



CRYSTAL

CRW-4100

DESCRIPTION:

Crystal CRW-4100 is a water-based mold release agent suitable for a variety of molding applications.

Crystal CRW-4100 is suitable for the molding of medium and high density urethane foams and elastomers, as a release agent for the molding of elastomeric belting, and for the release of MDI bound recycled rubber components.

Depending on application **Crystal CRW-4100** can be used as is or diluted to an appropriate strength.

PACKAGING, HANDLING, AND STORAGE CONDITIONS:

Available in 5 Gal pails, 55 Gal drums and 330 Gal totes.

Containers should be kept closed prior to and during use to avoid external contamination. Store below 100°F and above 32 °F. Keep product from freezing.

Storage in steel, galvanized steel or black iron will degrade the active ingredients of this product. For safety precautions consult MSDS.

PHYSICAL PROPERTIES:

Appearance	Milky White Liquid
pH	4.0
Viscosity	Water Thin
Odor	Sweet / Ether
Specific Gravity	1.01 g/CM ³
Water Solubility:	Fully Miscible
Shelf Life	12 months

APPLICATION INSTRUCTIONS:

For best results the surface of the mold must be cleaned prior to application of **Crystal CRW-4100**. Typical cleaning methods would be media/dry ice blasting or treatment with alkaline detergent followed by neutralization and rinsing with water.

Base Coat:

For best results, the tool should be above 180°F when applying **Crystal CRW-4100** or at a temperature suitable for rapid evaporation of water. For spray application, utilize an air atomizing spray gun or an airless spray gun which produces a finely atomized spray particle. Apply 4 or 5 light coats, varying the direction of each to ensure total tool coverage and sealing. Allow each pass to dry completely prior to application of the next coat.

Crystal CRW-4100 can be used as a diluted material for base-coating and touch-up. Generally a 6:1 dilution is appropriate for most general molding applications. Molding operations requiring a high level of slip will benefit from using the material as is or at most a 1:1 dilution with DI water.

Touch-up:

Use the same application equipment used for basecoating. Typically a single pass application of the diluted or undiluted material prior to failure of the basecoat proves to be effective.