



# SAMBU FINE CHEMICAL CO., LTD.

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## Technical Data Sheet – Green 9000

### 1. Physical properties

Appearance	Milky liquid
Type of emulsifier	Non ionic
Specific gravity	0.90 ~ 1.10
Shelf life	6 Months

### 2. Process of Green 9000

- 1) Dilution ratio of Green-9000 is 1:8-12 with soft water. The ratio is variable according to the condition, molds, PU raw materials, and so on.
- 2) Spraying angle of gun is 60° and effective spraying distance between mold and spray gun is 10 ~ 20cm.
- 3) Usually, nozzle size of spray gun is 0.3 ~ 0.5mm

\* Volume of Green series for nozzle size 0.3mm

R.A. feeding pressure (Kg/cm <sup>2</sup> )	Air supporting pressure (Kg/cm <sup>2</sup> )	Output of Green-9000 (g/sec)
1.0 ~ 3.0	2.0 ~ 3.5	1.0 ~ 1.2(± 10%)

\* Volume of GREEN series for nozzle size 0.5mm

R.A. feeding pressure (Kg/cm <sup>2</sup> )	Air supporting pressure (Kg/cm <sup>2</sup> )	Output of Green-9000 (g/sec)
1.0 ~ 3.0	2.0 ~ 3.5	2.9 ~ 3.2(± 10%)

- 4) Operator must check air pressure of spray gun and R.A tank before production start.
- 5) If R.A is sprayed excessively, the drying on the mold surface is so delayed that it will interrupt de-



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molding and bonding.

6) Usually, dry time of water base release agent is over 3min.

☞ If you want fast dry, Green series should be thin coated on mold surface and workers have to rub with cloths and blow off excess releasing agent with air from the surface of mold after spraying.

7) Proper mold temperature is 65 ~ 70 °C

8) We think that proper spray time is 4 ~ 8 sec on a mold.

( Example : upper plate - 2sec, middle plate - 2sec, lower plate - 2sec )

※ According to factory conditions, the process or situations might be changed.

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