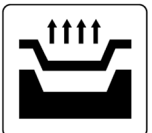




Chemlease® 5097W Water-Based Release Agent



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Description

Chemlease® 5097W is a water-based release agent that is easy to apply and gives excellent release ease for composite molding. When used as directed, Chemlease® 5097W will help keep molds clean and free from build-up of resins and molding compounds. Chemlease® 5097W is ready-to-use and is environmentally friendly.

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 for composite molds and bead/ice blasting for metal molds.
2. Perform a final cleaning of the mold surface using an appropriate Chemlease® mold cleaner. Speak to your Sales Representative for a product recommendation.
3. Seal mold with a Chemlease® Mold Sealer if appropriate. Speak to your Sales Representative for a product recommendation.

Wipe-On Application

1. Chemlease® 5097W may be wiped onto the mold surface at room or elevated temperatures.
2. Wipe-on a thin, even layer of Chemlease® 5097W onto the mold surface using a clean, cotton cloth and allow the water carrier to evaporate completely.
3. Apply 2-4 more coats of Chemlease® 5097W as outlined in step 2 for a total of 3-5 coats prior to layup and molding.
4. Reapply one or more coats after each demolding as described above to maintain proper release.

Spray Application

1. Chemlease® 5097W may be spray applied onto the mold surface at room or elevated temperatures.
2. Use conventional air spray equipment, such as HVLP, and hold the spray tip 8-12"/20-31cm from the mold surface. Use a cross-hatch [0/90] spray technique wherein each subsequent coat is sprayed in the perpendicular direction to ensure full coverage.
3. Spray apply a light coat onto the mold surface and allow the water carrier to evaporate completely.
4. Apply 2-4 more coats of Chemlease® 5097W as outlined in steps 2 and 3 for a total of 3-5 coats prior to layup and molding.

5. Reapply one or more coats after each demolding as described above to maintain proper release.

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 Chemlease® 5097W at temperatures above 40°C/104°F. Keep from freezing. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures, allow to warm to room temperature before using.

Handling

We believe Chemlease® 5097W 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® 5097W 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.