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AMBERCOMPOSITES



Release Innovation™

PRODUCT DATA

Chemlease® 131

Semi-Permanent Release Agent

Description

Chemlease® 131 is a one-part, room-temperature curing material that provides a long-wearing release film with proper mold preparation and application. It gives easy, multiple releases, and does not require an extended cure. It is a ready-to-use liquid dispersion.

Application

Always use in a well-ventilated area. The ideal temperature of the mold for application is between 18-27°C. If Chemlease® 131 is applied below 18°C, allow a longer time than generally recommended for room temperature curing. If applied above 27°C, curing will be faster.

1. Shake or mix well before and during use. Soak a clean, soft, lint-free 100% cotton cloth (we recommend Chemlease® Cotton Cloth) until it is thoroughly wet.
2. Starting at one end of the mold, wipe a generous wet film over the mold in small sections.
3. Repeat until the mold is completely covered.
4. Allow to dry (haze) 10-15 minutes minimum at 20°C with good ventilation.
5. Check the mold for any area that appears uncoated (where haze is not present). Coat as above.
6. After the mold has dried to a haze, polish with a clean, dry, lint-free cotton cloth, we recommend our Chemlease® Cotton Cloth, until a high gloss is obtained. To ensure that no release agent is re-deposited onto the mold change cloth frequently.
7. Repeat steps 1-6 an additional 3 times for a total of 4 coats of Chemlease® 131. This will allow the release agent to seal any mold pores and will give the necessary film thickness to permit multiple releases. A final polish with a clean cotton cloth will achieve a higher Class A. gloss.
8. No additional cure time is necessary. The mold is ready for use.

Mold Preparation/Cleaning

Because Chemlease® semi-permanent release agents polymerize on the mold surface, all traces of prior

release agents, sealers and buffers/polishes must be removed from the mold.

To clean the mold following buffing, take the following steps:

1. Using liberal quantities of clean water, wipe the mold with a clean, soft, lint-free cotton cloth and wipe until dry.
2. Soak a clean, soft, lint-free cloth with Chemlease® Mold Cleaner EZ.
3. Apply the cleaner to the mold surface.
4. Before the cleaner dries, use a second clean cloth to wipe off the dissolved wax and other contamination.
5. Continue steps 3 & 4 until the surface is free of wax. When all trace of prior release agent have been removed, the hand/thumb will skid, and not slip, across the mold surface.

This method will remove not only wax release agents, but also waxes, silicones and water solubles contained in buffing and rubbing compounds (including "jewelers' rouge").

Touch-Up:

As parts are removed from the mold, abrasion will gradually wear away the release film. When slight sticking is noticed, maintain the film by applying one or two touch-up coats (as required), as described above.

Molders should experience no buildup with Chemlease® 131. Previously applied product does not have to be removed prior to touch-up.

If the mold surface contains buildup of material such as styrene, internal mold releases, UV absorbers, gel coats, "top coats" or other mold contaminants, clean the mold with Chemlease® Mold Cleaner EZ as specified under Mold Preparation/Cleaning.

Storage

Store at room temperature, product is frost sensitive. Do not use if use-by date has been exceeded.

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Technical Department

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Chemlease® 131

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Handling

We believe Chemlease® 131 has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Material Safety Data Sheet. Storage Stability, unopened container 9 months. Store at room temperature, product is frost sensitive. Do not use if use-by date has been exceeded.

Packaging

Chemlease® 131 is available in containers filled with 0,72 kg and 3,9 kg.

Further Information

Request information on our complete range of materials for this industry.

The information contained in this document is given in good faith based on our current knowledge. It is only an indication and in no way binding, particularly as regards infringement of or prejudice to third party rights through the use of our products. Chem-Trend warrants only that its products will meet its sales specifications. This information must on no account be used as a substitute for necessary prior tests which alone can ensure that a product is suitable for a given use. Users are requested to check that they are in possession of the latest version of this document and Chem-Trend is at their disposal to supply any additional information.

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