



DAC **INDUSTRIES**

Products & Best Practices

*DAC Sprays and Best Practices
For Injection Molding*

35 YEARS

Supplying the plastics industry

DAC Industries is your go-to resource for troubleshooting or product recommendations. DAC Industries has the experts to help solve your problems.

Over 5000 Plants

Use DAC products daily

Our products have been formulated for the specific needs of plastic injection molders, and is the trusted brand for many of the world's largest plastic molding companies.

100% Satisfaction

Solutions for piece of mind

We provide unmatched customer service. That is why every can of DAC products is backed by a 100% customer satisfaction guarantee. If for any reason you are unsatisfied with our products, we will refund your purchase.



CLEANERS

Pg. 4

DEGREASERS | RESIN REMOVERS | FOAMING SPRAY

- Prevent cosmetic defects and mold damage due to contamination or resin buildup
- For use in toolroom or in-production

MOLD RELEASES

Pg. 8

NON-SILICONE | PAINTABLE | SILICONE | BIODEGRADABLE

- Useful during startups
- Reduce unplanned downtime

LUBRICANTS

Pg. 10

SPRAY FILM | GREASE | SPRAY GREASE | PENETRATING OIL

- Prevents galling and binding of moving parts without bleeding
- Formulas for different temperature ranges

RUST INHIBITORS

Pg. 12

SHORT-TERM | LONG-TERM | ACID NEUTRALIZING | FINE MIST

- Prevents damage to molds due to rust
- Reduces downtime of repairs and cleaning due to rust buildup

MISCELLANEOUS PRODUCTS

Pg. 14

GREASE | PLATING AGENTS | HEAVY-DUTY RELEASES | SPRAY CLEANER



CLEANERS

DEGREASERS



Registered Compound
Program List 2 (Grease 04, 05)
Registration # 141209

SDS



11 oz can
12 cans / case

DAC-353 Universal II All Purpose Degreaser

DAC-353 is a heavy-spray, non-chlorinated degreaser with dispersing agents that will lift oil and grease then flush it away with ease. Our formula will clean down to the pores.

- Most popular degreaser.
- Ion degreasing formula.
- NSF Certified.



Registered Compound
Program List 2 (Grease 04, 05)
Registration # 141209

SDS



11 oz can
12 cans / case

DAC-103 Universal All Purpose Degreaser

DAC-103 is a variable-spray, non-chlorinated degreaser with dispersing agents that will lift oil and grease then flush it away with ease. Our formula will clean down to the pores.

- CO2 Propellant
- Ion degreasing formula.
- NSF Certified.



Registered Compound
Program List 2 (Grease 04, 05)
Registration # 141209

SDS



8.6 oz can
12 cans / case
55 gallon

DAC-108 Does It All

DAC-108 is an economical, non-chlorinated degreasing spray that has dispersing agents to lift and move oil and grease up and off metal surfaces. This degreaser is a great choice for environments where ventilation may be of concern.

- NSF Certified.
- Low VOC.
- Rapid evaporation.



Registered Compound
Program List 2 (Grease 04, 05)
Registration # 141209

SDS



8.6 oz can
12 cans / case
55 gallon

DAC-205 Excel Mold Cleaner Plus Degreaser

DAC-205 Excel is our most powerful cleaner*. This low-odor product is recommended for applications in areas without chloride restrictions* and where an extra-strength cleaner/degreaser is needed.

- Strongest formula.
- Non-flammable.
- Non-conductive.

*Contains trichloroethylene (TCE)

DAC INDUSTRIES' BEST PRACTICES



PROPER CLEANING PREVENTS

- Mold damage
- Cosmetic defects
- Part trimming

1



Protect your mold surface by:

- Spraying directly onto mold surface for flushing.
- Applying spray to a clean rag or towel to extend the use of product.
- Using air or tissue around mirrored surfaces.

2



When spraying directly onto the mold start with cores and cavities, then clean outer mold surfaces. This ensures that contamination is not brought back into the mold.

3



Continue with mold surfaces, focusing on vents and parting lines.

4



Wipe with a clean paper towel or rag. This will ensure steel is free of contaminants.



