

MIRACLE GLOSS[®] Release System for Epoxy Wind Blades

Professional Mold Release Since 1942



Product Description

The Miracle Gloss release system for epoxy wind blades incorporates a choice of sealers (solvent or water-based) and an ambient temperature cure water-based semi-permanent release agent that provides multiple releases with minimal transfer.

Miracle Gloss[®] Release System Advantages using MG660 Sealer & MG670 Release Agent

- Non-Flammable
- VOC free
- Minimal transfer to the part
- Multiple releases
- Excellent adhesion to mold surfaces
- Stable resin emulsion – 1 year shelf life

Miracle Gloss Release System Advantages using MG480 Sealer and MG670 Release Agent

- **MG480 Solvent Sealer** cures at ambient temperature.
- **MG670 Release Agent** is nonflammable, VOC free, and cures at ambient temperature
- Minimal transfer to the part
- Multiple Releases
- Excellent adhesion to mold surfaces

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.

Afterwards use a Stoner Mold Cleaner and perform a tape test to ensure mold is properly cleaned.

2. Apply either 4 coats of **MG480 Solvent Sealer**, **OR** 4 coats of **MG660 Water Based Sealer**. Apply each coat and allow to dry for 15 minutes. **DO NOT** wipe or buff off any coat. Repeat 3 more times.
3. If using **MG480 Solvent Sealer**, wait 30 minutes after the 4th coat before applying **MG670**.
4. If using **MG660 Water Based Sealer**, after the 4th coat bake the sealer for 1 hour @ 80°C. Cool to room temperature before applying **MG670**.
5. **MG670 Semi-Permanent Release Agent** only requires 2 coats. Apply the 1st coat and wait 15 minutes before applying the 2nd coat. **DO NOT** wipe or buff off either coat.
6. Wait 30 minutes after the last coat for complete cure before proceeding with molding.
7. When it is apparent that the ease of release is impacted, apply one more coat of **MG670**. **DO NOT** wipe or buff off and allow to cure for 30 minutes before returning the mold to production.

Storage and Handling

Miracle Gloss[®] **MG660 & MG670** should be stored in a cool, dry, well-ventilated area. Do not expose to freezing temperatures. **MG480 Mold Sealer** is moisture sensitive. Reseal the lid immediately after each use. This product contains flammable solvents

Packaging

All products are available in 1-gallon containers.

- **MG480 Solvent Sealer** Part # MG480GLXXXX1
- **MG660 WB Sealer** Part # MG670GLXXXX1
- **MG670 Release Agent** Part # MG670GLXXXX1

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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