

RED LINE  
  
MOLD RELEASE & CLEANERS



**REDLINE 5000**

**Melamine Short-Flow Mold Cleaner** is used for compression cleaning of mold cavities with substantial wall thickness. Perform size is 2" x 2" x 1/4". It is a short flow compression-grade alpha cellulose filled melamine formaldehyde mold cleaning material. Because of its short flow, this melamine compression grade mold cleaner is generally more effective in removing mold staining than transfer grade cleaning melamines

**Short Flow Melamine Product Bulletin**

- Supplied in 2" x 2" preforms weighing 28 grams; The preform contains an easy-break center V-groove, so that it can be broken to form 1" x 2" pieces for use in smaller areas
- Because it is an extremely stiff flow material, approximately 1 to 5 inches at 175° C, clamp pressure should be reduced on the press, and the soft-close feature should be used on the platens if available
- Molding temperatures as low as 300° F can be used. Cure times may vary from 2 to 5 minutes. It is recommended that the cured melamine be removed from the cleaned areas immediately to minimize sticking
- Because short flow melamine removes residual release so thoroughly, the mold surface is often "dry". It is therefore recommended that a light application of external mold release be applied to the mold (particularly the KO pins) surface before molding is resumed.
- Depending on the frequency of cleaning, more than one cleaning shot is generally recommended. It is best to continue the cleaning procedure until all traces of staining or compound contamination have disappeared from the white melamine. Supplied in 30 pound plastic pails.

(continued)

### Short Flow Melamine Material Specifications

Color:	White
Preform Size:	2" x 2"
Preform Weight:	28 grams
Spiral Flow:	1.5 inches
Shelf Life:	6 months at 70° F

NOTE: A High Flow version of this product is available. Please contact ISD, Inc. for applications where a long flow material is more appropriate. Call 401-400-8995 or E-mail [support@idsales.com](mailto:support@idsales.com).

### Cleaning Procedure for Short Flow Melamine

- Can be molded at temperatures as low as 300° F and at pressures as low as 200 psi.
- To reduce the possibility of damage to any thin wall sections or sharp corners in the mold, it is recommended that clamp pressure be reduced to a minimum, but still adequate pressure to fill the mold cavities.
- Make sure that an adequate amount of melamine is placed in the mold so that when it is closed both the upper and lower sections of the mold cavities are filled.
- Place melamine squares adjacent to each other and over the cavity and runner area of the lower half of the mold. To reduce waste, the preforms may be broken in half as long as the area to be cleaned is covered by the preforms.
- If the pot and face of the plunger have exhibited staining and sticking, it may be advisable to place an appropriate amount of melamine in the cull area of the mold.
- If your press is equipped with a "slow close" option, it is helpful to use it to optimize the flow of the cleaning compound.
- With the press in manual mode, close the mold halves together using reduced clamping pressure and normal molding temperatures. Set the cure cycle for five minutes initially. This time may be varied up or down depending on the cleanliness of the mold, and cross-sectional area of the cavities.
- Open the mold and remove all of the cured compound, being careful to thoroughly clean any relief areas in both halves of the mold to prevent damage to locating or knock-out pins.
- This process may have to be repeated a number of times until the melamine contains little or no discoloration from epoxy stains or mold release.
- If this cleaning procedure is required more than once a shift, consult your epoxy supplier.
- Since this cleaning compound removes most of residual release agents in the tools, it is recommended that the mold be "conditioned" with applications of release (Frekote HMT is preferred) before epoxy molding is resumed.
- Exhaust fumes from the melamine should be drawn away from the operator through an exhaust vent at the rear of the press.