

Diamond Shield Mould Finish M9

Technical Data Sheet

**PRODUCT
DESCRIPTION**

Diamond Shield Mould Finish is an alcohol based single component clear coating developed for the rotational molding industry.

INTENDED USE

Diamond Shield Mould Finish M9 is a semi permanent mould release designed for the rotational mould industry using PE material up to 400°C. The coating is sprayed and baked onto clean, blasted mould surfaces to give significantly improved mould release properties and enhanced surface finish of the molded part. The coating eliminates the need for other spray on mould releases reducing down time between cycles.

PROPERTIES/BENEFITS

- Long lasting easy to clean coating.
- Excellent mould release qualities
- Resistant to abrasion and scratching
- Resistant to acid and solvents
- Heat Resistant to 400°C
- Improves finish of molded part

**PRACTICAL
INFORMATION FOR
DIAMOND SHIELD
MOULD FINISH**

Colour	Transparent
Typical Thickness	5 –10 µm after curing
Theoretical Coverage	40m ² /L, with 0.5 nozzle
Practical Coverage	Allow appropriate loss factors
Method of Application	Spraying
Drying Time	
Open Mould	220°C for 30 minutes
Temperature Stability	From -20°C to 400°C
This product is not to be thinned-down.	

SURFACE PREPARATION

Surfaces need to be dry, free of dirt, dust, grease and silicones. Aluminum should be alkaline cleaned.

APPLICATION GUIDE

Spray gun setup	0.5 to 1.3mm
Spray pressure	2-3 bar
Mould Preparation	Preheat mould to 30°C
Application	One open (dust) coat followed by 2 medium (wet) closed coats allowing 10-30 minutes between each coat for product to "tack off". Avoid excessive thicknesses which may cause the product to run.
Drying Time	After the metal has reached the appropriate temperature, cure for 220°C for 30 minutes;
Clean up	Butyl Acetate, Acetone
Mixing	Supplied ready to spray

CONSUMPTION

Depending upon the surface to be treated, a result of about 40 - 50 m² may be achieved with 1 kg.

AVAILABILITY

1 kg box, 5 kg canister, 25 kg drum. Other packing forms/sizes are possible after prior consultation with Unicoatings Pty Ltd and according to transport possibilities/regulations.

STORAGE

The product may be stored for at least 12 months in its original packing. Protect from frost and direct sunlight.

DISPOSAL

Empty containers as well as any remaining product must be disposed of according to the local laws and regulations or it must be taken to the community collection point for such materials.

***SAFETY/PROTECTION
MEASURES***

When using this product please take note of the instructions on the Material Safety Data Sheet (MSDS). When spraying, we recommend the use of Nitrile gloves, full suit and full air supplied hood. The use of chemical preparations should only take place when safety measures are observed and are always out of reach of children. The technical information given here is according to the latest technical knowledge and composed from our own experience. We cannot be held responsible for any misuse of this product. In the event of a new version of this information becoming available - this information here set out is no longer valid.
