



**TR INDUSTRIES**  
11022 Vulcan Street  
South Gate, CA 90280-0893

## TR-104 HI-TEMP MOLD RELEASE

### DESCRIPTION:

An industry standard premium paste release for use in higher exothermic applications. Formulated using only the highest quality refined carnauba wax, blended with other high temperature synthetic waxes and additives producing the highest quality mold release wax for the composites market.

### PRODUCT FEATURES:

- ★ Ease of application and removal – may be allowed to stand before polishing
- ★ Provides hard film with superior heat and chemical properties
- ★ Polishes to high gloss without streaking
- ★ Reduced wax build-up and styrene accumulation

### PHYSICAL PROPERTIES:

Dry Time: 5-10 minutes@ 72°F. Varies depending on working temperature  
Wax Melting or Softening Point: 195 - 210°F (88 - 99°C)  
Penetration Hardness: 1 at 25°C (carnauba wax)  
Color: light blue tint (color coded for identification)  
VOC Content: 4.84lbs./gal (580g/l)

### USES:

- As a release agent for composite molding on all FRP tooling, Formica, metal and other hard surface molds.
- ★ Open mold hand or spray lay up
  - ★ Resin Transfer/injection (RTM) & (RIM)
  - ★ Vacuum bag and compression molding
  - ★ Polyester & epoxy resins

**NOTE:** Check suitability when heat curing or higher temperature molding above 215°F (102°C)

### APPLICATION:

On new or reconditioned tooling, suggest use of our sealer glaze TR-301 or TR-910 semi-permanent sealer prior to waxing for added release, gloss and mold life. Apply wax with sponge applicator in thin even circular motion to the mold surface. Allow to haze dry (approx. 5-10 min) depending on ambient temperature and polish wipe to gloss finish with soft cloth (do not use microfiber cloth). For new or reconditioned molds, apply a minimum of 6 coats of paste wax, waiting approximately 30-60 minutes between applications for the wax to set & harden after the polish wipe. Best results are obtained, if after application, mold is allowed to stand overnight and a subsequent final coat of wax release applied the following day prior to gel coating. Follow with a coat of wax for the first 2-3 parts released. Then determine how many parts can be effectively produced before re-waxing is required. This will vary depending on molding condition, configuration, resin, mold cycles, effective cure of production gel coat and other factors.

### STORAGE AND PRECAUTIONS:

Flammable solid, store in a cool dry place and keep in original unopened container. Keep away from spark, open flame or other sources of ignition.

### PACKAGING:

Available in 14oz (397g) cans and packaged in case quantity of 12. Contact your local TR distributor or call direct.

### FOR INDUSTRIAL USE ONLY

*The information contained herein is based on tests considered to be reliable and accurate. Because of the wide variance of associated materials and conditions, however no warranty is expressed or implied. Each user is encouraged to prepare a test part for their particular application.*

