



Releasomers® Water-Based Technology FOR THE ROTATIONAL MOLDING INDUSTRY

Benefits

Releasomers™ supplies the plastic rotational molding industry with the best in water-based mold release coatings. Free of alcohol and solvents, these coatings meet all existing and anticipated environmental regulations. **Releasomers™** coatings yield consistent, controlled release for maximum performance.

Rotational molders use **Releasomers™** release coatings because:

- Their long life can reduce the need for frequent operator spraying.
- They are safe, easy to use, and work with LLDPE, LDPE, MDPE, HDPE, XLPE, PP, plastisol, and nylon.
- They exhibit minimal transfer of release materials to the molded product.
- They produce consistent parts without warpage or sticking, allowing your production to run smoothly.
- Stoner provides qualified, expert technical support.

	Releasomers P440	Releasomers P441	Releasomers P442	Releasomers P446	Releasomers P448
Release Type	Semi-Permanent, General Purpose	Semi-Permanent, General Purpose	Semi-Permanent, High Release	Semi-Permanent, Light Release	Semi-Permanent, Light Release
Resin Carrier	Water	Water	Water	Water	Water
Typical Uses	Mold internals	Mold internals	Mold Internals	Part lines, Removable pins, High releases	Large flat surfaces, Difficulty in containing warpage
Solvent Free	Yes	Yes	Yes	Yes	Yes
Alcohol Free	Yes	Yes	Yes	Yes	Yes
Recommended Compatibility Compounds	LLDPE, LDPE, MDPE, HDPE, XLPE, PP, Nylon, Plastics	LLDPE, LDPE, MDPE, HDPE, XLPE, PP, Nylon, Plastics	LLDPE, LDPE, MDPE, HDPE, XLPE, PP, Nylon, Plastics	LLDPE, LDPE, MDPE, HDPE, XLPE, PP, Nylon, Plastics	LLDPE, LDPE, MDPE, HDPE, excellent for XLPE, PP, Nylon, Plastics
Apply to Mold	Warm* ²	Warm* ²	Warm* ²	Warm* ²	Warm* ²
Min. Cure Temp. / Min. Cure Time	132°C (270°F)* ³ / 5 minutes	132°C (270°F)* ³ / 5 minutes	132°C (270°F)* ³ / 5 minutes	132°C (270°F)* ³ / 5 minutes	132°C (270°F)* ³ / 5 minutes
Agitation Required	Slight	Slight	Slight	Slight	Slight
Product Cosmetics	Satin	Satin	Satin	Satin	Satin
Appl. Frequency	Varies with function	Varies with function	Varies with function	Varies with function	Varies with function
Action if Frozen	Thaw, Agitate	Thaw, Agitate	Thaw, Agitate	Thaw, Agitate	Thaw, Agitate

*² Hot to the touch; approximately 48°-60°C (120°-140°F).

*³ Inner mold temperature; normally accomplished by cycling coated mold when empty.

Technical Assistance

Call: 800-227-5538

Email: TimeSaver@StonerSolutions.com

Visit: www.releasomers.com

Stoner Molding Solutions
You Mold It, We Release It™

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A Brand of Stoner