If applicable, follow up with additional mold spray products. These will work better on clean steel.

- Rust inhibitor for storage / overnight shutdown.
- Mold release for production.

CLEANERS

RESIN REMOVERS & FOAM CLEANER



SDS



12.5 oz can
12 cans / case

DAC-102 On Line Mold Cleaner and Resin Remover

On Line Mold Cleaner and Resin Remover allows fast and efficient removal of polycarbonates and polystyrenes and will soften hard plastics such as nylon and Delrin®. The adjustable spray tip provides versatility and precise spray direction for cleaning small areas without residue.

- NSF Certified.
- Use during production, or off-line.
- Adjustable spray volume spray tip.



SDS



19 oz can
12 cans / case

DAC-104 All Purpose Foam

DAC-104 All Purpose Foam has excellent vertical adhesion for easy gas removal from vents. Our citrus-scented formula cleans and removes rust off the backs of molds, leaving a “Like New” appearance. Clears plugged vents with no down press time.

- Foam spray.
- Works on rust and resins.
- Excellent results when followed up with a degreaser.



SDS



9 oz can
12 cans / case

DAC-208 On Cycle Heavy Duty Resin Remover

On Cycle Heavy Duty resin remover is so powerful* it will remove the heaviest build-ups by allowing longer contact time on mold surfaces.

- Use on hot or cold molds.
- Works on the toughest resins.
- Can be injected or transfer-molded off.

*Contains trichloroethylene (TCE)



SDS



8.6 oz can
12 cans / case

DAC-111 Extreme Resin Remover

DAC-111 Extreme Resin Remover is our strongest formula* and will remove build-up on mold surfaces from gasses and many difficult to remove resins.

- Strongest resin remover works on most resins.
- Breaks down gas deposits in vents.
- Controlled evaporation.

*Contains trichloroethylene (TCE)

DAC INDUSTRIES' BEST PRACTICES



COMMON PROBLEMS:

- Rusty mold and/or platens
- Clogged vents
- Resin buildup

RUSTY / DIRTY MOLD



1 Spray DAC-104 onto dirty surface and wait 15 – 20 seconds (or more if needed).



2 Scrub with an abrasive pad or clean tissue / towel.



3 Flush / wash off the mold surface with a degreaser.



PLUGGED VENTS



1 Spray DAC-102, then let it sit for a few minutes.



2 Fill both sides of the mold with DAC-104 and close the mold.



3 Run 2 – 3 shots of resin through the mold to clear vents of buildup and residue.

DIFFICULT RESINS

- Polycarbonates
- Polyacetal resins
- Nylon
- Colfax
- Polystyrenes
- Some Delrins



1 Spray DAC-111, then let it sit for a few minutes.



2 Scrub with an abrasive pad or clean tissue / towel*.



3 Flush / wash off the mold surface with a degreaser.

*Additional steps may be needed, such as heating resin with a torch first.

MOLD RELEASES



SDS



8.6 oz can
12 cans / case

DAC-15151 All Purpose Mold Release

DAC-15151 All Purpose release spray is non-silicone, fully paintable and uses lecithin, an approved direct-food additive. Safe for use on all thermoplastics, including polycarbonates, styrene, acrylics, and other sensitive plastics used in urethane R.I.M. molding.

- No silicone.
- No chlorinated solvents.
- Paintable.



SDS



8.6 oz can
12 cans / case

DAC-36361 Paintable Mold Release

DAC-36361 Paintable release spray is all-temperature and works efficiently on both hot and cold molds, providing a smooth dry film which can be used where parts will be painted, hot-stamped, metallized, or otherwise decorated.

- Works on hot or cold molds.
- No CFC's.
- No chlorinated solvents.



SDS



8.6 oz can
12 cans / case

DAC-45451 All Temperature Silicone Mold Release

DAC-45451 All Temperature Silicone release spray works on hot or cold molds. This product is chlorinated solvent free, and provides a smooth, odorless, dry, non-toxic film.

- Silicone based.
- Works on hot or cold molds.
- Non-toxic



SDS



8.6 oz can
12 cans / case

DAC-85851 Biodegradable Paintable Release Spray

DAC-85851 release spray is completely non-toxic, biodegradable and suitable for applications where parts undergo second operations such as painting, hot stamping or metallizing.

