Chemlease® 1363

Semi-Permanent Release Agent

Description

Chemlease® 1363 is unique semi permanent mold release agent developed specifically for the polyester molding industry.

Benefits

- Multiple releases between applications
- Provides excellent gloss
- Easy to apply
- High temperature stability
- Eliminates the use of wax
- Does not build up on the mold surface
- Reduces labor time and costs
- Virtually no transfer to molded part

Chemlease® solvent carriers contain no Class I or II registered ozone depleting substances

Application

Mold Preparation:

1. Mold surfaces should be thoroughly cleaned to remove all traces of wax, release agents, sealers and buffing compounds.
2. Do a final cleaning of mold surface with Chemlease® Mold Cleaner EZ.
3. Seal mold with Chemlease® 15 Sealer. (See 15 Sealer Technical Data Sheet for details)

APPLICATION FOR BASE COATS:

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and other sealers.
2. Surface should be dry and free of contaminants.
3. Saturate a clean 100% cotton cloth (we recommend Chemlease® Cotton Cloth) and wipe on a smooth continuous film. Apply no more than a few square feet at a time.
4. Wait 15-20 seconds. While film is still wet, wipe the surface with a second clean dry cotton cloth using a circular motion from the outside, working inwards until film is left dry and clear.
5. Repeat above procedures until entire mold surface has been covered.
6. Apply 4-5 coats, allowing 10 minutes between each complete coat.
7. Allow 20-30 minutes for full cure. Proceed with production.

NOTES:

Time will vary with room and mold temperature. Wipe off as the solvent begins to evaporate. If the release agent is left on too long, you may notice some smearing or streaking. To remove the smear or streak, rub the affected area with the recommended Chemlease® release agent, then simply remove the excess sooner than you had before.

TEST TO ENSURE PROPER APPLICATION:

Attach a small strip of masking tape to different areas of the mold. There should be very little resistance when removing the tape if proper release is applied. Compare to an untreated mold. (Tape should adhere to untreated mold).

TOUCH UP COATS:

Once in production the release film will begin to wear. Rather than applying a touch-up coat once the parts begin to stick, it is better to do preventative maintenance. For example, if trials determine that 20 releases are obtainable between touch-up coats, it is better to reapply a touch-up coat after every 15 cycles or at the end of every second shift if you are, for example, turning the molds 8 times per shift. The above described action will keep the molds in production longer and help establish a routine of quality preventative maintenance.

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Sales
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Technical Department

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Release Innovation™

PRODUCT DATA

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COATING PATCH REPAIRS:

Prior to repairing a patch, make sure the release is removed for 3-4 inches around the area to be repaired. Note: Semi permanent releases must be removed with mild abrasion as well as a solvent wipe. If not, the patch will not bond to the surface and break out. Once the patch is cured, treat the area as a new mold:

1. Clean with Mold Cleaner EZ;
2. Apply Chemlease® 15 Sealer and cure per instructions;
3. Apply 5 coats of Chemlease® 1363 release agent and cure.

Touch up the patched area with Chemlease® 1363 every other cycle for the first 4-6 releases.

Remember, the patch is weaker than the rest of the mold and will require extra attention for the first few cycles.

Further, a touch-up coat (other than patch repair) should usually be done over the whole mold. This prevents having to re-touch another area that is wearing on the next cycle. However, there may be some areas of surface draft, etc. That may require a touch up more frequently. For example:

- Touch up complete mold every 16 cycles;
- Touch up small areas with difficult draft angles every 8 cycles.

Chemlease® 1363 is designed to blend into itself very easily and operator experience will quickly determine the number of cycles between spot and complete touch-up. For a spot touch-up, only the 10-minute room temperature cure time is needed.

Whenever the mold is stripped, reapply Chemlease® 15 Sealer and/or the Chemlease® 1363 base coats as described.

Storage

It is important that the materials be left in the factory containers as the product is susceptible to moisture contamination if the container is left open or the material is stored in the wrong type of container. The material should always be clear. Storage stability in unopened containers is 12 months.

Handling

We believe Chemlease® 1363 has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Material Safety Data Sheet.

Packaging

Chemlease® 1363 is available in containers filled with 0,87 ; 4,4 kg and 15 kg.

Further Information

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

Supplied by

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