

## TECHNICAL DATA SHEET

DryFilm lubricant & release agent **RapidChem™ Lubricant V522**

<b>Description</b>	<p><b>RapidChem™ Lubricant V522</b> meet with ISO 10993 biological evaluation of medical devices is a translucent, solvent-based dispersion. When applied to a mold, it exhibits outstanding release or antistick properties and has a very low coefficient of friction. It is clean, non-oily, non-staining, chemically inert, and can function in temperatures to 260°C (500°F) .</p>								
<b>Direction for Use</b>	<p><b>Blast:</b> After the mold has cooled, bead blast all surfaces to be coated. All dust must be blown off and surfaces wiped with a residue-free solvent using a clean rag. A recommended alternative would be to spray the bead blasted mold with residue-free solvent and blow dry with filtered air.</p> <p><b>Spray:</b> V522 must be applied to room temperature surfaces. V522 can be applied with a pressure fed tank sprayer. Equipment must be rated for handling flammable liquids. Gun pressure should be regulated to a maximum of 20 psi and pot pressure of 2-4 psi for application. We recommend four light coats, once from each direction, to coat places that may have been shadowed from raised parts. The spray will go on wet, dry quickly, and turn white when all solvents have evaporated. This enables the operator to see any areas that may have been missed. Touch up as necessary for complete coverage. There is no problem with overlapping of the spray causing discoloration of the finished part as with some other mold releases.</p> <p><b>Bake2:</b> Place mold in oven set at 360–365°C (680–690°F). When the <i>mold surface temperature</i> reaches the required temperature range of 360°C (680°F) minimum—365°C (690°F) maximum, maintain this surface temperature for a minimum of 10 min. It is essential that the coated surfaces reach these temperatures. When these conditions have been reached, the oven should then be turned off and dampers opened to allow quicker cooling of the mold.</p>								
<b>Specification</b>	<table> <tr> <td>Color</td> <td>White transparent</td> </tr> <tr> <td>Operation temperature, °C</td> <td>-65 ~ 276</td> </tr> <tr> <td>Density, 25°C g/cm³</td> <td>0.8</td> </tr> <tr> <td>Flash point, °C</td> <td>12</td> </tr> </table>	Color	White transparent	Operation temperature, °C	-65 ~ 276	Density, 25°C g/cm³	0.8	Flash point, °C	12
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<b>Storage and Handling</b>	<p><b>RapidChem</b> mold release agent should be stored in a cool, dry, well ventilated area. Do not expose to freezing temperatures. Freezing will affect the physical condition, but will not damage the release effectiveness. Thaw at room temperature, and mix well before using.</p>								
<b>Shelf Life</b>	RapidChem™ lubricant has a shelf life of 2 years from the date of shipment.								



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