



## Semi-permanent Mold Release Coating for Composite Molding Systems

### Dyna-Tek DT-6060 Mold Release Product Data Sheet

#### Product Summary

In some cases, DT-6060 can be used as a standalone product when used on relatively smooth, low porosity substrates and finishes. It is best used with one of our surface sealers such as DT-420, DT-405 or DT-432. Used together, this combined coating system has a proven track record of increased lay-up production due more cycles without recoating, reduced wear and tear on molds/tooling (thus higher ROA's), and increased quality results.

- Proven performance in use with all composite resin systems including toughened Epoxy resin systems, as well as polyester, vinyl-ester, phenolics, BMI.
- Excellent adhesion to most tooling substrates:
  - All metals
  - INVAR
  - Plated finishes
  - Composite tools.
- High temperature resistance of over 750° F/400° C
- Semi-gloss, clear finish.
- Fully cured, DT-6060 will not transfer silicone to molded parts.
- DT-6060 ambiently fully cures in 60 minutes.
- DT-6060 can be re-applied over itself as often as necessary to revitalize the release properties without any measurable coating thickness build-up.
  - There will be a loss in performance once production wear and tear begins to remove the sealer coating.
  - To re-coat, clean the mold surface with isopropyl acetate or tert-butyl acetate, allow to dry, and then re-apply DT-6060.
- No out-gassing during production (see our Tech Bulletin – “Thermal Analysis of DT-6060”)

#### Product Characteristics

- Clear – semi gloss
- Pencil Hardness (ASTM D3363) – 6h
- Mandrel Bend (ASTM 522) – 0 mm coating loss or signs of cracking with 180° rotation.
- Solvent Based Polymer
- Odor: Solvent

- No Chlorinated Solvents
- One (1) year shelf life from date of manufacture with observance of “special precautions” (below)
- Handling & Storage precautions:
  - DT-6060’s polymerizing catalysts are oxygen molecules and moisture. Therefore, to preserve bottled products, it is best to reseal containers when not using.
  - Follow all safety precautions and open slowly if you observe any expansion of the container.
  - Do NOT store where it can be exposed to sunlight.

### **Product Application**

- Easy to apply. Can be wiped or spray on.
- DFT coating thickness of 1-2  $\mu$ .
- Curing Options:
  - At room temperature, 6060 will dry to the touch in 20 min. and ideally allowed to air dry for 60 minutes at 60° - 110° F.
- Application temperature - 50° - 90° F.

### **Specific Benefits**

- DT-6060 exhibits increased durability and adhesion when used with DT-420 or one of our other sealers.
- Higher tooling ROI, Lower tooling maintenance costs.
  - Tooling life is extended as reapplications of DT-6060 requires no sanding, dry ice blasting or other forms of mechanical etching.
- Increases lay-up cycles, Reduces downtime/set-ups, More production through-put.

### **Safety Information**

Refer to our SDS for all safety data.

**For more information, call 816.444.6266 and ask for Technical Support or email [info@dyna-tek.com](mailto:info@dyna-tek.com)**