

LORD® LokRelease™ 237 Aqueous Mold Release

Technical Data Sheet

LORD® LokRelease™ 237 aqueous mold release is a modified PDMS-based, fast-curing release agent designed for use with molded elastomers, including EPDM, natural rubber, nitrile, neoprene, fluorocarbon elastomers and other sulfur-cured or peroxide-cured elastomers. It can be used when molding elastomers up to 400°F (204°C).

LORD LokRelease 237 mold release is a semi-permanent release agent that is available in multiple dilutions. This water-based mold release provides an anti-stick coating for fast, easy part removal from molds.

Features and Benefits:

Process Enhancer – provides quick, easy part release; produces low build-up, allowing more production time between mold cleanings; improves molding efficiency in many processes including injection, compression and transfer molding.

	Pure Elastomer	Elastomer-to-Metal
Injection	•	•
Compression	•	•
Transfer	•	•

Improved Appearance – reduces defects caused by sticking.

Environmentally Recommended – water-based coating provides multiple release cycles per application.

Typical Properties*	
Appearance	White Liquid
Density lb/gal (g/cm ³)	8.34 (1)
Dispersing Medium	Water

*Data is typical and not to be used for specification purposes.

Application:

Surface Preparation – Remove mold release residue and other contaminants from surface of the mold prior to application to improve adhesion and durability. Gentle abrasive (plastic) bead or dry ice blasting methods may be used.

Dispensing – Use stainless steel or plastic equipment if dispensing or storing material in a new container. Clean equipment with water before repackaging LORD LokRelease 237 mold release.

Applying – LORD LokRelease 237 mold release must be applied to mold surfaces preheated above 250°F (121°C) in order for the water to flash off quickly. The mold surface must be preheated to the cure temperature before application to ensure even coating.

Apply mold release using a fine mist spray. Apply three light coats on hot mold surface, allowing time for each coat to dry. Heavy application that causes pooling or puddling of LORD LokRelease 237 mold release coating in the mold should be avoided, as this will result in an uneven coating. A fine mist spray will help prevent pooling or puddling in the mold.

If dilution is desired, use deionized water.



Drying/Curing – Cure mold release coatings according to the Time vs. Temperature chart. Measuring the mold surface to determine actual surface temperature will ensure correct determination of cure time.

Small hand molds, platen-heated molds, or lower molding temperatures may require additional cure time. Heavy application of aqueous mold release can cool the mold surface, resulting in an uneven coating.

A heavy, uneven coating may not cure sufficiently and may be more susceptible to sweep, poor elastomer knit, and heavy transfer to the molded product.

If spot sticking occurs after molding, mold release coating can be “touched-up” by spraying LORD LokRelease 237 mold release directly on the sticking area and allowing time to cure.

Cleanup – If necessary, mold release coating can be removed from mold surface by gentle abrasive (plastic) bead or dry ice blasting.

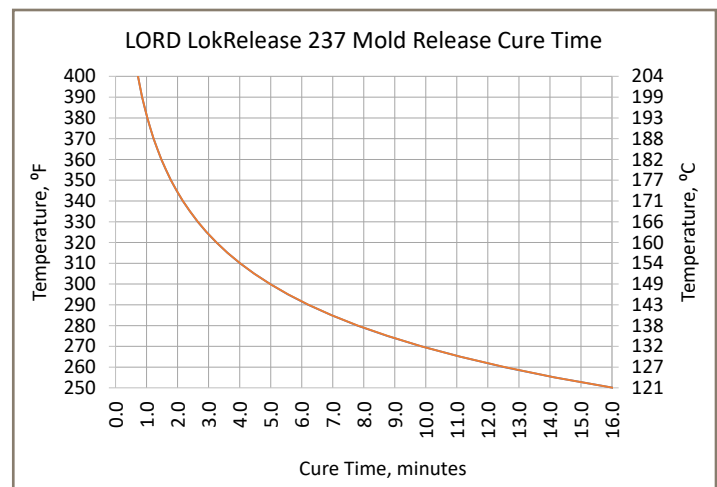
Shelf Life/Storage:

Shelf life is one year from date of manufacture when stored at room temperature [$<80^{\circ}\text{F}$ ($<27^{\circ}\text{C}$)] in original, unopened container. Do not freeze product. Keep container closed when not in use.

Cautionary Information:

Before using this or any Parker LORD product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

For industrial/commercial use only. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.



Values stated in this technical data sheet represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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