

Chemlease® 15 Sealer EZ

Mold Sealer

Description

Chemlease® 15 Sealer EZ 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

- HAPs Free*
- 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.
- Reduces labor time and costs
- High temperature stability

*HAPs are not formula constituents of this product. Standard manufacturing processes may result in trace quantities [$<0.1\%$] of HAPs.

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

Application Instructions

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 clean cotton cloth (not dripping) and wipe on a smooth continuous film of no more than 0.6 meter² at a time.
4. When the film begins to evaporate at the edges, approximately 15-20 seconds, wipe the surface with a second clean dry cotton cloth. Use a circular motion from the outside, working inwards until the tooling is left dry and clear. *See Notes.*
5. Repeat above procedures until entire mold surface has been covered. Usually only one coat is necessary on a seasoned mold (Two coats are recommended when sealing a new or green mold. Allow 15 minute cure time between the first and second application. Wait one hour after the second coat before applying the release or top coat).
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 new, clean, hand held manual spray bottle or a clean dry air system. It is important that all containers and spray lines are thoroughly cleaned and dried. If container is dirty, rinse at least twice with an appropriate cleaner.
3. Keep spray nozzle 25 to 38 cm from mold surface and apply a smooth, thin continuous film. Do not allow to run or drip (by over applying).
4. When film begins to evaporate at edges, approximately 15-20 seconds, 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. *See Notes.*

5. Repeat above procedures until the entire mold surface is covered overlapping slightly to ensure complete coverage. Usually only one coat is necessary on a seasoned mold (Two coats are recommended when sealing a new or green mold. Allow 15 minute cure time between the first and second application. Wait one hour after the second coat before applying the release or top coat).
6. Allow to cure for one hour before applying mold release.

Important

The recommended number of coats and cure times are a general guideline found to be more than 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.

Troubleshooting Tips

1. Keep container closed at all times when not in use.
2. Mold must be thoroughly cleaned and dried before application. To test if the mold is clean, use a small piece of masking tape (approximately 2,5 cm in width) on the mold surface. There should be sufficient resistance when removing the tape.
3. Material should be clear with no noticeable precipitate. If cloudy or milky, material is contaminated.
4. Areas of application must be well ventilated.

Packaging

Chemlease® 15 Sealer EZ is available in 1 L, 5 L and 20 L containers.

Safety Data

Material Safety Data Sheets are available for all Chemlease® products and should be consulted prior to use of the product.

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 before.

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