

WATERWORKS

Aerospace Release System



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DEPARTURE

DESCRIPTION

DEPARTURE release agent has been specifically formulated to meet the high performance requirements of the Advanced Composites industry by providing consistent, effortless releases without buildup on the mold. **DEPARTURE** is a versatile polymer that chemically bonds to the mold surface and with correct application will not transfer to the part or other processing equipment surfaces. **DEPARTURE** pre-saturated wipes are engineered to deliver release agent to the surface without risk of over-application. The applicator cloth holds the product well (eliminating rapid evaporation) and distributes a fine dispersion of droplets across the mold surface, providing easy control and complete coverage.

DEPARTURE BENEFITS

- * Environmentally safe
- * No CFCs, VOCs, or ODCs
- * Exempt from REACH requirements
- * Thermal stability - 260 °C (500 °F)
- * No odor - solvent and alcohol free
- * Eliminates porosity by improving resin flow
- * Easy application by spraying or wiping
- * Non-flammable and safe to use
- * No respirator required

USES

DEPARTURE was specifically developed for releasing thermosets, thermoplastics and prepregs. **DEPARTURE** is suitable for all manufacturing processes used in molding and bonding advanced composite structures.

HOW TO USE

Before applying **DEPARTURE**:

- ✓ All previous surface treatments, residues, waxes or oils should be removed using **FRESH START** or another ZYVAX mold and part cleaner.
 - ✓ The mold should be properly sealed with a WATERWORKS or ZYVAX mold sealer according to the technical data sheet.
1. Lightly mist the mold surface with a hand-sprayer or wipe-on a thin, even layer of **DEPARTURE** to the mold surface.
 2. If the mold surface below 80 °C (180 °F) - wait approximately 60 seconds and wipe off with a clean, dry wipe. Continue wiping until the material is evenly distributed. If the mold surface above 80 °C (180 °F) – do not wipe off.
Apply in sections; overlap slightly when covering multiple areas.
 3. Let cure for 15 minutes.
 4. Apply a second coat of **DEPARTURE** in the same way, and wait for a minimum of 30 minutes before the layout of materials.
DO NOT RE-USE DISCARDED WIPES.

For touch-ups, apply a single coat of **DEPARTURE** as above and allow 30 minutes for cure before using the mold.

SAFETY DATA

Material safety data sheets for all ZYVAX products are available at www.zyvax.com and should be consulted prior to use of product.

STORAGE & SHELF LIFE

Store product between 5 °C and 30 °C (41 °F and 86 °F). Shelf life is 18 months from the date of manufacture, in the original unopened container. When using pre-saturated wipes, make sure that the container lid closes securely in place so that evaporation does not occur to the remaining wipes.

USE LIFE

Use life of product is 60 days from opening of container. Product must be kept in the original container and the lid replaced immediately after dispensing. Outside of the container, pre-saturated wipes should be used within 10 minutes. After opening, product should continue to be stored properly. **WARNING:** *Never puncture any ZYVAX product container.*

LIMITATIONS OF LIABILITY

To the best of our knowledge, the technical data contained herein are true and accurate at the date of issuance, and are subject to change without prior notice. User must contact ZYVAX to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to ZYVAX quality control. We assume no responsibility for coverage, performance, or injuries resulting from its use. Liability, if any, is limited to replacement of products. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY ZYVAX, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING FITNESS FOR A PARTICULAR PURPOSE.