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

Releasomers™ P442
Water Based Extra Heavy Duty Rotational Mold Release



Product Description

Stoner® Releasomers™ P442 Semi-permanent, non-transferring mold coating for thermoplastics, elastomers, and more. Apply to molds to let parts release quickly and easily.

P442 ADVANTAGES:

- Water-based semi-permanent coating.
- General purpose.
- Higher amount of release than P441 for greater release.
- Freeze – thaw stable.

Uses

Stoner® Releasomers™ P442 is used for thermoplastics, elastomers, and more for quick and easily parts releasey.

Directions for Use

Recommended Procedure

1. Clean mold thoroughly to remove all prior mold release and other sources of contamination.

2. If spraying, use spray equipment that provides a fine mist. When wiping, lightly dampen a clean cloth with Releasomers P442 after agitation. After agitation, apply lightly to the mold's surfaces, making certain that all areas of the mold are entirely coated.

3. A minimum inner mold temperature of 132°C (270°F) is recommended to cure the release. This can easily be accomplished after application by running the mold empty through a full production cycle with the oven temperature at 170°C (350°F). Proper curing will give a bond between mold and coating that will ensure no transfer of coating to the first molded part, as well as ensure the most effective coating for durability and cycle life.

4. 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.

Storage and Handling

Keep container tightly closed. VAPOR MAY BE HARMFUL. Use only with adequate ventilation. Avoid contact with eyes. Do not ingest. Keep out of the reach of children. Before using, for more specific health and safety information, refer to the Material Safety Data Sheet available for this product from Stoner. Contains: water-based release agent.

Packaging

Stoner® Releasomers™ P442 is available in:

• 1-gallon	Part # P442GL
• 5-gallon pails	Part # P442PL
• 55-gallon drum	Part # P442DR

Technical Assistance

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