

LOKRELEASE™ MOLD RELEASE TROUBLESHOOTING GUIDE



APPLICATION

PROBLEM	CORRECTIVE ACTION
When applying the mold release, the carrier material does not evaporate.	<ol style="list-style-type: none"> 1. Check application temperature. If it is below the minimal bake temperature* of the mold release, increase the heat of the mold. *Consult TDS of mold release for this information 2. Re-evaluate the volume of spray being applied and adjust as necessary. Ensure that volume applied is low enough to avoid overspray.
After the initial application, certain areas of the mold begin to stick.	<ol style="list-style-type: none"> 1. This is normal with complex molds. Retouch areas or cavities where problems occur and continue molding.
When applying a water-based mold release, drops of the material "jump" on the surface of the mold and leave a white residue.	<ol style="list-style-type: none"> 1. Wipe excess mold release with a dry rag. 2. Optimize the atomization of the mold release by adjusting the controls of the spray gun. 3. Ensure the spray gun has a small nozzle of 0.6-0.8mm and atomization creates a fine mist; material should not drip when sprayed vertically on a porous surface such as cardboard.
Parts begin to stick in the mold. Certain cavities stick more often than others.	<ol style="list-style-type: none"> 1. Establish a frequency of a partial application to troublesome sections. 2. Establish a frequency of full application throughout the mold.
When applying the mold release, a large cloud of material is observed.	<ol style="list-style-type: none"> 1. Determine the consumption of mold release per application. Average consumption of mold release on a 16 cavity mold should be around 20 to 30 grams per application. 2. Reduce spray pressure if needed. 3. Check to see if spray gun has any defects. If a problem is found, fix spray gun or replace entirely.
Parts in the posterior cavities become jammed.	<ol style="list-style-type: none"> 1. Use an HVLP (high volume, low pressure) spray gun with an extension nozzle at 90° to avoid shadowing effect.

PROCESS

PROBLEM	CORRECTIVE ACTION
Parts cannot be release from the mold or it takes significant force to release parts.	<ol style="list-style-type: none"> 1. Clean the mold using grit blasting, dry ice blasting, etc. 2. Check the design of the part, mold, and runners. 3. If problem is not solved, a different mold release may be required for this mold. Consult with LORD technical service at customer_support@lord.com or call +1 877 ASK LORD (275 5673).
Rubber parts have cracks or flow lines.	<ol style="list-style-type: none"> 1. Reduce the amount of mold release sprayed per application. 2. If you are using a silicone based mold release, you may need to consider switching to a PTFE option for this part.

CLEANING

PROBLEM	CORRECTIVE ACTION
Pieces continue to stick to the mold despite correct application of mold release and proper application frequency.	<ol style="list-style-type: none"> 1. Clean the mold entirely and set periodic cleaning frequency on each mold.