

PRODUCT DATA

Chemlease® 2185

Semi-Permanent Release Agent

Description

Chemlease® 2185 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.

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.

This method will remove not only wax release agents, but also waxes, silicones and water solubles that are contained in buffing and rubbing compounds. This includes "jewelers' rouge." 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 (tee-shirt-type material) and wipe until dry.
2. Soak a clean, soft, lint-free cloth with a Chemlease® Mold Cleaner.
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 contaminants.
5. Continue steps 3 and 4 until the surface is free of wax. When all traces of prior release agent have been removed, the hand/thumb will skid, and not slip, across the mold surface.

Application

Always use in a well-ventilated area. Consult MSDS prior to use. The ideal temperature of the mold for application is between 18-27°C.

If Chemlease® 2185 is applied below 18°C, allow a longer time than generally recommended for room-temperature curing. If applied when the mold surface is over 27°C, curing will be faster.

1. Shake or mix well before and during use. Soak a clean, soft, lint-free cotton cloth (tee-shirt type material) until it is thoroughly wet.

2. Starting at one end of the mold, wipe a generous wet film over a 2 x 0,6 cm section.
3. Repeat until the mold is completely covered. (see note after "5" which applies to very large molds)
4. Check the treated mold for any area that appears uncoated (where haze is not present). Coat as above.
5. After the product has dried to a haze on the mold surface, polish with a clean, dry, lint-free cotton cloth until a high gloss is obtained. To ensure that no release agent is re-deposited onto the mold, change cloth frequently.

Note: Do not allow any product to remain dry (hazed) for any longer than 30 minutes as it will become very difficult to buff out
6. Repeat steps 1-6 an additional four times for a total of five coats of Chemlease® 2185. 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.
7. A cure time of 30 minutes is recommended prior to molding parts.

Touch-Up Coats

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® 2185. Previously-applied Chemlease® does not have to be removed prior to touch-up. If the mold surface contains buildup of materials such as styrene, internal mold releases, UV absorbers, gel coats, "top coats" or other mold contaminants, clean the mold with a Chemlease® Mold Cleaner as specified under Mold Preparation/Cleaning.

Chemlease® 2185

Semi-Permanent Release Agent

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.

Packaging

Chemlease® 2185 is available in 2,78 kg container.

Safety Data

Please ask your Chemlease® sales representative for a copy of the Material Safety Data Sheet.

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.

Edition 17.06.2008

Supplied by

AMBERCOMPOSITES

94 Station Road, Langley Mill
Nottingham, NG16 4BP United Kingdom
T: +44 (0)1773 530899 F: +44 (0)1773 768687
E: sales@ambercomposites.com
www.ambercomposites.com

Further Information

Request information on our complete range of materials for this industry from your Chem-Trend sales representative