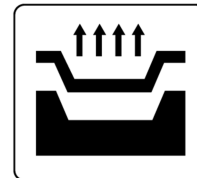




Chemlease® 2185

Semi-Permanent Release Agent



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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 65-80°F/18-27°C.

If Chemlease® 2185 is applied below 65°F/18°C, allow a longer time than generally recommended for room-temperature curing. If applied when the mold surface is over 80°F/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 2 foot 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.

Packaging

Chemlease® 2185 is available in a variety of package sizes. Please contact Chem-Trend customer service for details.

Safety Data

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

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.