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Release Innovation™

PRODUCT DATA

Chemlease® 1365

Semi-Permanent Release Agents

Description

Chemlease® 1365 is a rapid curing semi-permanent mold release agent that provides multiple releases with virtually no transfer to the molded part. The cured film has high thermal stability. It is developed for releasing most composite materials where matte or satin finish is required.

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

Application

Mold Preparation:

1. Clean mold surface to remove all traces of waxes, releases and sealers.
2. Clean mold with Chemlease® Mold Cleaner EZ.
3. Apply Chemlease® 1366 Mold Sealer to new or porous molds (see technical data sheet for details).

Instructions for base coats:

To the cleaned/sealed mold surface:

1. Using a wetted clean 100% cotton cloth (we recommend Chemlease® Cotton Cloth) or fine mist spray pattern, wipe or spray on a smooth, wet, (not runny) continuous film over the entire mold surface.
2. Do not wipe film off, allow to dry on its own and cure for 10 minutes.
3. If puddling or dripping occurs, (usually the case for heavy application or cold molds) wipe off any excess on the mold surface with a clean, dry cotton cloth
4. Apply a total of 3-5 coats per the above instructions.
5. Allow final coat to cure for 30 minutes at room temperature. Cure is instant at 120°C or higher.

Edition 16.06.2008

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Erstellt: Dr. I Däke – 16.07.2008
Technische Abteilung

TIPS: If final time can be extended to one hour or longer at room temperature or mold can be heated to 65°C or higher for 30 minutes, this will further enhance the quality of release and the number of releases between applications.

Touch-up coats:

Reapply one light coat as required and cure as for final coat.

Important:

The recommended number of coats and cure times are a general guideline found to be more sufficient in a broad spectrum of moulding conditions. When moulding products with extreme geometries or experiencing low-humidity conditions in the shop, the customer may find the need to extend the cure time between coats and increase the number of coats applied to the mould. The efficiency of a release film is best determined through a combination of tape tests and experimentation.

Storage

Do not store at temperatures above 40°C. Keep container tightly sealed to prevent evaporation and/or moisture contamination. If stored in cold temperatures, allow product to warm to room temperature prior to use.

Do not use, if the expiry date has been exceeded.

Handling

For more information, request a copy of Chem-Trend's Material Safety Data Sheet.

Packaging

Chemlease® 1365 is available in 1 and 5 liter containers.

Further Information

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

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Geprüft / Freigegeben: Dr. I Däke – 18.07.2008

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