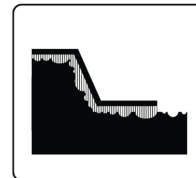




Chemlease® Sealer 2697

Mold Sealer

Distributed by
Freeman Manufacturing & Supply Co.
www.freemansupply.com (800) 321-8511



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Description

Chemlease® Sealer 2697 is a HAPs-free* solvent-based semi-permanent sealer for the composites industry which affords easy application in one step. The product should be applied to the mold surface very lightly and allowed to dry. The original mold surface finish appearance will be reproduced once the product is dry.

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

Application

Wipe-On Method

1. The mold surface must be cleaned to remove all traces of wax, release agents, and other sealers before application of Chemlease® Sealer 2697 can be attempted. Use the appropriate Chemlease® Mold Cleaner (Contact your Chem-Trend Sales Representative for a recommendation).
2. Dampen a 100% cotton cloth and apply a very light and even coat to the mold surface. Apply the product in 2' x 2' sections, overlapping each section slightly in order to ensure full coverage.
3. As a guide to achieving a "very light coat", the wet film should shine, but there should be no runs in it when applied to a vertical surface. In normal temperature conditions, the film should evaporate less than 60 seconds after applying. If the film still remains after 1 minute, the product was applied too heavily and will produce streaks on the mold. To fix the affected area, wipe off the remaining film. Then wipe a lighter coat with a dampened sealer cloth and immediately wipe off to remove the streaks. Then recoat as described above.
4. As soon as the wiping action appears not to be forming a film, add more product to the cloth as describe above in step #2.
5. Continue working across the mold in 2' x 2' sections until the entire surface has been coated.
6. Allow the coat to cure for 15 minutes.
7. Using the same method, apply an additional coat onto the mold surface for a total of 2 coats. For a new mold or difficult to release part, apply an additional 2 coats for a total of 4 coats.
8. Allow the sealer to cure for a minimum of 30 minutes after the final coat has been applied before applying release agent onto the mold.

Spray-On Method

1. The mold surface must be cleaned to remove all traces of wax, release agents, and other sealers before the application of Chemlease® Sealer 2697 can be attempted. Use the appropriate Chemlease® Mold Cleaner (Contact your Chem-Trend Sales Representative for a recommendation).

2. Use an HVLP spray gun to apply a light, even coat to the mold surface. Keep the spray gun 8-10 inches away from the mold surface while spraying approximately two linear feet (0.6 meter) per second. We recommend 7-10 psi for the fluid pressure and 20- 30 psi for the air pressure as a general guideline. Spray the first coat on the mold surface and allow the solvent to evaporate. No waiting between coats is necessary when spraying.
3. Spray using a cross-hatch (0/90) technique to ensure full coverage. Spray the next coat perpendicular to the first for a total of two coats. For a new mold or difficult to release part, apply an additional 2 coats for a total of 4 coats.
4. Allow the sealer to cure for a minimum of 30 minutes after the final coat has been applied before applying release agent onto the mold.

Important

The recommended number of coats and cure times are a general guideline found to be sufficient in a broad spectrum of molding conditions. When molding products with extreme geometries or experiencing low-humidity conditions, the customer may find it necessary 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.

Storage

Do not store at temperatures above 100°F/38°C. Keep container tightly sealed to prevent evaporation and/or moisture contamination.

Handling

We believe Chemlease® Sealer 2697 has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Safety Data Sheet.

Packaging

Chemlease® Sealer 2697 is available in a variety of package sizes. Please contact Chem-Trend customer service for details

Further Information

Request information on our complete range of materials: custom-formulated release agents for polyurethane molding; tire lubes and bladder coatings; Mono-Coat® semi-permanent release coatings; aerosol formulations; mold cleaners and sealers; specialized coatings and application equipment.

While the technical information and suggestions for use contained herein are believed to be accurate and reliable, nothing stated in this bulletin is to be taken as a warranty either expressed or implied.