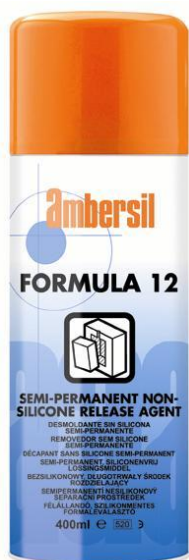




## FORMULA TWELVE NON-SILICONE SEMI-PERMANENT RELEASE AGENT



**FORMULA TWELVE** is a specially formulated release coating for use in a wide variety of rubber and rotational moulding applications. The coating once applied to a pre-heated mould surface forms a thin, inert and thermally stable release film. Multiple releases of many grades of polyethylene, polypropylene and all natural and synthetic rubbers (except silicone elastomers) can be expected.

### ADVANTAGES

- Fast curing
- Easier release
- Maximum multiple release
- Lower mould build-up
- No contaminating transfer
- Reduced reject rates
- Effective to 250°C

### MOULD PREPARATION

**New Moulds:** All moulds must be thoroughly cleaned and dried and Any traces of previous release agents must be removed, using one of Ambersils mould cleaners or Amberklene FE10, ME20 or LO30.

**Old Moulds:** All traces of previous release agents and moulding residues must be cleaned away, taking care to ensure that any deep cavities, corners or undercuts are free of residues and signs of oxidation.

**Application:** Mould should be clean and dry. Apply a thin, even film from 15 – 25cm at temperatures between ambient room temperature and 60°C. Allow 5 – 10 minutes for film to cure before commencing moulding.

Performance will be enhanced by re-coating once the first few releases have been made.

With respect to curing times and baking on of the release agent film, this will depend greatly on the grade of material being moulded, mould construction and mould condition.

- 1 Only a thin film is required, apply 8-10" from the mould surface. To obtain the best results, coat small areas at a time working progressively from one side of the mould to the other. Avoid spraying over the same area that was just coated until the solvent has fully evaporated
- 2 On new moulds apply 2-3 base coats prior to commencing moulding, allowing up to 5-10 minutes after each application for complete solvent evaporation. The film should be dry and not feel tacky. A

further two coats should be applied after the second release from the tool paying special attention to any deep cavities and undercuts and leaving 5-10 mins after the final coat for the film to cure properly.

- 4 Performance will be enhanced by re-coating once the first few releases have been made. As the mould becomes conditioned to **Formula Twelve**, release will become more uniform and multiple releases will be obtained.
- 5 When any slight variances in the quality of release are noted, a light touch up coat may be applied. This may be done to the affected area or to the whole mould surface following the guidelines above.

#### **CHEMICAL AND PHYSICAL PROPERTIES**

Appearance	:	Finely atomised spray
Odour	:	Hydrocarbon
Solvents	:	Aliphatic Naptha
Shelf Life	:	1 year from date of manufacture
Packaging	:	400ml, available in bulk form as ROM100
Flammability	:	Classified as extremely flammable under current EU regulations
Pressure at 25°C	:	40 psi

#### **STORAGE**

The product may be stored at normal ambient temperatures and has a shelf life of not less than 12 months with correct storage.

#### **HEALTH AND SAFETY**

Health and Safety sheet available separately.

#### **TECHNICAL SERVICE**

Ambersil provides a technical support service and maintains a constant programme of research and development. We are able to assist customers by specific product development to meet particular requirements.

#### **MISREPRESENTATION ACT 1967**

#### **TRADE DESCRIPTIONS ACT 1968**

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