- Biodegradable.
- Paintable.
- Works on hot or cold molds.

DAC INDUSTRIES' BEST PRACTICES



MOLD RELEASES

- Prevent stuck parts
- Improve startup efficiency
- Reduce downtime



1

Clean the mold surface with a cleaner or degreaser.

- Mold releases work best on clean steel.



2

Ensure the press is ready to start by checking:

- Process settings.
- Barrel temps.
- Water flow.
- Material moisture.



3

Standardize Application Procedure.

- Hold 6-12 in. away from mold surface.
- Use a light dusting at startup.
 - Focus on the front $\frac{1}{2}$ of the mold.
- Use a heavy coating if in-production.
 - Apply generously to both halves of the mold.



4

Apply the mold release

- Spray directly to the mold surface.
 - Focus on deep ribbing, cores and cavities.
- Or to avoid part contamination, apply to a clean paper towel or tissue and wipe onto the mold surface.

LUBRICANTS



SDS



8.6 oz can
12 cans / case

DAC-206 Wear Guard

DAC-206 is the most popular of all DAC Industries lubrication sprays because of its ability to keep parts lubricated for long runs without bleeding, galling or binding with a thin film over a wide range of temperatures.

- Dry lubrication spray.
- Adjustable spray nozzle: Light, Medium, Heavy.
- Temperature range up to 600° F.



SDS



8.6 oz can
12 cans / case

DAC-113 Super Lube

DAC-113 lubricant spray is an option for high-temperature operations where injection molders need a lubricant that won't bleed onto mold surfaces, bind or gall moving parts. Recommended for medical molding applications.

- For use on cams, slides and pins.
- Adjustable spray nozzle: Light, Medium, Heavy.
- High temperature range: 300° to 900° F.



SDS



8.6 oz can
12 cans / case

DAC-200 Die Lube

DAC-200 is recommended as an alternative to grease at low to moderate temperatures because of its ability to keep parts lubricated for long runs without bleeding, galling or binding with a thin film.

- Dry lubrication spray.
- Temperature range up to 200° F.
- Recommended as a grease alternative.



SDS



8.6 oz can
12 cans / case

DAC-75751 Extreme Penetrating Oil

DAC-75751 is a specially formulated cleaner, lubricant and protectant (CLP) that works in a variety of applications from air tool maintenance to every-day tools and equipment.

- Displaces moisture.
- Inhibits corrosion.
- Penetrates and loosens frozen/rusted nuts.

DAC INDUSTRIES' BEST PRACTICES



PROPER LUBRICATION PREVENTS

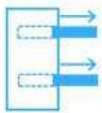
- Galling & binding
- Cosmetic defects from bleeding
- Mold damage

1



- Shake the can to prepare the lubrication spray.
- This ensures that the contents mix properly for an even distribution of chemicals.

2



- Push ejector pins forward.
- This ensures the entire pin is lubricated.

3



- Clean the pins of any oil, grease, or other buildup.
- Directly apply a cleaner or degreaser or apply to a clean towel and wipe off.

4

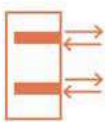


Apply lubrication spray:

- By spraying directly onto the ejectors to cover the entire pin.
- Or spray onto a clean paper towel, or tissue and apply by wiping pins to reduce the amount of product used.



5



Test and Clean

- Move the pins back-and-forth once properly lubricated.
- After testing, keep pins back.
- Clean the face of the mold with a degreaser or mold cleaner.



RUST INHIBITORS



DAC-101 Moisture Guard Rust Inhibitor

Moisture Guard displaces moisture and prevents rust and corrosion with an advanced 4-in-1 aerosol formula utilizing the best military spec. corrosion inhibitors and moisture displacing compounds. Excellent for short-term or long-term storage.

- Moisture displacing.
- Semi-transparent, wet coating.
- Short to long-term storage.



DAC-300 Ultra Fine Dry Mold Shield

This rust inhibitor spray will give you total control over corrosion with additional acid vapor neutralizing benefits. The DAC-300 has a fine mist that fog coats surfaces without bleeding or leeching, and is easily removed from metal surfaces.

