

## Water-Based Semi-Permanent EPDM Automotive Rubber Seals Mold Release Agent 20 to 1 Dilution

Our Product Introduction

### Basic Information

- Place of Origin: Guangdong, China
- Brand Name: Lubekote
- Certification: ISO 9001:2015, RoHS, REACH
- Model Number: LK-9700W-EPDM
- Minimum Order Quantity: 20 Liters
- Price: USD 12-18 / Liter
- Packaging Details: 20L HDPE drum with tamper-evident cap, 200L steel drum for bulk orders, export-grade palletized packaging
- Delivery Time: 5-7 working days for stock, 15-20 days for production
- Payment Terms: T/T, L/C, PayPal, Western Union
- Supply Ability: 50000 Liters per Month



### Product Specification

- Product Type: Water-Based Semi-Permanent Mold Release Agent
- Target Rubber: EPDM (Ethylene Propylene Diene Monomer)
- Application: Automotive Rubber Seals, Gaskets, Hoses
- Dilution Ratio: 1:20 (Concentrate To Water)
- Release Cycles Per Application: 5-8 Cycles
- Drying Method: Air Dry At Room Temperature / Hot Mold Application
- Appearance: Milky White Liquid
- PH Value: 6.5-7.5
- Specific Gravity: 1.00-1.05 G/cm<sup>3</sup>
- Shelf Life: 12 Months (Unopened, 5-35°C)
- VOC Content: <50 G/L
- Packaging Options: 1L, 5L, 20L, 200L
- Highlight: **water-based EPDM rubber mold release,**

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## Water-Based Semi-Permanent Mold Release Agent for EPDM Automotive Rubber Seals

### Product Introduction

Lubekote LK-9700W-EPDM is a high-performance water-based semi-permanent mold release agent specifically designed for EPDM (Ethylene Propylene Diene Monomer) rubber automotive sealing components. EPDM rubber is widely used in automotive weatherstrips, door seals, window seals, and under-hood gaskets due to its excellent resistance to heat, ozone, and weathering. However, EPDM's inherent tackiness during vulcanization often leads to sticking and mold fouling. Our LK-9700W-EPDM addresses this challenge by forming a durable, chemically bonded release film on mold surfaces that withstands multiple molding cycles without reapplication. With a 20:1 water dilution ratio, it offers exceptional cost efficiency while maintaining consistent release performance.

### Key Features & Benefits

**Semi-Permanent Release Film:** One application lasts 5-8 molding cycles, significantly reducing downtime and improving production throughput compared to conventional spray-on release agents.

**Enhanced Dilution Efficiency at 20:1 Ratio:** 1 liter of concentrate yields 20 liters of ready-to-use solution, reducing per-part cost by up to 95% versus traditional release agents.

**Zero Transfer Technology:** The cured release film does not transfer to the rubber part surface, ensuring clean parts ready for bonding, coating, or assembly without post-demolding cleaning.

**EPDM-Specific Formulation:** Engineered specifically for EPDM rubber's unique surface chemistry during peroxide and sulfur curing systems, ensuring reliable release where generic agents fail.

**Mold Build-Up Prevention:** The thin, uniform film prevents mold residue accumulation, extending mold cleaning intervals and protecting expensive tooling investment.

**Water-Based, Low VOC:** VOC content below 50 g/L meets international environmental regulations including EU Directive 2004/42/EC and US EPA standards.

### Why Choose Us

With over 12 years of expertise in rubber processing auxiliaries, our team combines German-engineered release technology with cost-effective Chinese manufacturing to deliver world-class products at competitive prices. We hold 7 national invention patents and 3 utility model patents in release agent technology. Our products are trusted by automotive tier-1 suppliers across Asia, Europe, and North America. Every batch undergoes rigorous quality testing including demolding force measurement, surface roughness analysis, and accelerated aging tests. We provide comprehensive technical support, including on-site mold preparation guidance, optimal dilution ratio recommendations, and application method training. Choose Lubekote for proven performance backed by measurable production results.

### Technical Parameters

Parameter	Specification
Product Type	Water-Based Semi-Permanent Mold Release Agent
Target Rubber	EPDM (Ethylene Propylene Diene Monomer)
Application	Automotive Seals, Gaskets, Weatherstrips
Dilution Ratio	1:20 (Concentrate : Deionized Water)
Release Cycles per Application	5-8 Cycles
Appearance	Milky White Liquid
pH Value	6.5-7.5
Specific Gravity	1.00-1.05 g/cm <sup>3</sup> at 25°C
VOC Content	<50 g/L
Shelf Life	12 Months (Unopened, 5-35°C Storage)

### Application Instructions

**Mold Preparation:** Clean mold surface thoroughly with an alkaline mold cleaner to remove all residues, old release agent, and contamination. Ensure the mold surface is completely dry.

**Dilution:** Mix 1 part LK-9700W-EPDM concentrate with 20 parts deionized or distilled water. Stir gently until homogeneous. Do not use tap water as mineral content may affect film formation.

**Application:** Apply the diluted solution to the hot mold surface (120-180°C) using an air spray gun set at 2-3 bar pressure. Apply 2-3 light, even coats with 30-second intervals between coats for proper solvent evaporation and film curing.

**Curing:** Allow the final coat to cure for 2-3 minutes before starting production. The film will thermally cross-link on the hot mold surface, creating a durable release layer.

**Maintenance:** When release performance begins to degrade (typically after 5-8 cycles), apply a single touch-up coat. No need to strip and re-clean the mold.

### Frequently Asked Questions (FAQ)

**Q: Can this release agent be used with sulfur-cured EPDM?**

A: Yes, LK-9700W-EPDM is compatible with both sulfur-cured and peroxide-cured EPDM systems. The release film remains stable at typical EPDM curing temperatures of 150-180°C.

**Q: How does the 20:1 dilution compare in cost to conventional silicone-based sprays?**

A: At 20:1 dilution, the effective cost per liter of ready-to-use solution is approximately 5% of the concentrate price. Compared to conventional silicone-based sprays at \$8-15/L, our solution typically achieves 60-80% cost savings while providing superior release performance.

**Q: Does it affect post-molding bonding or painting processes?**

A: No. The non-transfer formulation ensures no residue remains on the rubber part surface. Parts demolded with LK-9700W-EPDM can be directly bonded, coated, or assembled without additional cleaning steps.

**Q: What is the recommended storage condition?**

A: Store in a cool, dry place at 5-35°C. Protect from freezing as freeze-thaw cycles may destabilize the emulsion. Keep containers tightly sealed when not in use.

**Q: Is it compatible with aluminum molds?**

A: Yes, LK-9700W-EPDM is compatible with steel, aluminum, and chrome-plated mold surfaces. It also provides mild corrosion protection for steel molds during production pauses.



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