

PRODUCT DATA

## Chemlease® 1366 Mold Sealer

### Description

Chemlease® 1366 is a high performance sealer developed to condition and seal mold surfaces, reduce mold porosity and act as a base for new or reconditioned molds.

#### BENEFITS:

- Reduces porosity problems.
- Provides an excellent base coat for all types of release agents.
- Compatible with fiberglass, aluminum, steel, and most solid or dense surfaces
- Shortens break-in time.
- High temperature stability.

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

### Application

#### Wiping

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and other sealers. We recommend Chemlease® Mold Cleaner EZ.
2. Surface should be dry and free of contaminants.
3. Saturate a clean and 100% cotton cloth, not dripping, (we recommend Chemlease® Cotton Cloth) and wipe on a smooth continuous film of no more than a few square feet at a time.
4. Wait until the Chemlease® 15 film starts to evaporate (approximately 3-20 seconds) and while film is still wet, wipe the surface with a second clean dry cotton cloth using a circular motion from the outside working inward until the film is left dry and clear. A cold mold surface may require a longer waiting period before wiping off excess material.
5. Repeat above procedures until entire mold surface has been covered. Usually only one coat is necessary.
6. Allow to cure for one hour before applying mold release.

#### Spraying

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and sealers.
2. To apply by spraying use a hand held manual spray bottle or a dry air system. It is important that all containers and spray lines be thoroughly clean and dry.
3. Keep spray nozzle 10 to 15 inches from mold surface and apply a smooth, thin continuous film. Do not allow to run or drip (by over applying).
4. While film is still wet, wipe the surface with a clean dry cotton cloth using a circular motion from the outside working inward until film is left dry and clean.
5. Repeat above procedures until the entire mold surface is covered overlapping slightly to ensure complete coverage. Usually only one coat is necessary.
6. Allow to cure for one hour before applying mold release.

**Note:** Cold temperatures increase time necessary for cure. Cure time can be accelerated by elevating mold temperature to 100 °C for 30 minutes.

#### Important

The recommended number of coats and cure times are a general guideline found to be more sufficient in a broad spectrum of molding conditions. When molding 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 mold. The efficiency of a release film is best determined through a combination of tape tests and experimentation.

**PRODUCT DATA****Storage**

Keep container closed at all times when not in use. Mold must be thoroughly cleaned and dried before application. A good test to tell if the mold is clean is to use a small piece of masking tape (approximately 1" in width) on the mold surface. Sufficient resistance should be felt when removing the tape. Material should be clear with no noticeable precipitate. If cloudy or milky, material is contaminated. Areas of application should be well ventilated. Storage stability in an unopened container is 12 months.

**Handling**

We believe Chemlease® 1366 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® 1366 is available in containers filled with 0,87 kg and 4,3 kg.

**Further Information**

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

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