

**Stoner**

# TraSys<sup>®</sup> 258

## Mold Release Coating

### Product Description

**Trasys<sup>®</sup> 258** is a translucent, solvent-based dispersion. When applied to a mold, it exhibits outstanding release or anti-stick properties and has a very low coefficient of friction. It is clean, non-oily, non-staining, chemically inert, and can function in temperatures to 260°C (500°F) or higher. TraSys<sup>®</sup> 818 is recommended for touch-up.

### Uses

Release life with TraSys<sup>®</sup> 258 is excellent, and multiple release into the thousands is obtainable. Excellent performance has been observed with compression molding silicone elastomer.

### Direction for Use

The recommended steps in coating a mold with TraSys<sup>®</sup> 258 are highlighted below. These steps can be accomplished in-house, if you are equipped with an oven that will reach 400°C (750°F) for the cleaning of the mold's surface and 360°C (680°F) for the curing of the coating.

#### Recommended Procedure

- Burn<sup>1</sup>:** Place mold in oven, and raise the mold surface temperature<sup>2</sup> to 370–400°C (700–750°F) for a period of 30 min. This will turn any excess rubber deposits to ash, but, more importantly, will burn any previous release out of the mold's pores, thereby thoroughly cleaning the mold.
- Blast:** 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.
- Spray:** TraSys<sup>®</sup> 258 must be applied to room temperature surfaces. TraSys<sup>®</sup> 258 can be applied with a pressure fed tank sprayer, such as those manufactured by Binks or Devilbiss. Equipment must be rated for handling flammable liquids. Gun pressure should be regulated to a maximum of 20 psi and pot pressure of 2-4 psi for application. We recommend four light coats, once from each direction, to coat places that may have been shadowed from raised parts. The spray will go on wet, dry quickly, and turn white when all solvents have evaporated. This enables the operator to see any areas that may have been missed. Touch up as necessary for complete coverage. There is no problem with overlapping of the spray causing discolouration of the finished part as with some other mold releases.
- Bake<sup>2</sup>:** Place mold in oven set at 360–365°C (680–690°F). When the mold surface temperature reaches the required temperature range of 360°C (680°F) minimum—365°C (690°F) maximum, maintain this surface temperature for a minimum of 10 min. It is essential that the coated surfaces reach these temperatures. When these conditions have been reached, the oven should then be turned off and dampers opened to allow quicker cooling of the mold.

### Storage and Handling

Store containers in a cool, dry, well ventilated area away from heat, sparks, and flames. Keep container tightly closed. The solvents used in TraSys<sup>®</sup> 258 mold release coating may dissolve natural skin oils; therefore, contact with the skin should be avoided to prevent dry skin. Adequate ventilation must be provided in work areas where TraSys<sup>®</sup> 258 mold release coating is being used. 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. Vapor from the solvent may develop slight pressure. Therefore, care should be exercised when opening containers. Containers should be closed promptly after removing part of the contents to avoid evaporation. If this product is exposed to extreme heat conditions from misuse or equipment failure, toxic decomposition products that include hydrogen fluoride can occur.

Hydrogen fluoride has an ACGIH threshold limit value of 3 parts per million parts of air as a ceiling limit, an OSHA permissible exposure limit (PEL) of 3 ppm of fluoride as an 8-hr time-weighted average, and 6 ppm of fluoride as a short-term exposure limit (STEL).

### Shelf Life

**Trasys<sup>®</sup> 258** has a shelf life of 18 months from the date of manufacture printed on the container label.

### Packaging

**Trasys<sup>®</sup> 258** is available in:

- Cases of 4x1-gallon Part # TRA258GLXX2

### Technical Assistance

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