



Application Instructions

DT-6060 Mold Release - Product Application Instructions

May 2018

Description

DT-6060 is formulated as a semi-permanent mold release; used in conjunction with DT-420 for molds and tooling of either metallic or composite substrate(s) and has a proven track record for use with toughened Epoxy resin systems, polyester, vinyl-ester, phenolics, and BMI resins.

Formulated to provide outstanding release and slip properties, yet DT-6060 adheres to itself even when fully cured thereby making it recoatable. DT-6060 is very efficient; with coverage rates of 3500 – 4000 sq. ft. per gallon.

For more information on recoating DT-6060, see the “Tech Bulletins” in the Downloads of our site at www.Dyna-Tek.com/Downloads

General Instructions

Formulated as an outstanding Mold Release to complement a new application of DT-420 Mold Sealer provided DT-420 has been fully cured. If the DT-420 has been exposed to contaminants, clean with the recommended methanol solvents (see below) first and make sure the surface has fully dried prior to applying DT-6060.

As DT-6060 experiences wear and tear resulting in diminished release properties, recoating is simple production friendly. Assuming the tooling/mold doesn't require re-sealing as well, recoating over DT-6060 requires only that the surface be cleaned again using the recommended methanol solvents, allow to fully dry, and then reapply DT-6060. NO removal of prior coats of DT-6060 is required.

Safety Data

Be sure and read the Safety Data Sheet (SDS) prior to applying DT-420.

Application

The following instructions are deemed to be the recommendations of Dyna-Tek. Deviations from these applications can produce good results as well, however long-term testing by Dyna-Tek is still inconclusive and therefore deviating from the methods defined below are not recommended. Dyna-Tek recommends:

1. For consistent results, apply DT-6060 in well illuminated and climate-controlled environments.
2. Use clean, lint-free cloths such as Sontara blue cloths (pn E-4143) for wiping DT-6060 on to surfaces.
3. Pour Dyna-Tek DT-6060 on to a folded cloth until it is wet, but not dripping. Do not pour DT-6060 on to the tool surface. It depends on the part, and level of finish required, but working within an area of 4 square feet is usually recommended.
4. Wipe DT-6060 over the mold surface, using care to wipe on in a smooth and continuous manner. Assuming it is being applied over DT-420 a thin, wet film will be seen. Areas where this appearance is not seen may indicate a lack of sealer or contaminants still remaining on the surface. DT-6060 is formulated as a thin film coating; 2-3 μ when cured, so do not try to build coating thickness.
5. Ambient cure: If thermal cure is not available, depending on the application, DT-6060 can be put back into service is as little as 12 hours.
6. Thermal cure: Allow the part/coating to flash off and ambiently cure for a minimum of 60 minutes at room temperature (ideally 60° - 70° F.). Thermal cure using a convection oven, or any other oven capable of providing a consistent temperature throughout and has oxygen present. Cure temperature of 121° C./250° F) for a minimum of 1 hour.
7. Upon completion of curing, allow the tool to cool to room temperature before returning into service.

Touch-up and Re-coating.

Unlike DT-420 which is formulated to adhere to itself once cured, DT-6060 is designed to be reapplied to itself as many times as needed until the Mold Sealer begins to wear off. To re-apply:

- Prep the surface by cleaning it with methanol solvents such as Isopropyl Acetate, T-Butyl Acetate or Denatured Alcohol; ensuring that the surface is free of any impurities.
- Allow to fully dry.
- Re-apply DT-6060 to the surface as instructed above.

Additional Information

For more technical information on DT-6060, visit the [Tech Bulletins](#) section of our website that may answer further questions.

The technical and application instructions herein are believed to be accurate and reliable. We do not assume the responsibility for the results obtained by others using methods we have no

control. It is the user's responsibility to determine the merits and suitability of our products based on the different variables for the application; including any hazards potentially involved in the handling and use thereof. Dyna-Tek specifically disclaims any warranties, either expressed or implied from the use of our products

Storage

This product is classified as a flammable and should be stored pursuant to the regulations in your area. Product should be stored at room temperatures, not to exceed 75° F. (24° C.)

If permissible, pour the needed material into a smaller container when working with it to avoid the coating in the primary storage container losing its solvents to evaporation. Never return the unused portions back to the container. Always make sure the container lids are securely tightened. Allowing the product to sit with the lid off while working will cause the solvents to evaporate thereby resulting in the product's formulation falling out of compliance for it to work well.

Note

The technical and application instructions herein are believed to be accurate and reliable. We do not assume the responsibility for the results obtained by others using methods we have no control. It is the user's responsibility to determine the merits and suitability of our products based on the different variables for the application; including any hazards potentially involved in the handling and use thereof. Dyna-Tek specifically disclaims any warranties, either expressed or implied from the use of our products.

Intellectual Rights

DT-420 and related products of coating compositions are covered under U.S. 9,856,400 issued January 2, 2018. Coatings formed within this series are the subject of pending U.S. Patent Application No. 15/820,853 filed November 22, 2017.