



MIRACLE GLOSS® MG670

Ambient Cure Water Based Semi-Permanent Mold Release



Product Description

Miracle Gloss® MG670 Water Based Semi-Permanent Mold Release Agent is a unique, ambient cure water based semi-permanent mold release agent designed to release phenolic, epoxy, isophthalic, orthophthalic, DCPD and vinyl ester resin systems. It combines fast cure with outstanding chemical and abrasion resistance. It gives a smooth, continuous film with unmatched adhesion to the mold.

Miracle Gloss® G670 ADVANTAGES:

- Ambient cure. Does not require heat to cure.
- Non-Flammable.
- VOC free.
- Will not transfer to the part.
- Application temperature up to 400°C (750°F).
- Tough, abrasion resistant film.
- Excellent adhesion to mold surfaces.
- Stable resin emulsion – 1 year shelf life.

Uses

Miracle Gloss® MG670 is designed to release phenolic, epoxy, polyester or vinyl ester resins in compression molding, resin transfer molding, vacuum infusing, casting, hand layup, or spray up processes.

Direction for Use

1. Clean mold surfaces 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.

2. Afterwards use a Stoner Mold Cleaner and perform a tape test to ensure the mold is properly cleaned.
3. Apply either 2 coats of **MG480 Sealer**, OR 4 coats of **MG660 Water Based Sealer** and apply per their application instructions.
4. **MG670 Semi-Permanent Release Agent** can be applied by spray, roller or wiping on. Regardless, only a very thin film is required. If wiping on, use a clean 100% cotton towel or reinforced paper towel is recommended.
5. Apply to an area of approximately 3-4 square feet, let sit for 2 minutes, then buff off with a clean microfiber towel. Continue with small sections of the mold until 100% of the mold surface has been sealed and wiped off.
6. Repeat Step-4 one or two times, waiting a minimum of 15 minutes between coats.
7. Wait 30 minutes after the last coat for complete cure before proceeding with molding.
8. When it is apparent that the ease of release is impacted, apply one more coat of **MG670** and allow to cure for 30 minutes before returning the mold to production.

Note: A 30–60-minute cure time of the last coat (or recoat) will substantially increase the number of release cycles.

Storage and Handling

Miracle Gloss® MG670 should be stored in a cool, dry, well-ventilated area. Do not expose to freezing temperatures.

Packaging

Miracle Gloss® MG670 Semi-Permanent Mold Release Agent is available in:

- 1-gallon plastic bottle Part # MG670GLXXXX1
- 5-gallon plastic pail Part # MG670PLXXXX1
- 55-gallon plastic drum Part # MG670DRXXXX1

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.



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