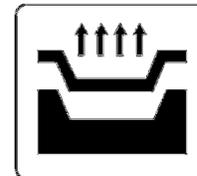




Chemlease® CPre

Release Agent



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Description

Chemlease® CPre is a unique semi-permanent mold release system developed specifically for applications in which pre-release can be a concern such as large flat parts or concave shaped molds. Chemlease® CPre provides multiple releases between application while maintaining a Class A finish and fine mold details.

Chemlease® CPre is easy to apply, eliminates the use of wax while minimizing mold build up, and can reduce labor time and costs. Chemlease® CPre allows the use of most standard fine line masking tapes. Chemlease® solvent carriers contain no Class I or II registered ozone depleting substances.

Mold Preparation

1. Mold surfaces should be thoroughly cleaned to remove all traces of wax release agents sealers and buffing compounds.
2. Do a final cleaning of mold surface with Chemlease® Mold Cleaner.
3. Seal mold with the appropriate Chemlease® mold sealer. (Contact your local Chemlease® representative for information and details.)

Application for Base Coats

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and other sealers.
2. Surface should be dry and free of contaminants.
3. Saturate clean cotton cloth (not dripping) and wipe on a smooth continuous film. Apply no more than a few square feet at a time.
4. While film is still wet, 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.
5. Repeat above procedures until entire mold surface has been covered.
6. Apply 4-5 coats, allowing 15 minutes between each complete coat.
7. Allow 30 minutes for full cure. Proceed with production.

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 smears or streaks, rub the affected area with the recommended Chemlease® release agent, simply remove the excess sooner than you had before.

Touch-Up Coats

Once in production the release film will begin to wear. Rather than applying a touch-up coat once the parts begin to stick it is better to do preventative maintenance. For example, if trials determine that 20 releases are obtainable between touch-up coats, it is better to re-apply a touch-up coat after every 15 cycles or at the end of every second shift if you are, for example, turning the molds 8 times per shift. The above-described action will keep the molds in production longer and help establish a routine of quality preventative maintenance.

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.

Storage

Do not store at temperatures above 49°C/120°F. Keep containers tightly sealed to prevent evaporation and/or contamination. It is important that the materials be left in the factory containers as the product is susceptible to moisture contamination if the container is left open or the material is stored in the wrong type of container. The material should always be clear. If cloudiness is detected, contact your Chem-Trend technical representative.

If stored in cold temperatures, allow time to warm to ambient temperatures before using.

Packaging

Chemlease® CPre 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.