

# Technical Bulletin

## Wachsfabrik Segeberg GmbH

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### Oskar's M-700 Mould Release Paste Wax

**General:** M-700 is a solid emulsion of pure carnauba wax in hydrocarbon solvents and water. It forms a very hard and resistant coat on mould surfaces resulting delayed formation of styrene/wax residues (wax-built-up) and avoid pre-release causing high costs of working. Oskar's M-700 does not contain silicone.

**Technical Data:**

Appearance:	pasty
Colour:	beige
Odour:	characteristic
Density:	~ 0,88 g/cm <sup>3</sup> at 20 °C
Flashpoint:	> 65 °C
Solubility:	partly miscible in water, miscible in hydrocarbons

**Contains:** Hydrocarbons, C10-C14, n-alkanes, isoalkanes, cyclics, <2% aromatics

**Storage:** M-700 has a shelf life of at least 24 month if stored in its original, unopened containers in a dry and cool place. Avoid freezing and prolonged temperatures above 30°C (86°F).

**Comments:** M-700 is one component of OSKAR'S MOULD RELEASE AND MAINTENANCE SYSTEM. More detailed information regarding this system can be supplied upon request. This documentation describes the application of M-700 as well as the other parts of this system.

The data given above are based on current knowledge and experience. The data do not signify any warranty.

## **APPLICATION INSTRUCTIONS:**

Oskar's M-700 was especially formulated for easier application to polyester- and epoxy moulds and to prevent wax build-up. It is highly heat-resistant. It also provides outstanding mould protection and easy release of finished parts.

1. Put some material in a clean, dry cloth and apply to an area of ca. 70 – 70 cm by pressing the wax through the cloth in circular motion. This method of application ensures a thin layer on the mould and lumps of wax are withheld.
2. Polish immediately with a clean, dry and soft cotton cloth. Polishing becomes more difficult the more time passes when applied at increased temperature. Use several cloths for polishing.
3. New moulds should be waxed 5 – 7 times in a row before using. The open pores on the surface will be closed.
4. A waiting time of ca. 1 – 2 hours is recommended between each layer when M-700 is applied at room temperature. After the last layer is applied a waiting time of 24 hours is recommended.
5. Subsequent tempering of the mould can have positive effects. The liquid wax can ingress into the surface of the mould.

## **Limitations of Liability**

The foregoing are general instructions furnished for information only and Wachsfabrik Segeberg may make changes in our mold release/sealer products or instructions at any time. The user is responsible for determining each product's suitability for the user's purpose and for taking all precautions necessary to protect property and persons against any hazards from handling or use of each product, and Wachsfabrik Segeberg cannot assume liability for use of any product for any specific purpose or application. YOUR SOLE REMEDY FOR ANY DEFECT OR PERFORMANCE FAILURE OF ANY OF OUR PRODUCTS IS RETURN OF THE UNUSED PRODUCT FOR REPLACEMENT OR A FULL REFUND, AT WACHSFABRIK SEGERBERG OPTION. ALL WARRANTIES, EXPRESSED OR IMPLIED, INCLUDING WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE, AND ALL OTHER REMEDIES ARE HEREBY DISCLAIMED. Wachsfabrik Segeberg disclaims any liability for consequential or incidental damages of any kind, including damage to molds or other equipment or loss of profits, regardless of our knowledge of the possibility of such damages and regardless of the failure of any other remedy.

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