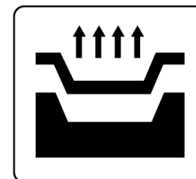




Chemlease® 258-R

Water-based release agent for difficult molding applications



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Description

Chemlease® 258-R is designed to provide easy part release for difficult, abrasive molding applications. Chemlease® 258-R is typically recommended for the following processes: filament winding, pre-preg wrapping and wet lay-up on mandrels; LPMC, BMC, polymer concrete, and high abrasion compression molding.

Application

Chemlease® 258-R can be spray or wipe applied, although the wipe method is considered to be the most effective.

Mold Preparation

For best performance, mandrels should be free of all contaminants including previous release agents, resin, etc. This can be accomplished with the appropriate Chemlease® mold cleaner and an abrasive pad (i.e. Scotch Brite). Perform a final wipe with mold cleaner using a lint-free cotton cloth.

Wipe on/ leave on application

Soak a clean, lint-free soft cotton cloth with Chemlease® 258-R and apply to the mandrel. Initially, two to three even, light coats should be applied to ensure proper coverage, with a few minutes of dry time between each coat. As a guide to achieving a "light coat", when the film is applied to a VERTICAL mold surface, the wet film should shine, but there should be no runs in it. Runs in the film indicate too heavy an application. The film should proceed to dry evenly at ambient or warm temperatures. Do not heat cure Chemlease® 258-R prior to molding. After de-molding the part, reapply Chemlease® 258-R as required (typically one coat). A noted increase in performance and ease of application will occur if Chemlease® 258-R can be applied on a warm surface. However, a (high) heat cure/dry is not recommended

Spray on/ leave on application

Using a finely-atomized spray, apply one light uniform coat of Chemlease® 258-R over the entire clean surface of the mandrel. Hold the spray tip 10-25cm from the mold surface. As a guide to achieving a "light coat", when the film is applied to a VERTICAL mold shine, but there should be no runs in it. Runs in the film indicate surface, the wet film should too heavy an application. Any running, puddling or excess should be wiped off. The film should proceed to dry

evenly at ambient or warm temperatures. Do not heat cure Chemlease® 258-R prior to molding. After de-molding the part, reapply Chemlease® 258-R as required (typically one coat).

NOTE: Chemlease® 258-R will not build up unless substantially over-applied.

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 experimentation in order to ensure optimum performance.

Storage

Do not store at temperatures above 38°C. Prolonged exposure to higher temperatures may reduce product stability and/or performance. Do not allow to freeze. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures, allow product to warm to room temperature and shake well prior to use.

Handling

For more information, please request a copy of Chem-Trend's Material Safety Data Sheet.

Packaging

Product is available in a variety of packaging. Please contact our customer service team for details.

Further Information

Request information on our complete range of materials for this industry.

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