



PennWhite

Resin 9515

solvent-free release agent

technical data sheet

release agents

Resin 9515 is a solvent-free methyl silicone resin that has been specially designed for mould release of items including:

- Cast polyurethane elastomers (car accessories, footwear, etc.)
- Melamine, phenolic, polyester and epoxy resins.

TYPICAL PROPERTIES

Nature	Special silicone resin
Appearance	Clear liquid
Colour	Colourless to straw yellow
Active ingredients % approx.	100
Solvent	None
Flash point °C	152
Specific gravity at 25°C approx.	0.99
Viscosity at 25°C mm ² /s approx.	180
Diluents	White spirit, isopropyl alcohol, aromatic, aliphatic and chlorinated hydrocarbons.

APPLICATION

Mould Release Agent

Resin 9515 can be applied as supplied or, preferably, diluted in a suitable solvent at a concentration which will depend on the method of application. This may be done with a brush, pad or spray gun.

It is absolutely essential to clean the moulds and remove any traces of grease before application of **Resin 9515**.

The number of operations will depend on working conditions, the moulding materials and the shape of the moulds, but as a general rule, one application of **Resin 9515** is sufficient for 2 to 10 mould releases.

Mould Protective Agent

Resin 9515 is very widely used with for mass-production of articles of varying materials in RTV moulds and membranes. The use of **Resin 9515**, in addition to enhancing the self-mould release effect of RTV, provides effective protection against chemical attack by the material used for reproduction, thus appreciably extending the lifetime of the membranes.

Isopropyl alcohol dilutions of **Resin 9515** are extremely useful in the moulding of rigid or semi-rigid polyurethane foams, which are particularly corrosive. This solvent must be evaporated completely before the polyurethane is cast, as it may interfere with the chemical foaming reaction. In certain cases petrol or white spirit may be preferable as diluents.

(OPA2/F2)

TDS: 195

Issue: 02

Revised: 21/05/2014

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For additional technical or safety advice call us on 01606 734820 or email info@pennwhite.co.uk

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Resin 9515 should be applied at each moulding operation and in a quantity just sufficient for the purposes, otherwise defects, such as microporosity and run out may appear in the moulded articles. In some cases a glossy effect, not always desired, is observed on the surface of the articles. The original appearance can be restored by adding a de-lustering agent to the solution of **Resin 9515**.

FINISHING TREATMENT

If the moulded articles are subsequently to be glued, painted, varnished or printed, it is essential to remove all traces of grease very carefully. Small batch tests are recommended before mass-production of articles.

In case of varnishing or painting, adding 0.1 to 0.5 % of silicone oil (47 V 100 to 47 V 350) to the paint or varnish very often prevents any adherence problems. Here again, prior tests are essential before any mass-production.

PACKAGING

Resin 9515 is supplied in 25kg and 200Kg drums.

STORAGE

Resin 9515 can be stored for 12 months in its original closed container, at a temperature between 5 and 25°C.

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