

PRODUCT DATA

Chemlease® 15 Sealer

Mold Sealer

Description

Chemlease® 15 Sealer is a high performance sealer developed to condition and seal mold surfaces, reduce mold porosity and act as a base for new or reconditioned molds.

Benefits

- Reduces porosity problems.
- Provides an excellent base coat for all types of release agents.
- Compatible with fiberglass, aluminum, steel, and most solid or dense surfaces
- Shortens break-in time.
- High temperature stability - 850°F/450°C

Chemlease® solvent carriers contain no Class I or II registered ozone depleting substances.

Application Instructions

Wiping

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and other sealers. We recommend Chemlease® Mold Cleaner.
2. Surface should be dry and free of contaminants.
3. Saturate clean cotton cloth (not dripping) and wipe on a smooth continuous film of no more than a few square feet at a time.
4. Wait until the Chemlease® 15 Sealer film starts to evaporate (approximately 3-20 seconds) and while film is still wet, wipe the surface with a second clean dry cotton cloth using a circular motion from the outside working inward until the film is left dry and clear. A cold mold surface may require a longer waiting period before wiping off excess material.
5. Repeat above procedures until entire mold surface has been covered. Usually only one coat is necessary.
6. Allow to cure for one hour before applying mold release.
Note: Cold temperatures increase time necessary for cure. Cure time can be accelerated by elevating mold temperature to 200°F for 30 minutes.

Spraying

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and sealers.
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).
4. While film is still wet, wipe the surface with a clean dry cotton cloth using a circular motion from the outside working inward until film is left dry and clean.
5. Repeat above procedures until the entire mold surface is covered overlapping slightly to ensure complete coverage. Usually only one coat is necessary.
6. Allow to cure for one hour before applying mold release.
Note: Cold temperatures increase time necessary for cure. Cure time can be accelerated by elevating mold temperature to 200°F for 30 minutes.

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.

Troubleshooting Tips

1. Keep container closed at all times when not in use.
2. Mold must be thoroughly cleaned and dried before application.
Note: A good test to tell if the mold is clean is to use a small piece of masking tape (approximately 1" in width) on the mold surface. Sufficient resistance should be felt when removing the tape.
3. Material should be clear with no noticeable precipitate. If cloudy or milky, material is contaminated.
4. Areas of application should be well ventilated.

Packaging

Chemlease® 15 Sealer is available in 1 and 4 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.