



**TR INDUSTRIES**  
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## **TR-600 PVA** **MOLD RELEASE**

### **DESCRIPTION:**

TR-600 is a water and alcohol solution of polyvinyl alcohol resin coating for the releasing of polyester, vinyl-ester and epoxy resins from a variety of mold surfaces.

### **PRODUCT FEATURES:**

- ★ High resin content
- ★ Good heat and chemical resistance properties up to 300°F
- ★ Spray or brush applied
- ★ Tinted color for visual aid during application

### **USES:**

As a release agent for composite molding on all FRP tooling, metal and other hard surface molds, added insurance against part hang up for newly fabricated molds when used with paste wax release. Aids initial break-in during first 2-3 molding cycles.

- ★ Open mold hand or spray lay up
- ★ Resin Transfer/injection (RTM)
- ★ Vacuum bag
- ★ Polyester, vinyl-ester and epoxy resins

### **APPLICATION:**

TR-600 can be applied by spraying or brushing, however spray application is preferred to produce even film coverage. Spray over wax prepared master or mold with either an HVLP spray gun using 20-25psi air pressure or conventional spray gun at 60-90psi air pressure while holding spray gun 12-18 inches from surface. Apply fine mist coat followed by additional coats to form a continuous film without any sags or runs. Allow sufficient time between wet coats, approximately 15-45 minutes depending on temperature, humidity and film thickness. Once part is de-molded the film is easily removed with water on the molded part. If any laminate hang-up or sticking occurs, apply warm water to interface of mold and part so it works its way dissolving film allowing the part to float free.

### **NOTE:**

Porous molds or substrates (wood) should first be sealed with a heavy wax such as our 100 Series mold release. DO NOT apply to directly to plaster surface, must first be sealed with lacquer, polyester resin/primer or automotive sealer type coatings. Allow sufficient time for sealers and any wax coats to cure properly according to manufactures specifications before applying PVA film. Clean spray gun or other equipment with water after use.

### **PHYSICAL PROPERTIES:**

Dry Time: 15-45 minutes – varies depending on temperature, humidity and film thickness  
Wt/Gal.: 7.8-8.2 lbs./gal  
Flash Point: 76°F (24°C)  
Appearance: Green

### **STORAGE AND PRECAUTIONS:**

Use in a well ventilated area with adequate safety precautions. Contains flammable solvents. Store in a cool dry place and keep in original un-opened container away heat, open flame and sparks.

Available in gallon 4x1/cases, 5 gallon and 55 gallon drum. Please contact your local TR distributor or call direct.

*The information contained herein is based on tests considered to be reliable and accurate. Because of the wide variance of associated materials and conditions, however no warranty is expressed or implied. Each user is encouraged to prepare a test part for their particular application.*