

Technical Data Sheet

**STRUKTOL<sup>®</sup> MC-A**

Mould Cleaning Compound

**Properties**

Appearance		light coloured rubber compound in roll form
Odour		slightly aminic
Density	[kg/m <sup>3</sup> ]	1140
Storage stability		at least 12 months under normal storage conditions
Dimension		8x350 mm
Packing		22 kg hobbocks

**Curing Conditions**

Cure temperature	160 °C - 195 °C
Cure time	5-30 minutes
Recommended cure	175 °C, 10 minutes

The data given are typical values which are not intended for use in preparing specifications. For test methods refer to the corresponding supplement.



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## **Recommendations for Application**

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

STRUKTOL MC-A removes the deposits which build up during vulcanization of rubber compounds. Deposits from silicone or fluoroelastomer compounds may not be removed with the same efficiency as for normal NR/SBR deposits.

STRUKTOL MC-A 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.

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

STRUKTOL MC-A works by releasing active materials into the mould fouling. The penetrated deposit is combined with the cleaning compound. The cure temperatures should be between 160 °C and 195 °C with a minimum cure time of 5 minutes. Optimum curing temperature is 175 °C.

The effectiveness of cleaning depends on the kind of deposit, cure temperature and pressure. Higher temperatures accelerate the diffusion of the active materials into the dirt layer, but the corresponding reduction in cure time will prevent sufficient combination of the deposit onto the cleaning compound.

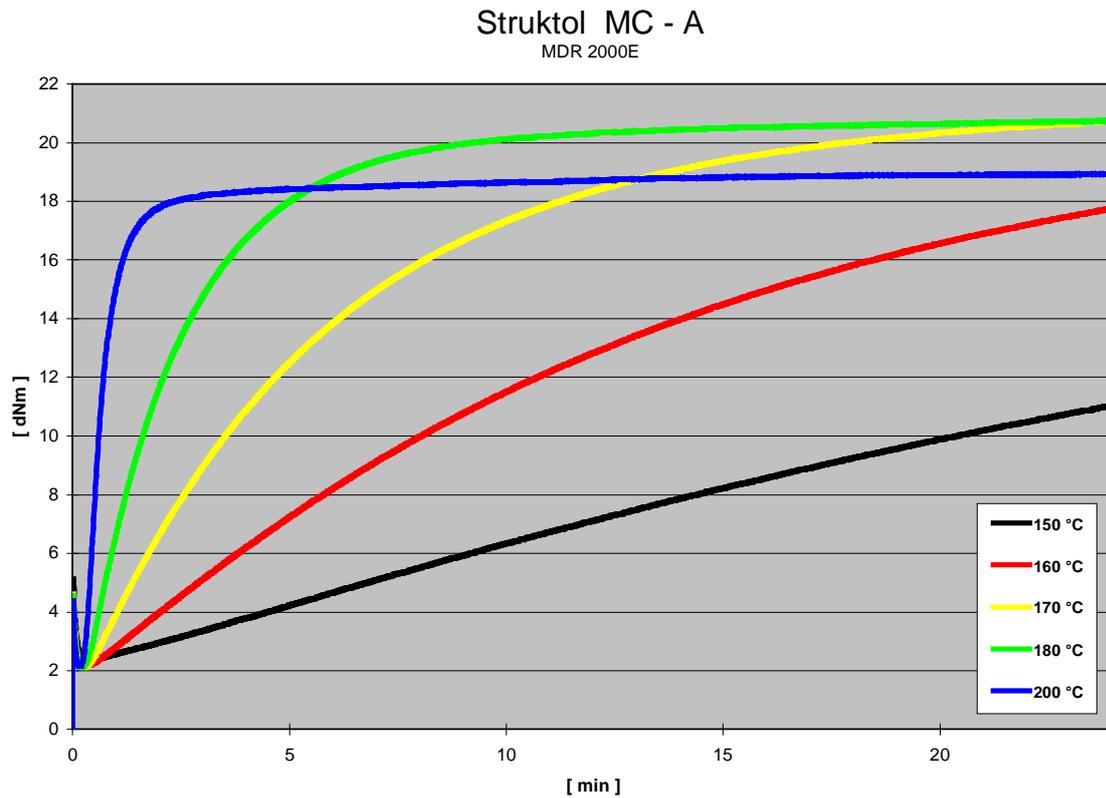
If using STRUKTOL MC-A as a regular mould cleaning agent it is advisable to clean the mould more frequently to prevent the build up of difficult to remove deposits.

If starting with a very dirty mould it may be necessary to make more than one application of STRUKTOL MC-A 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.

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

### To optimize cleaning effect

The longer the curing time the more efficient is the cleaning effect. The following rheometer traces show the relationship between temperature and cure time. Optimum cure cycle is 10 minutes at 175 °C.



### Cleaning of intricate moulds

For moulds with deep undercuts, to avoid hot tear problems it is necessary to use a cure cycle in which the vulcanizate is removed after reaching 80 per cent of optimum cure.

### How to use STRUKTOL MC-A most economically

For large moulds a filling compound can be used on which STRUKTOL MC-A is applied as a veneer.

### **Recommendation to minimize fuming problems**

Areas where STRUKTOL MC-A is in use must be adequately ventilated. It is advisable to have extraction equipment over presses. To reduce fuming in the atmosphere it is advisable to place the vulcanized STRUKTOL MC-A in water immediately after stripping from the mould.

Another recommendation to reduce fuming is to use STRUKTOL MC-A at the end of a days moulding and remove the vulcanizate from the cold mould the next day.

### **Safety Instructions**

STRUKTOL MC-A can be handled safely at room temperature.

Eye contact and prolonged skin contact with hot compound should be avoided.

Compound should be stored under cool and dry conditions.

The suggestions for application and usage of our products as well as possible proposed formulations are meant to advise only to the best of our knowledge. This information is without obligation and does not release customers from their own testings to ensure suitability for intended processes and use. Liability is only accepted in case of intention or gross negligence. Liability for any defects caused by minor negligence are not accepted. Each producer is responsible and liable to observe legislation and patent rights of third parties.  
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