- Neutralizes acid vapor.
- Clear coating, easy to remove.
- Recommended for short-term to long-term storage



DAC-116 White Rhino

DAC-116 prevents rust and corrosion with a white-indicator, semi-permanent shell ideal for long-term storage in harsh environments or for tools shipped overseas.

- Semi-permanent shell coating.
- White color indicator shows coverage area.
- Long-term storage.



DAC-302 Heavy Duty Neutra-Shield

DAC-302 has a formula specialized to neutralize stronger, more acidic resins and flame retardants. Use this inhibitor for applications where other rust inhibitors are not strong enough, or you are experiencing corrosion even with protection.

- Extra-strength destroys acid vapors on contact.
- Moisture displacing agents.
- One-step rust neutralizer & moisture displacer.

DAC INDUSTRIES' BEST PRACTICES



RUST INHIBITORS PREVENT

- Damage caused by rust
- Extra costs of cleaning
- Mold damage

1



Turn down TCU's below 100° F to allow to cool during teardown.

- Rust inhibitors work better on metal close to room temperature.

2



Remove water lines at the end of the run.

- Avoids moisture on the mold surface.

3



Clean the mold surface with cleaner or degreaser.

- Be sure to focus on removing all water.
- Inhibitors work best on clean steel.

4



Shake the can to prepare the inhibitor spray.

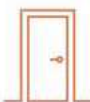
- This ensures that the contents mix properly for an even distribution of chemicals.

5



Apply the rust inhibitor.

- Press down directly on the nozzle. Avoid pressing from the side. This may damage the nozzle.
- Spray from approximately 12 in. away for even distribution and coverage.
- Focus on deep ribbing, cores and cavities which are more prone to rusting.
- Close the mold when finished.



MISCELLANEOUS PRODUCTS

DAC-REDGR Red Grease #2



14 oz tube
10 or 50 / case

DAC Red Grease prevents chattering, galling and binding, and is an all-purpose, non-melt grease, specially formulated with extreme pressure anti-wear additives to provide heavy duty service.

- High adhesive and cohesive properties.
- Heavy shock tolerance (65 Timken load)
- High temperature range (over 650° F)



9.5 oz can
12 cans / case

DAC-220 Easy Spray Grease

Easy Spray Grease is a superior non-melting grease that withstands extreme pressure and high temperature and won't break-down and leech-through ejector pins, cams, or sliders.

- High adhesive and cohesive properties.
- Heavy shock tolerance (100 Timken load)
- High temperature range (over 650° F)



8.5 oz can
12 cans / case

DAC-110 Micro Plate

Micro Plate is a dry graphite film lubricant for ejectors, lifters and core pins. Its unique bonding to metal will give you an instant plating agent that can be applied in house.

- Graphite lubrication.
- Recommended for soft metals.
- High temperature range up to 1,150° F



8.5 oz can
12 cans / case

DAC-306012 Heavy Duty Paintable Mold Release

DAC Heavy Duty Paintable mold release spray is all-temperature and works efficiently on both hot and cold molds with an extra strength dry film, and can be used where parts will be painted, hot-stamped, metallized, or otherwise decorated.

- Eliminates hydraulic vacuum effect.
- Paintable.
- Works on hot or cold molds (60° F to 600° F)

MISCELLANEOUS PRODUCTS



8.5 oz can
12 cans / case

DAC-112 Armor Plate

Armor Plate is a dry-film, semi-permanent Teflon compound plating agent. It fills voids in metal, eliminating surface friction, enhancing material flow and parts release. Armor Plate will not shrink or expand over a wide range of temperatures.

- Semi-permanent Teflon dry film.
- Eliminates surface friction.
- Wide temperature range.



32 Fl oz bottle
12 bottles / case

DAC-107 All Purpose Cleaner & Degreaser

The convenient trigger spray makes it ideal for clean room applications where aerosol sprays are prohibited. It quickly dissolves the tough grease, dirt, oil, wax, ink, resin, carbon, soot, and soap scum. Will not harm painted surfaces. This excellent penetrating formulation is safe to use, non-toxic, and produces no objectionable fumes when sprayed.

