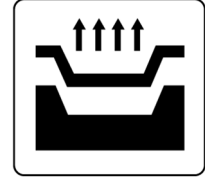




Chemlease® 2710

Semi-Permanent Release Agent



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Description

Chemlease® 2710 is a solvent-based semi-permanent release agent 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.

Mold Preparation

1. Mold surfaces should be thoroughly cleaned to remove all traces of wax, oils, sealers, buffing compounds and other release agents. Proper removal typically requires abrasive methods such as buffing, wet-sanding or bead/ice blasting.
2. Perform a final cleaning of the mold surface using an appropriate Chemlease® Mold Cleaner.
3. Seal mold with a Chemlease® Sealer if appropriate.

Application – Wipe-On Method

1. Lightly dampen a cotton cloth with the release agent.
2. Apply a light, even coat to the mold surface. In normal temperature conditions, the film should evaporate in less than 30 seconds after applying. If the film remains longer, the product was applied too heavily and will produce streaks on the mold. To remove streaks, promptly reapply release agent to the affected area then immediately wipe off.
3. As soon as the wiping action appears not to be forming a film, add more product to the cloth as described above.
4. Continue wiping across the mold until its entire surface has been coated.
5. Allow the coat to dry and cure for 15 minutes.
6. Using the same technique, apply 4 - 6 total coats. For a new mold or difficult to release part, apply additional coats as necessary to season the mold.
7. After the final coat has been applied, allow to cure for a minimum of 30 minutes before molding.

8. When release becomes difficult, reapply one or more coats of Chemlease® 2710. Allow to cure for 15 minutes and resume molding.

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.

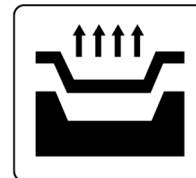
Application – Spray-On Method

1. Use a HVLP spray gun fitted with a small spray nozzle, 0.013 – 0.021 in. (0.3 – 0.5 mm). As a general guideline, fluid pressure should be set to 7-10 psi (0.5 – 0.7 Bar) and air pressure set to 20-30 psi (1.5 – 2.0 Bar).
2. Position the spray gun 8-10 inches away from the mold surface while spraying approximately two linear feet (0.6 meter) per second.
3. Spray a light, even coat to the entire mold surface. No cure time between coats is necessary when spraying; simply allow to dry.
4. Spray subsequent coats perpendicular to one another, known as a cross-hatch (0/90) pattern, to ensure full coverage.
5. Using the same technique, apply 4 - 6 total coats. For a new mold or difficult to release part, apply additional coats as necessary to season the mold. .
6. After the final coat has been applied, allow to cure for a minimum of 30 minutes before molding.
7. When release becomes difficult, reapply one or more coats of Chemlease® 2710. Allow to cure for 15 minutes and resume molding.



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Storage

Do not store at temperatures above 49°C/120°F. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures allow warming to room temperature before using.

Packaging

Chemlease® 2710 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. **WARNING:** Never puncture any Chemlease® product container.

Further Information

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

Legal Notice

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