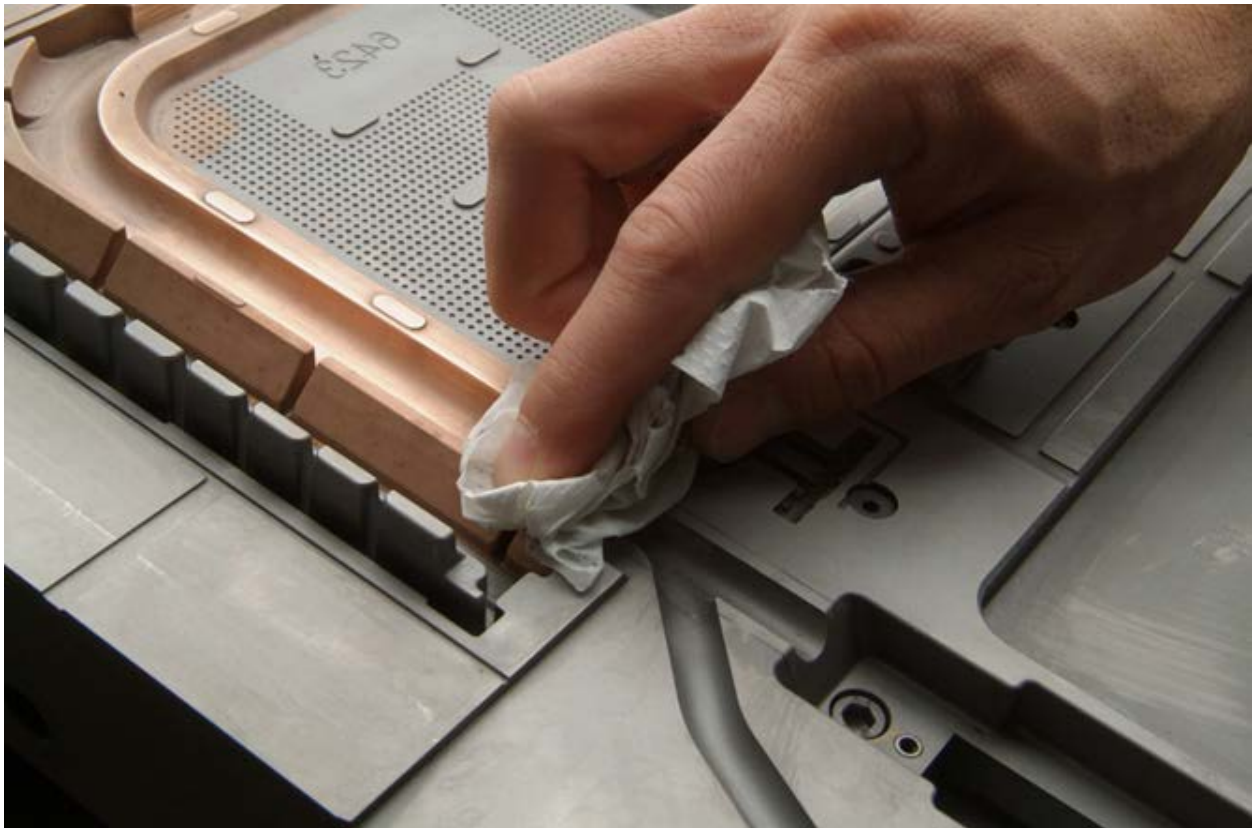


DT-6060 - Field Application Instructions

Note: Dyna-Tek DT-6060 can be used by itself as a mold release when pulling the molds out of service and sending them off-site for a professional application is not an option. For optimum results, molds coated with our Trisilon base coat and then subsequently coated with DT-6060 will enjoy a longer operational life as the Trisilon base coat's matrix provides for greater durability; yet has excellent inter-coat adhesion with the DT-6060.



- Clean tool surface insuring oils, dirt and previously used release agents are completely removed.
 - If surface cleaning isn't sufficient to clean the mold, we suggest other cleaning methods and/or the use of our DT-520 Nano-adhesion promoter.
- Dampen a lint-free pad or cloth (available through Dyna-Tek as well) and lightly cover the mold's entire surface in a back and forth motion insuring 100% coverage with a thin coat. Do not allow to pool.
- Dry film thickness will be approximately 3-5 microns... 5-7 with the use of DT-520 Ad Pro.

- Assuming the environment and mold's substrate temperature is at least 70 – 90 degrees (F.), allow the coating to dry to the touch for 30-40 minutes and then reapply a second coat as listed above.
 - During the first and second applications, you will feel the cloth's resistance go away as it glides over the surface. This is the coating's covalent bonding action occurring as the oxygen molecules are being displaced and the pores of the substrate fill with the 6060. Once the substrate's pores have been filled in, the coating begins to build its 2-5 micron layer at the surface.
- Allow to cure for 30 minutes and the tool is ready for service
 - For optimum performance either a 5 day (ambient temp) cure time, and/or a heat cure (after an ambient cure for 30-40 min.) at 350 °F for 2 hours on the initial 2-coat application only is recommended.
- Economical
 - Approximate coverage of 4,000 sq. ft. per gallon
- Safe; comes in gallon packages vs. 55 gallon drums for competitive products that cover far less area/gallon

DT-6060 is made to revitalize the non-stick performance, re-seal any opened pores (from wear and tear) and protect the molds from the rigors of operations.

Subsequent reapplications -

Clean surface of any foreign material and repeat the application instruction above.

- Re-coats bond to previously coated surface and do not create a mil thickness build