

CHEMLINQ™ MCL-T27

Melamine Cleaning Compound



- Optimized workability and effective removal of organic and inorganic contaminants
- Restores mold surface quality without abrasion
- Extends mold life and reduces maintenance downtime

CHEMLINQ MCL-T27 is a mold cleaning compound (tablet) composed of melamine resin, silica filler, and other additives. It effectively removes organic and inorganic residues from metal mold dies used in transfer molding, helping restore surface quality and extend mold life. Its non-abrasive formulation ensures thorough cleaning without damaging mold surfaces. **CHEMLINQ MCL-T27** provides effective cleaning on its own, and delivers even greater results when used with the **CHEMLINQ RCS rubber cleaning sheet** series.

Typical Properties

Property	Value	Unit
Appearance	White, cylindrical pellet	–
Specific Gravity	1.59 $\pm$ 0.02	–
Compression Ratio	80	%
Spiral Flow at 175 °C	50 $\pm$ 5%	cm
Gel Time at 175 °C	20	s
Hot Hardness at 120 s	84 $\pm$ 5	Shore D
Flash (50/20/15/10/5 μ m)	7.6/2.6/2.2/2.2/1.5	mm

Recommended Molding Parameters

Parameter	Auto Mold	Conventional Mold
Preheat Time	0–10 s	–
Preheat Temperature	–	90–110 °C
Mold Temperature	175 $\pm$ 15 °C	175 $\pm$ 15 °C
Transfer Pressure	95 $\pm$ 5 kg _f /cm ²	85 $\pm$ 55 kg _f /cm ²
Transfer Time	8–25 s	20–40 s
Curing Time	4–10 min	5–15 min

The information in this document describes typical properties and recommended use of CHEMLINQ™ Melamine Cleaning Compound and is provided for reference only and are not intended as formal specifications. It does not guarantee performance or suitability under all conditions. Results can vary with equipment, process parameters, and operating environments. Users must perform their own evaluations to confirm compatibility, effectiveness, and regulatory compliance for the intended application.

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Processing

Instructions

1. Ensure the mold temperature is appropriate for cleaning, typically around the operating temperature of the mold. Make sure the mold is free from any significant debris or loose contaminants.
2. Place the MCL-T27 pellets into the mold cavity. The number of pellets depends on the size of the mold and the level of contamination.
3. Close the mold and initiate a standard transfer molding cycle. This includes applying the necessary pressure and heat to activate the cleaning compound. The heat and pressure help the MCL-T27 pellets to flow across the mold surfaces, effectively loosening and removing organic and inorganic residues.
4. After the cycle is complete, open the mold and eject the cleaning compound residue. Inspect the mold for any remaining contaminants. If necessary, repeat the process using additional pellets or in combination with other cleaning methods, such as CHEMLINQ™ RCS rubber cleaning sheets.
5. Perform a final inspection to ensure all residues are removed.

Storage and Handling

CHEMLINQ MCL-T27 is supplied as pressed pellets sealed in double PE bags. Store and transport unopened product in a dry environment at $\leq 25\text{ }^{\circ}\text{C}$; refrigeration is unnecessary, yet maintaining $\leq 10\text{ }^{\circ}\text{C}$ extends shelf life. Keep product away from heat sources such as molding dies and preheating panels, and maintain ambient relative humidity $\leq 30\%$ to prevent moisture ingress that can impair curing performance. For product stored in cold storage, keep the bags sealed and allow them to reach room temperature ($23\text{ }^{\circ}\text{C} \pm 5\text{ }^{\circ}\text{C}$) in an area $\leq 30\%$ RH for 18–24 h before opening. Shelf life is 6 months when stored $\leq 25\text{ }^{\circ}\text{C}$ and 12 months when stored $\leq 10\text{ }^{\circ}\text{C}$, each period measured from the manufacturing date.

Use the product in a well-ventilated area. Always follow safety guidelines and wear protective equipment when handling. For more safety information, check the Safety Data Sheet (SDS).

The molding parameters listed here are reference guidelines based on internal trials with standard molding equipment. Users must set and validate their own conditions, taking into account mold surface finish, cavity design, package configuration, and end-use requirements. Each user is responsible for optimizing these parameters to achieve safe, effective residue removal while meeting all applicable quality and regulatory standards.

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