



©2016 Chem-Trend L.P.

Chemlease® MPP 2684W

Mold Prep and Primer

Description

Chemlease® MPP 2684W is a semi-permanent water-based mold primer especially formulated for sealing and priming tooling substrates including, but not limited to polymeric substrates such as polyester, vinyl ester, epoxy, phenolic, BMI, urethane. This primer can also be used to seal most metal surfaces including Invar, steel, aluminum, electroformed nickel as well as chromed and anodized surfaces.

Uses

Chemlease® MPP 2684W should be applied onto a clean mold surface. Chemlease® MPP 2684W is an excellent sealing material, but should not be used as a mold release agent. Use of this product without a release agent may result in severe damage to the mold. The primer may also work to re-surface a worn mold. The appropriate Chemlease® sealer or releasent should be applied on top of the product after it has been cured.

Mold Preparation

1. After the mold has been buffed and polished with rubbing and polishing compounds, wash the mold surface thoroughly with clean water. The proper water wash will remove all fillers and water-soluble contaminants from the buffing and polishing compounds. Use liberal amounts of water. Wipe dry with clean cotton cloths. If following with a water-based cleaner, there is no need to dry the mold surface.
2. Following the water wash, use a Chemlease® mold cleaner to remove all traces of contaminants such as waxes, silicones, oils, etc. Use liberal quantities of the mold cleaner in a well-ventilated area, according to the specific instructions on the Product Data Sheet. Wipe dry with clean cotton cloths until the mold is "squeaky clean" by thumb or hand rub test.
3. The wiping cloth should be changed regularly to ensure that a clean, absorbent surface of the wiping cloth is always presented to the mold surface. This procedure prevents recontamination of the mold by wiping cloths which carry contaminants lifted from the mold.

Application Instructions

1. Apply Chemlease® MPP 2684W by a wipe-on/leave-on technique. Use clean, soft cotton cloths. "Fill" the cloth with Chemlease® MPP 2684W, but product should not drip from the cloth. Wipe a light coat on to the mold surface. **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 or sags in it.** Apply the product to the whole mold as quickly as possible, ensuring complete coverage. Care should be taken on large structures to ensure that the overlap area is as small as possible and that the product on the area overlapped has not already cured – you should perform overlaps on the "wet edge".

Generally, 2 or 3 coats are sufficient to seal/prime.

Allow 30 minutes between each coat. After the final coat, allow a 1-2 hour cure at room temperature.

2. When the product has cured, apply the appropriate Chemlease® water-based mold sealer or topcoat. Please refer to the proper Product Data Sheet for application details and instructions.

Cure Test

Under the best conditions, Chemlease® MPP 2684W has been found to cure in as little as one hour. A simple test method for complete cure is: Apply one drop of water onto a flange area that has been coated with the product. Wait a few seconds then wipe off with a clean cloth. If there is no evidence of the drop on the tool surface, the product is completely cured.

Important

The recommended number of coats and cure times are a general guideline found to be 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 it necessary to extend the cure time between coats and increase the number of coats applied to the mold.

Storage

The container should be kept closed at all times when not in use to prevent contamination, evaporation and/or premature curing. Store product between 40°F/4°C and 100°F/38°C. Although Chemlease® MPP 2684W is water-based, it is a flammable product. Keep away from heat, sparks, flames and combustion sources during storage and use. If stored in cold temperatures, allow to warm to room temperature before using. Do not allow to freeze.

Handling

We believe Chemlease® MPP 2684W has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Safety Data Sheet.

Packaging

Chemlease® MPP 2684W is available in a variety of package sizes. Please contact Chem-Trend customer service for details.

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.