

Mould Release Technology



Qiicote® Selector Guide

- Cleaner
- Sealer
- Semi-Permanent Mould Release
- Internal Mould Release
- For Thermosets and Thermoplastics

Qiicote
Mould Release Technology

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THERMOSET

PRODUCT	DESCRIPTION		COMPONENT MATRIX							MOULD MATERIAL					APPLICATION						PACK SIZE			
			Gelcoat		Thermoset Resin Systems					Epoxy composite	Polyester / gelcoated	Metal	Sealed Tooling Block	Silicone	Application Temp. (°C)	Application	New mould - number coats	Cure time between coats	Post cure time - new mould	Post cure time - used mould		Sprayable		
			Epoxy	Unsaturated polyester	Epoxy	Unsaturated polyester	Vinylester		Phenolic															
C110	Heavy duty cleaner for the removal of resin residue, sealant & adhesive, wax grease and contamination.									✓	✓	✓	✓		15 - 30	Brush or wipe on, allow to dissolve contamination and wipe off with a clean cloth.	1							1l / 5l
C120	Light solvent cleaner for the preparation of the mould surface prior to the application of Qiiicote mould release									✓	✓	✓	✓		15 - 30	Brush or wipe on, wipe off immediately with a clean cloth.	1-2							1l / 5l
C130H	Cleaner for high temperature mould tools. Will remove heavy soils & residue from the mould surface.									✓		✓			<100	Brush or spray on hot mould (<100°C) or wipe on (<60°C) and allow to dissolve contamination. Wipe off with a clean cloth.	repeat application as necessary					✓		1l / 5l
S200	Sealer - foundation coat used to seal micro porosity and light surface scratches.	430								✓	✓	✓	✓		15 - 30	Apply a thin wet film by wiping, brushing or spraying. Immediately wipe off and polish with a clean cloth.	3	23°C - 30 mins 60°C - 15 mins	23°C - 60 mins 120°C - 15 mins	n/a		✓	1l	
R370 R375 R377	Multi-release, low slip (R370), medium slip (R375), or high slip (R377), high gloss semi-permanent mould release.	190	✓	✓	✓	✓	✓		✓	✓	✓	✓		15 - 60	Apply a thin wet film by wiping, brushing or spraying. Immediately wipe off and polish with a clean cloth.	5	23°C - 15 mins 60°C - 6 mins	23°C - 60 mins 120°C - 10 mins	23°C - 30 mins 120°C - 6 mins		✓	1l / 5l		
R380*	Durable, multi-release, high gloss semi-permanent mould release.	400	✓	✓	✓	✓	✓		TBC	✓	✓	✓	✓		15 - 60	Apply a thin wet film by wiping, brushing or spraying. Immediately wipe off and polish with a clean cloth.	5	23°C - 15 mins 60°C - 6 mins	23°C - 60 mins 120°C - 10 mins	23°C - 30 mins 120°C - 6 mins		✓	1l / 5l	
AQ610	Multi-release, water-based semi-permanent mould release with high thermal stability.	250	✓	✓	✓	✓	✓			✓	✓	✓	✓		20 - 200	At <60°C apply a thin wet film by wiping or brushing. Immediately wipe off with a clean cloth and polish with a fresh clean cloth. At >60°C spray on and leave to dry.	6	23°C - 15 mins 60°C - 6 mins	23°C - 60 mins 120°C - 10 mins	23°C - 30 mins 120°C - 6 mins		✓	1l / 5l	
SILICONE SHIELD	Release agent for preserving seals.	100	✓	✓	✓	✓	✓			✓	✓	✓	✓		15 - 60	Apply a thin wet film by wiping, brushing or spraying.	1-4	23°C - 15 mins 60°C - 6 mins	n/a	n/a		✓	5l	
SMART900	Internal mould release for pultrusion moulding.	200			✓				✓			✓			n/a	Add 0.5% - 1.5% to resin system and mix thoroughly.	n/a	n/a	n/a	n/a	n/a	n/a	5l	

*New product - data is provisional at time of issuing.



THERMOPLASTIC

PRODUCT	DESCRIPTION	PROCESSING TEMP. (°C)	COMPONENT MATRIX							MOULD MATERIAL					APPLICATION					PACK SIZE		
			Polyethylene PE	Polypropylene pp	Polyamide (Nylon)	Polyurethane PU	Polyethylene Terephthalate (Polyester) PET	Polyphenylene sulfide pps	Polyetheretherketone PEEK	Epoxy composite	Polyester / gelcoated	Metal	Sealed Tooling Block	Silicone	Application Temp. (°C)	Application	New mould - number coats	Cure time between coats	Post cure time - new mould		Post cure time - used mould	Sprayable
S200	Sealer - foundation coat used to seal micro porosity and light surface scratches.	430													15 - 30	Apply a thin wet film by wiping, brushing or spraying. Immediately wipe off and polish with a clean cloth.	3	23°C - 30 mins 60°C - 15 mins	23°C - 60 mins 120°C - 15 mins	n/a	✓	1l
R400	High temperature, multi-release, high slip, high gloss semi-permanent mould release.	430	✓	✓	✓	✓	✓	✓	✓						15 - 100	Apply a thin wet film by wiping, brushing or spraying. Immediately wipe off and polish with a clean cloth.	5	23°C - 15 mins 60°C - 6 mins	23°C - 60 mins 120°C - 10 mins	23°C - 30 mins 120°C - 6 mins	✓	1l / 5l
AQ620R	Sprayable, multi-release, water-based semi-permanent mould release with high thermal stability for roto moulded thermoplastic parts.	250	✓	✓	✓	✓	✓								20 - 200	At <60°C apply a thin wet film by wiping or brushing. Immediately wipe off with a clean cloth and polish with a fresh clean cloth. At >60°C spray on and leave to dry.	6	23°C - 15 mins 60°C - 6 mins	23°C - 60 mins 120°C - 10 mins	23°C - 30 mins 120°C - 6 mins	✓	1l / 5l



Find out what PRF can do for your business

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Important Notice

All statements, technical information and recommendations offered are only for consideration and evaluation. Whilst they are believed to be accurate they are not guaranteed and are provided without warranty of any kind. No undertaking is given that the goods/products supplied are fit for its particular purpose. The buyer/user shall assume all risks and liabilities in connection therewith.

Qicote Selector Guide iss 2.0 Oct 2015



Prepreg



Reinforcements



Resin



Aerospace Adhesives



Shears



Tooling Block



Mould Release



Consumables