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INSTRUCTIONS for the REMOVAL of MOLD RELEASE

Occasionally, it becomes necessary or desirable to remove residual mold release from either the molded parts or the substrate.

This can be accomplished in either of the following two ways:

- 1) Washing with a suitable solvent, or
- 2) Emulsifying with a suitable detergent and water solution.

If a solvent system is used to remove the mold release, care must be taken to assure that the solvent does not adversely affect the plastic part or the substrate. We do not recommend the use of successive dip tanks since the subsequent tanks quickly become contaminated with small traces of release agent which are re-deposited on the piece, thereby rendering the removal ineffective. A vapor degreaser would be the method of choice for removing mold release with a solvent.

Our mold releases are also soluble in the aromatic solvents such as xylene; aliphatic solvents such as white gasoline and V.M. & P. Naphtha; and chlorinated solvents such as perchloroethylene and trichloroethylene. *Our mold releases are not soluble in any of the alcohols or acetone.*

Mold release may also be removed by immersing the parts in a solution of water and detergent to emulsify the mold release agent. Warmer water will do a better job emulsifying than cold water. If the parts are small they may be placed in a nylon mesh bag. Larger parts may be immersed in a tank containing water and detergent and then hosed off with fresh running water. We do not recommend successive dip tanks here, either, for the same reason as stated above. Suitable detergents include lemon-scented Joy or commercial dishwashing compounds such as Cascade. Cascade has low foaming properties whereas lemon-scented Joy, which seems more effective, has high foaming characteristics. Tri-Sodium Phosphate (T.S.P.) is also a good emulsifier.

Goggles or face masks and gloves should be worn when using automatic dishwasher detergents because of the high alkalinity of these materials.