

RHODORSIL® RESIN 9515

Industrial release

Description	<p>RHODORSIL RESIN 9515 is a solventless methyl silicone resin which has been specially designed for mould release of:</p> <ul style="list-style-type: none"> • Cast polyurethane elastomers as well as soft and rigid PU foams. The following examples can be mentioned: Dashboards, shoe soles, upholstery, thermal insulation and sound proofing materials. • Melamine, phenolic, polyester and epoxy resins. • Rubbers.
Features	<p>In these demoulding applications, RHODORSIL RESIN 9515 offers the following advantages:</p> <ul style="list-style-type: none"> • Odour free (solvent free). • Very easy to use. • Proven efficiency. • Excellent adherence to the mould surface. • The moulded articles have an excellent surface finish. • Excellent thermal stability. • Reduces mould fouling. • Easy cleaning.
Nature and general uses	<p>RHODORSIL RESIN 9515 is used:</p> <ul style="list-style-type: none"> • As mould release agent on metal moulds. • As protective agent on moulds and membranes made of RTV silicone rubber.
Properties	<p>Appearance..... clear to slightly cloudy liquid</p> <p>Colour..... colourless to straw yellow</p> <p>Active ingredients, %, approx..... 100</p> <p>Solvent..... none</p> <p>Flash point (closed cup), °C, approx..... 180</p> <p>Specific gravity at 25 °C, approx..... 1.00</p> <p>Viscosity at 25 °C, mm²/s, approx..... 180</p> <p>Diluents.....Aromatic, aliphatic and chlorinated hydrocarbons, white spirit, aliphatic esters, isopropyl alcohol and Hexamethyldisiloxane (Rhodorsil H41V0,65)</p>

RHODORSIL[®] RESIN 9515

Processing

Mould release agent

The mould should be perfectly clean, grease-free, dry and if possible pre-heated to a temperature above 50 °C.

RHODORSIL RESIN 9515 is diluted in a solvent or mixture of solvents and applied with a brush, pad or spray gun.

The frequency of application depends on the complexity of the mould and the aggressiveness of the moulding material.

In general, reapplication is necessary every two to ten moulding operations.

For simple moulds a dilution of 3 to 5 % of **RHODORSIL RESIN 9515** in the chosen solvent is convenient.

The best solvent is methylene chloride.

If the user does not want to use chlorinated solvents we recommend the use of RHODORSIL H41V0,65.

But Hexane, Ethoxypropylacetate, Isobutylisobutyrate (IBIB) or a mixture of 70/30 H41V0,65/IBIB may also be used.

For complex moulds a dilution of 1 % in the same solvents may be necessary.

To slow down evaporation and prevent premature setting during spraying we recommend to (partially) use a solvent with a higher boiling point. Allow more time for drying before moulding.

Protective agent

Certain rigid or semi-rigid PUR foam formulations may attack RTV moulds or membranes.

In such cases, effective protection is provided by applying a layer of **RHODORSIL RESIN 9515**.

We recommend dilution to between 5 and 10 % in dichloromethane / isopropanol mixtures.

Finishing treatment of moulded articles

If the moulded articles are to be glued, painted, varnished or printed subsequently it is essential to carefully degrease the surface to be treated. Prior testing is necessary.

In the case of paints and varnishes, a « lack of adhesion » can often be prevented by adding between 0.1 and 0.5 % RHODORSIL OIL 47 V 100 to V 350 to the paint or varnish. Here again, prior testing is essential.

Packaging

RHODORSIL RESIN 9515 is supplied in 25 kg and 200 kg drums and in 1000 kg containers.

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Storage and shelf life

When stored in its original unopened packaging at a temperature of between – 20 and + 50 °C, **RHODORSIL RESIN 9515** may be stored for up to 12 months from its date of manufacture (expiry date).

Comply with the storage instructions and expiry date marked on the packaging. Past this date Bluestar Silicones no longer guarantees that the product meets the sales specifications.

Safety

Consult the Safety Data Sheet for **RHODORSIL RESIN 9515**.

Visit our website www.bluestarsilicones.com

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