

Chemlease® R&B EZ

Semi-Permanent Release Agent

Description

Chemlease® R&B EZ is a unique HAPs-free* semi-permanent mold release developed specifically for the composite molding industry. It may be used with a variety of molding resins including, but not limited to, polyester, vinyl ester, DCPD, Phenolic, epoxy and BMI. Chemlease® R&B EZ provides higher slip and is used primarily for closed molding of abrasive, low draft parts, where a quality finish is still required.

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

Application Instructions

Mold Preparation/Cleaning

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® Sealer.

Wiping

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. When the film begins to evaporate at the edge, wipe the surface with a second clean dry cotton cloth. Use a circular motion from the outside, working inwards until film is left dry and clear. See **Notes**.
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.

Spraying

1. The mold should be dry and free of contaminants before Chemlease® R&B EZ is applied to the mold surface. Thoroughly clean and remove all traces of wax, release agents, and other sealers. We recommend Chemlease® Mold Cleaner.
2. To apply by spraying use a hand held manual spray bottle or a dry air system. It is important that all containers and spray lines be thoroughly clean and dry.
3. Keep spray nozzle 10 to 15 inches from mold surface and apply a smooth, thin continuous film. Do not allow to run or drip (by over applying). Gently wipe excess material off of the mold using a clean, dry cotton cloth.
4. Repeat above procedures until the entire mold surface is covered, overlapping slightly to ensure complete coverage on the mold surface.
5. Apply 3-5 coats allowing 15 minutes between each coat.
6. Allow the mold to cure for 30 minutes after final coat.

NOTES:

Evaporation rates and 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, simply remove the excess sooner than you had before.

Touch-Up Coats

Rather than applying a touch-up coat once the parts begin to stick, it is better to do a preventative maintenance coat. For example, if trials determine that 20 releases are obtainable between touch-up coats, it is better to reapply 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. Cure the touch-up coat as stated in the previous application instructions.

Test to Ensure Proper Application

Attach a small strip of masking tape to different areas of the mold. There should be very little resistance when removing the tape if proper release is applied. Compare to an untreated mold. (Tape should adhere to untreated mold).

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

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.

Packaging

Chemlease® materials are available in 1, 5, and 55 gallon containers.

Safety Data

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

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.