

Technical Data Sheet

STRUKTOL® MC-B

Mould Cleaning Compound

Composition

Unvulcanised rubber compound containing chemical cleaning components

Properties

Appearance	Light coloured rubber compound
Odour	Slightly aminic
Density [kg/m ³]	1200
Physiological behaviour	Refer to safety data sheet
Storage stability	At least 12 months under normal storage conditions
Dimension	4 mm x 350 mm
Packing	22 kg hobbocks

Curing Conditions

Cure temperature	150 °C to 180 °C
Cure time	40 to 5 minutes
Optimum conditions	160 °C, 20 minutes



Recommendations for Application

STRUKTOL® MC-B is a curable rubber compound for in situ cleaning of moulds.

STRUKTOL® MC-B removes the deposits which build up during vulcanisation of rubber compounds. Deposits from silicone or fluoroelastomer compounds may not be removed with the same efficiency as for, e.g., NR/SBR deposits.

STRUKTOL® MC-B is used for mould cleaning by placing the compound in the mould as for a normal cure cycle. The cleaning takes place during the cure.

Cure conditions:

150 °C - 40 minutes	170 °C - 10 minutes
160 °C - 20 minutes	180 °C - 5 minutes

Mould removal is not necessary. STRUKTOL® MC-B can be milled, extruded or otherwise processed with the usual manufacturing machines.

STRUKTOL® MC-B works by releasing active materials into the mould fouling. The penetrated deposit combines with the cleaning compound and will be removed with it.

If starting with a very dirty mould it may be necessary to make more than one application of STRUKTOL® MC-B to completely remove the deposits.

To obtain maximum cleaning effect it is essential that the mould be fully filled and adequate pressure is maintained throughout the cure.

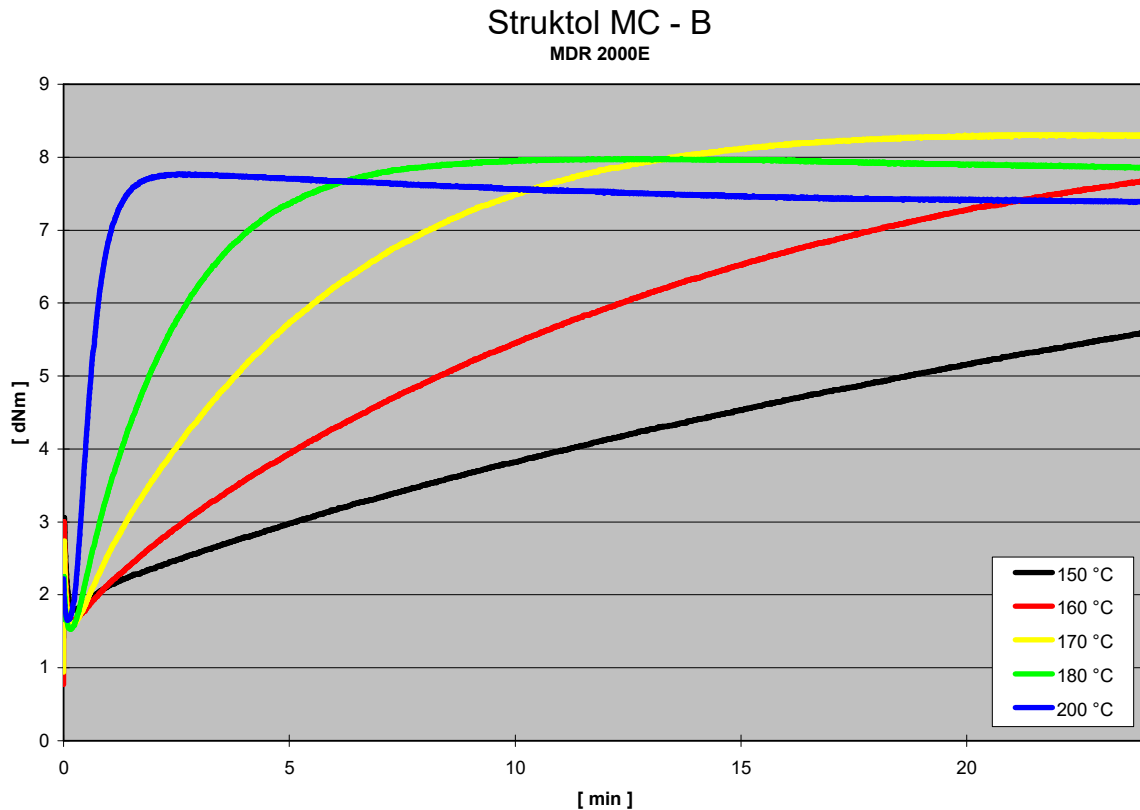
If using STRUKTOL® MC-B as a regular mould cleaning agent it is advisable to clean the mould more frequently to prevent the build-up of difficult to remove deposits.

With STRUKTOL® MC-B all commonly used steel alloys may be cleaned. We cannot recommend the use of STRUKTOL® MC-B for non-ferrous metals. If you are uncertain in applying our material please contact our technical agents for advice.



Optimisation of the cleaning effect

In general, the longer the vulcanisation time, the greater the cleaning effect. The following graph shows the dependence of temperature and vulcanisation time. We usually recommend approx. 10 minutes at 175 °C as vulcanisation conditions.



Measures for handling STRUKTOL® MC-B

In general, rooms in which STRUKTOL® MC-B is processed should be well ventilated. It makes sense to install an extraction system above the press.

A particularly effective and low-odour demoulding is achieved if STRUKTOL® MC-B is pressed into the cooling mould in the evening and not removed until the following morning. It is important that the press remains under pressure. This method is particularly suitable for simple, non-undercut moulds.



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