

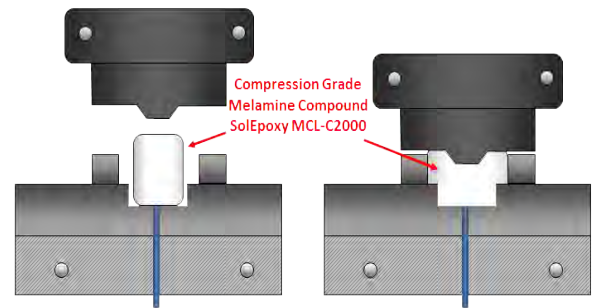
SolEpoxy™ MCL-C2000



Compression-grade melamine mold cleaning compound



SUPPLIED IN POWDER OR SQUARE PREFORMS



COMPRESSION-GRADE MELAMINE
MOLD CLEANING COMPOUND



MOLDS EASILY AND EFFECTIVELY
TO CLEAN MOLD STAINS AND RESIDUES

DESCRIPTION

SolEpoxy™ MCL-C2000 is a **compression-grade melamine mold cleaning compound** designed for cleaning transfer molding equipment and epoxy molds.

MCL-C2000 **molds very easily and effectively**. Most cleaning processes need **no more than three shots to completely clean molds** of all stains and residues.

MCL-C2000 can be supplied in loose powder or as square preforms, each with an easy break center "V-Groove," which can be used for applications requiring smaller charge sizes. Powder or preforms are supplied in three gallon plastic pails containing 20 lbs per pail.



ROHS AND REACH COMPLIANT

ADVANTAGES

- ▶ Made for transfer-mold equipment
- ▶ Compression-grade
- ▶ Used in production for the cleaning of epoxy mold compound
- ▶ Supplied in 2-inch-square pellet or powder form
- ▶ Used on conventional and automold presses

Cleans molds very effectively. Most cleaning processes do not need more than three shots to completely clean molds of all stains and residues.

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RECOMMENDED CURE CONDITIONS

Clamping Pressure	10 tons minimum	
Cure Conditions, minutes,	@ 150 - 190 °C	2 - 5
Moldability ¹	■■■■■	

UNCURED PROPERTIES

RoHS / REACH Compliant	yes	
Shelf Life, from date of manufacture, months,	@ 10 °C	24

TYPICAL CURED GENERAL PROPERTIES

Available Colors ²	☉ White	
Specific Gravity, g/cc	1.50	
Spiral Flow, inches,	@ 177 °C	3

¹ rating: ■■■■ poor, ■■■■ fair, ■■■■ good, ■■■■ excellent

² custom colors may be possible to formulate

MOLD CLEANING PROCEDURE

Before molding any new material or at the beginning of a new molding cycle, it is ESSENTIAL that the mold be completely clean from the previous molding.

This point becomes more important for matte finish molds as residue can be lodged in the charmillé which is undetectable to the naked eye. Any routine mold cleaning procedure should insure that the mold is perfectly clean before beginning the next cycle. If more than 8 cleaning shots are necessary, the cleaning frequency should probably be increased. For new molding compound trials, extra care should be taken since many materials are incompatible and even the slightest residue could hinder the evaluation or lead to misinterpretation of the results.

The compression mold cleaning process is the most effective for cleaning molds with large cavities and long or double runner systems. It is also the only method that will clean land areas and mold vents. A generally

acceptable mold cleaning procedure for MCL-C2000 is as follows:

1. In most cases, MCL-C2000 can be used at normal molding temperatures. The recommended range is 150-190°C. Before starting the cleaning process, the press clamping pressure should be reduced to 10 tons maximum.
2. Place MCL-C2000 squares adjacent to each other over the cavity and runner area of the lower half of the mold. To reduce waste, the preforms may be broken in half as long as the area to be cleaned is covered by preforms. Material may be placed in the transfer pot in order to clean this and the plunger face.
3. Set press to manual mode and close mold halves until the compound just touches the top half of the mold. Wait for 5 seconds and then completely close the mold halves. Excess material will squeeze out from the parting line of the mold. If cleaning material is placed in the transfer pot, the plunger sequence should be activated once the mold is completely closed.
4. Cure the cleaning compound for 2 minutes. Cleaning is generally more effective with longer curing time. For extremely dirty molds, the cycle time can be extended for up to 5 minutes.
5. Open the mold and remove all cured material from cavities, runners, gates, land areas, and vents. It is also important to check relief areas, as compound left in these holes could cause damage to locating pins.
6. Inspect the cured cleaning material for discoloration and repeat steps 2 to 5 until the material is free from stain.
7. Once the mold is clean, return the press to standard process conditions and prepare the mold by applying a thin wax layer and molding 3 to 5 shots of conditioning compound or 3 to 5 dummy shots of standard mold compound using 2 to 3 times the normal curing cycle time.
8. Resume normal molding. The first three shots of standard molding compound should be cured 2 to 3 times longer than normal in order to insure that press equilibrium and optimum release characteristics are achieved.

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STORAGE & HANDLING

Powder should be stored at 10°C or below, in closed containers. After removal from cold storage, the material **must be allowed to come to room temperature** in the sealed container to avoid moisture contamination. Suggested waiting time is 24 hours. Please consult our *Product Handling Recommendations for Coating Powders*.

For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

DATA RANGES

The data contained herein may be reported as a typical value and/or range of values based on actual test data and are verified on a periodic basis.

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