CHEMLINQ™ **MCN-T20** series

Transfer-grade Mold Conditioning Compound

- Compatible with wide range of mold designs
- No stain mark caused by wax accumulation
- Conditions mold cavities and plunger and forms release layer with uniform thickness

CHEMLINQ MCN-T20 series are transfer-grade mold conditioning pellets used to condition mold surfaces, enhance mold compound release, and extend production cycle times in between cleaning. These are highly effective mold conditioning products with good flow characteristics, allowing them to easily condition mold corners and thin gate areas. Their pellet shape and wide range of diameters, from 20 mm to 55 mm, ensure compatibility with existing transfer processes.

CHEMLINQ MCN-T20 Series is available in two versions: the standard **MCN-T20** and the fine-grind **MCN-T20F**, which is more suitable for molds with small runners and cavities

To achieve optimal cleaning and effectively condition both the mold surface and small cavities and runners, **CHEMLINQ MCN-T20** can be used in combination with the melamine-based cleaning tablets and pellets: **CHEMLINQ MCL-C10**, **MCL-T10**, and **MCL-T20**.

Specifications

Property	MCN-T20	MCN-T20F	Unit
Appearance	Gray, cylindrical pellets	Gray, cylindrical pellets	–
Specific Gravity	1.9	1.9	–
Filler Type	Crystalline/Fused	Fused	–
Filler Sieve Size	75	53	µm
Spiral Flow	46 /117	39/99	in/cm
Gel time	22	22	s
Hot Hardness (120 s)	>70	>70	Shore D
Flash (50/20/15/10/5 µm)	1.3/0.8/0.6/0.5/0.4	1.5/1.2/0.8/0.8/0.5	mm

Recommended Molding Parameters

Mold Type	Preheat Time	Preheat Temperature	Mold Temperature	Transfer Pressure	Transfer Time	Curing Time
Auto Mold	0–10 s	–	175–185 °C	90–110 kg_f/cm^2	5–10 s	2–3 min
Conventional	–	80–90 °C	175–185 °C	70–130 kg_f/cm^2	10–20 s	3–4 min

Europe
Industrieweg 15E,
1566JN Assendelft
The Netherlands
Phone: +31 (20) 893 2224
Email: info@caplinq.com

Canada
80 Sirocco Crescent
Ottawa ON, K2S 2C9
Canada
Phone: +1 (613) 482-2215
Email: info@caplinq.com

North America
36927 Schoolcraft Rd
Livonia, MI 48150
United States
Phone: +1 (313) 558-8243
Email: info@caplinq.com

South East Asia
S-08-07 Persiaran Triangle
B Lepas, Penang 11900
Malaysia
Phone: +60 (12)4302223
Email: info@caplinq.com

Processing Instructions

1. Ensure the mold temperature is appropriate for conditioning, typically around the operating temperature of the mold. Make sure the mold is clean.
2. Place the MCN-T20 tablets into the mold cavity. The number of pellets and shots required will depend on the mold size and the desired level of conditioning.
3. Close the mold and initiate a standard transfer molding cycle. This includes applying the necessary pressure and heat to activate the conditioning compound. The heat and pressure help the MCN-T20 pellets to flow across the mold surfaces.
4. After the cycle is complete, open the mold and eject the conditioning compound residue. To optimize release and conditioning, open the mold 60–80 seconds after MCN-T20 is fully cured. Ideal times may vary based on package type and mold design.
5. If necessary, repeat the process using additional conditioning compound pellets.

Please note that the provided information is based on available data and typical conditions. For specific applications and detailed test results, refer to the actual test data and conduct appropriate certifications.

Storage and Handling

1. The wax conditioning compound is sealed in PE bags, with 10 kg per carton.
2. Ensure the product stays dry, as high humidity can cause curing failures in the wax conditioning compound. Keep away the heat sources, as excessive heat can make the the wax conditioning compound ineffective.
3. The shelf life is 12 months from manufacturing date if stored at temperatures ≤10 °C. If taken from a cold room or refrigerator, thaw it in the sealed package for 18 to 24 hours until it reaches room temperature.
4. The pot life is 72 hours after being removed from the cold room and unpacked at room temperature (≤ 28 °C and RH < 65%).
5. This product can be re-thawed in a cold room by resealing the remaining product in a double PE bag. The total thawing and usage time should not exceed 72 hours.
6. Using the product beyond its guaranteed pot life requires careful testing. The remaining lifespan of the product will depend on the mold type, mold design, and storage conditions.

Europe
Industrieweg 15E,
1566JN Assendelft
The Netherlands
Phone: +31 (20) 893 2224
Email: info@caplinq.com

Canada
80 Sirocco Crescent
Ottawa ON, K2S 2C9
Canada
Phone: +1 (613) 482-2215
Email: info@caplinq.com

North America
36927 Schoolcraft Rd
Livonia, MI 48150
United States
Phone: +1 (313) 558-8243
Email: info@caplinq.com

South East Asia
S-08-07 Persiaran Triangle
B Lepas, Penang 11900
Malaysia
Phone: +60 (12)4302223
Email: info@caplinq.com