



## Lower-VOC Semi-permanent Aerospace Mold Release

### DT-6060e Mold Release - Product Data Sheet

#### Product Summary

DT-6060e 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-6060e will not transfer silicone to molded parts.
- DT-6060e ambiently fully cures in 60 minutes.
- DT-6060e can be re-applied over itself as often as necessary to revitalize the release properties without any measurable coating thickness build-up.
  - To re-coat, clean the mold surface with isopropyl acetate or tert-butyl acetate, allow to dry, and then re-apply DT-6060e.

VOC Testing - per EPA Method 24, reporting in pounds per gallon (2020)							
	ASTM D1475	ASTM D2369				Calculated VOC Results	
Dyna-Tek Products	Average Density	Average Solids %	Weight % VOC's	EPA VOC (grams/liter)	Material VOC (Grams/Liter)	EPA VOC (lbs./gal.)	Weight % VOC
DT-420 Mold Sealer	6.70	9.87%	90.13%	723	723	6.03	90.13%
DT-6060 Mold Release	6.78	0.89%	99.11%	795	795	6.63	99.11%
DT-6060E - lower VOC version	0.81	0.86%	99.10%	747	406	6.24	50.40%

*NOTE: Reduction in VOC's between 6060 and 6060e was the result of replacing the IPA solvent with VOC-exempt Tert-Butyl Acetate.*

#### Product Characteristics

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- Clear – semi gloss
- 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 μ.
- Curing Options:
  - At room temperature, 6060 will dry to the touch in 30 min. with full cure within 60 minutes at 60° - 70° F.
- Application temperature - 50° - 75° F.

**NOTE: For those experienced with using DT-6060, the 6060e will exhibit a slightly slower flash-off to achieve dry to the touch, however, it will be fully cured within 1-hour just like DT-6060.**

## Specific Benefits

- DT-6060 will exhibit better release properties, 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

Always review and defer 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)