

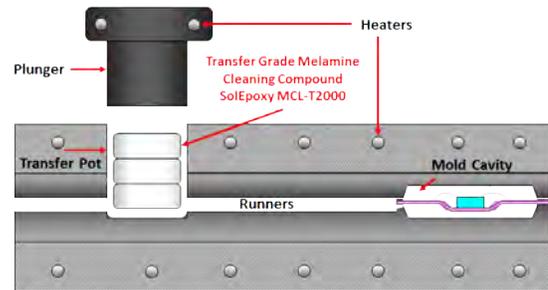
# SolEpoxy™ MCL-T2000



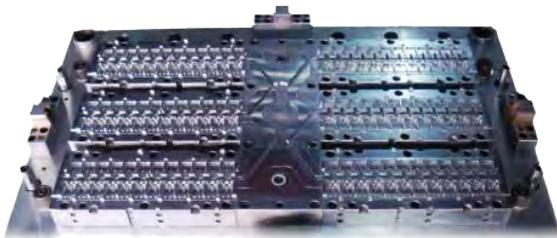
REACH-compliant, transfer-grade, melamine mold cleaning compound



SUPPLIED IN POWDER OR PELLET FORM



TRANSFER-GRADE MELAMINE  
MOLD CLEANING COMPOUND



MOLDS EASILY AND EFFECTIVELY  
TO CLEAN MOLD STAINS AND RESIDUES



ROHS AND REACH COMPLIANT

## DESCRIPTION

SolEpoxy™ MCL-T2000 is a **REACH-compliant, transfer grade, melamine mold cleaning compound** designed for cleaning transfer molding equipment and epoxy molds.

With a **long spiral flow** and **easy molding**, MCL-T2000 effectively cleans molds with **large cavities and long/multiple runner systems**. A transfer-grade compound, it is perfectly suited to an existing transfer-mold compound system.

MCL-T2000 can be supplied in powder form or in preform pellets similar to epoxy mold compound. If a compression-grade melamine mold cleaning compound is needed, please refer to MCL-C2000.

## ADVANTAGES

- ▶ Made for transfer-mold equipment
- ▶ Used in production for the cleaning of epoxy mold compound
- ▶ Supplied in pellet or in powder form
- ▶ Long spiral flow, molds easily for long and double-runner systems
- ▶ Used on conventional and automold presses

Cleans molds very effectively. Most cleaning processes do not need more than three shots to completely clean molds of all stains and residues.

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## RECOMMENDED CURE CONDITIONS

Moldability<sup>1</sup> ■■■■

## UNCURED PROPERTIES

RoHS / REACH Compliant yes

Shelf Life, from date of manufacture, months,  
@ 10 °C 4

## TYPICAL CURED GENERAL PROPERTIES

Available Colors<sup>2</sup> ☉ White

Specific Gravity, g/cc 1.50

Spiral Flow, inches, @ 177 °C 40

<sup>1</sup> rating: ■■■ poor, ■■■ fair, ■■■ good, ■■■ excellent

<sup>2</sup> custom colors may be possible to formulate

## MOLD CLEANING PROCEDURE

MCL-T2000 is designed to clean mold cavities, runners and vents. If land area needs to be cleaned, then it should be used in conjunction with MCL-C2000 (a compression grade melamine).

**Before molding any new material or at the beginning of a new molding cycle, it is ESSENTIAL that the mold be completely clean from the previous molding.** This point becomes more important for matte finish molds as residue can be lodged in the charmille which is undetectable to the naked eye. Any routine mold cleaning procedure should insure that the mold is perfectly clean before beginning the next cycle. If more than 8 cleaning shots are necessary, the cleaning frequency should probably be increased. For new molding compound trials, extra care should be taken since many materials are incompatible and even the slightest residue could hinder the evaluation or lead to misinterpretation of the results.

Transfer mold cleaning process is effective for cleaning molds with large cavities and long or double runner systems. It is also prevents damage to positioning pins and other sensitive parts of the mold. A generally acceptable mold cleaning procedure for MCL-T2000 is as follows:

1. In most cases, MCL-T2000 can be used at normal molding temperatures. Higher mold temperatures such as 170–190°C are more effective; however, it can be molded at lower temperatures. No changes to the transfer and clamp pressure are required.

2. Pour a volume of MCL-T2000 similar to the molding compound into the transfer pot and run process as normal.
3. The cycle time should be 3–5 minutes. Longer cycle times (5 minutes) will give optimum cleaning.
4. Open the mold and remove all cured material from cavities, runners, gates, and vents. It is also important to check relief areas as compound left in these holes could cause damage to locating pins.
5. Inspect the cured cleaning material for discoloration and repeat steps 2 to 5 until the material is free from stain. Initial shots may be white because material is removing wax layer. If the mold has not been cleaned regularly, it may take 7 or more shots to thoroughly clean it. Be sure to check mold to make sure all of the stain is removed and there is no melamine left in the cavities..
6. Once the mold is clean, set the press to standard processing parameters and prepare the mold by lightly waxing, molding 3 to 5 shots of conditioning compound or 3 to 5 dummy shots of standard compound using 2 to 3 times the normal curing cycle. The melamine cleans the mold down to the metal. It is necessary to have a layer of wax on the surface so that the material will release from the mold.
7. Resume normal molding. The first three shots of standard molding compound should be cured 2 to 3 times longer than normal in order to insure that press equilibrium and optimum release characteristics are achieved.

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## STORAGE & HANDLING

Powder should be stored at 10°C or below, in closed containers. After removal from cold storage, the material **must be allowed to come to room temperature** in the sealed container to avoid moisture contamination. Suggested waiting time is 24 hours. Please consult our *Product Handling Recommendations for Coating Powders*.

**For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).**

## DATA RANGES

The data contained herein may be reported as a typical value and/or range of values based on actual test data and are verified on a periodic basis.

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