

MIRACLE GLOSS™
Professional Mold Release Since 1942

MIRACLE GLOSS™ MG681

Semi-Permanent Release Agent

Overview:

MG681 Semi-Permanent Release Agent is a rapid curing polymer release agent that provides multiple releases for molders of polyester, vinyl esters, DCPD, and epoxy resins. It is universally excellent for open or closed molding.

Advantages:

- Will not transfer
- Minimal streaking
- 400°C temperature stability
- Multiple releases between applications
- Compatible with all non-porous tooling surfaces

Directions for Use:

1. Mold surfaces should be cleaned to remove any previous waxes, sealers, compounds or other surface contaminants. A mild polish may be required to remove any previous semi-permanent sealers or release agents. Afterwards use MG380 Mold Cleaner.
2. Perform a tape test over several areas of the mold to insure proper and complete removal of prior mold release agents or sealers.
3. Apply 2 coats of **MG480 Mold Sealer** as per application instructions.
4. **MG681 Semi-Permanent Release Agent** can be applied by spray, roller, or wiping on. Regardless, only a very thin film is required. If wiping on, a clean 100% cotton towel or reinforced paper towel is recommended.
5. Apply to an area of approximately 3-4 square feet and while the film is still wet, buff off with a clean micro fiber towel. Continue with small sections of the mold until 100% of the mold surface has been sealed and wiped off.
6. If streaking occurs, rewet the mold surface and immediately wipe off.
7. Repeat Step 5 four or five times waiting a minimum of 15 minutes between coats.
8. Wait a minimum of 30 minutes after the last coat for complete cure before proceeding with molding.
9. When it is apparent that the ease of release is impacted, apply one more coat of MG681 and allow to cure for 30 minutes before returning the mold to production.

Precautions:

Keep away from heat, sparks, open flames, and hot surfaces. No Smoking. Ground or bond container and receiving

equipment. Use explosion-proof electrical/ventilating/lighting equipment. Avoid breathing vapors. Use only outdoors or in a well-ventilated area. Contaminated work clothing must not be allowed out of the workplace. Store in a well-ventilated place. Keep container tightly closed. Store locked up. Dispose of contents or container in accordance with applicable local regulations. KEEP OUT OF REACH OF CHILDREN.

First Aid:

If Inhaled: Remove person to fresh air and keep comfortable for breathing. If on skin: Wash with plenty of soap and water. If on skin: irritation or rash occurs: Get medical attention. Wash contaminated clothing before reuse. Call a Poison Center or physician if you feel unwell. Emergency Phone: +1 (703) 741-5970 (CHEMTREC) • (800) 424-9300 in the US.

Storage and Handling:

MG681 is moisture sensitive. Reseal the lid immediately after each use. This product contains flammable solvents. Store in a cool, dry place. Use in a well-ventilated area. Consult SDS prior to use. Shelf life is 6 months from date of initial use.

Packaging:

MG681 Semi-Permanent Release Agent is available in 1 gallon cans, 4 cans per case.

Part # MG681GLXXX1

Technical Assistance:

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

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