



# TraSys® 9825

## Water Based Mold Release Agent

### Product Description

**Trasys® 9825** mold release coating is a water-based dispersion for hot mold applications. When applied to a mold, it exhibits outstanding durability and antistick properties and has a very low coefficient of friction. It is clean, non-oily, non-staining, chemically inert, and can function in high temperatures.

**Trasys® 9825** mold release coating has unique properties, making it an excellent release agent for epoxy, phenolic, or polyester resins. Unlike oily release agents, when properly applied, it does not interfere with post-finishing operations.

**Trasys® 9825** comes pre-diluted and is ready for use. Proper application results in superior release, and multiple releases are normal.

### Uses

**Trasys® 9825** is ideal for Compression Molding, Resin Transfer Molding, Vacuum Infusion, or Filament Winding of epoxy, phenolic, or polyester resins.

### Direction for Use

**Trasys® 9825** must be agitated before spraying. TraSys® 9825 mold release coating should be sprayed on hot, clean, and dry surfaces. For maximum results, preheat the mold surface to 150°C (302°F) before application. Properly applied, the coating will not be affected by water or most other materials that may come in contact with it.

### Recommended Procedure

1. Clean mold thoroughly, using glass or plastic bead media, dry ice, or abrasive pads and cleaning solvent or high pH detergent to remove all prior mold release and other sources of contamination.
2. Use low pressure spray equipment that provides a fine mist. After agitation, apply lightly to a hot mold, making certain that all areas of the mold are entirely coated.
3. Maximum performance can be achieved by applying up to 4 coats, waiting 5 minutes between coat.
4. Allow the final coat to cure for 5 minutes at 200°C (392°F), 10 minutes at 150°C (302°F), or 20 minutes at 100°C (212°F)

When spot touch-ups are applied, curing the freshly coated area with a heat gun will further enhance the bond between the coating and the mold's surface. Larger applications may require a bake cycle as described above. This will give a bond between mold and coating that will ensure the most effective coating for durability and cycle life.

### Typical Properties

Primary Polymer:	Thermoset Polysiloxanes
Specific Gravity:	1.0
Odor:	Slight
Color:	White
Flash Point:	None

### Storage and Handling

**Trasys® 9825** should be stored in a cool, dry, well ventilated area. Do not expose to freezing temperatures. Freezing will affect the physical condition, but will not damage the release effectiveness. Thaw at room temperature, and mix well before using.

Containers in use should be agitated before use and often during use. Drums will require a low rpm agitator to prevent phase separation in the storage container.

Breathing vapors should be avoided. If spraying, care should be taken to avoid inhaling mist or vapors, just as sprayed paint inhalation should be avoided.

Care should be taken not to expose TraSys® 9825 mold release coating to open flame or intense heat. Temperatures above 260°C (500°F) may cause chemical breakdown, resulting in toxic fumes. Always wash hands after handling TraSys® 9825 mold release coating.

### Shelf Life

**Trasys® 9825** has a shelf life of 18 months from the date of manufacture printed on the container label.

### Packaging

**Trasys® 9825** is available in:

- Cases of 4x1-gallon Part # TRA9825GLXX2
- 5-gallon pails Part # TRA9825PLXX2
- 55-gallon drum Part # TRA9825DRXX1

### Technical Assistance

Call: 800-227-5538 or 1 (717) 786-7355  
 Email: TimeSaver@StonerSolutions.com  
 Visit: StonerSolutions.com

**NO RISK GUARANTEE.** Stoner Molding guarantees 100% satisfaction or your money back. If you're ever dissatisfied with any Stoner Molding product, simply return the unused portion for a full refund.



**Stoner Molding Solutions**  
 You Mold It. We Release It.