

PRODUCT DATA

Chemlease® 71-90

Semi Permanent Release Agent

Description

Chemlease® 71-90 is a rapid curing semi-permanent mold release agent that provides multiple releases with no transfer to the molded part. Chemlease® 71-90 is the highest slip version of Chemlease® 71; primarily for closed molding of abrasive or low draft parts, where a matte or satin finish is required.

Chemlease® 71-90 is also suitable to be used in closed molding, such as Vacuum Resin Infusion and RTM - "B" Side.

Benefits

- High thermal stability to 850°F.
- Does not transfer.
- Multiple releases between applications.

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

Mold Preparation

1. Clean mold surface to remove all traces of waxes, releases and sealers.
2. Clean mold with Chemlease® Mold Cleaner.
3. Apply Chemlease® 15 Sealer to new or porous molds (see Chemlease® 15 Sealer product data sheet for details).

Application Instructions for Base Coats

To the cleaned/sealed mold surface:

1. Using a wetted clean cotton cloth or fine mist spray pattern, wipe or spray on a smooth, wet, (not runny) continuous film over the entire mold surface. With a second, clean, dry cotton cloth, wipe off any excess on the mold surface (usually the case for heavy application or cold molds).
2. Allow film to dry and cure for 10 minutes.
3. Apply a total of 3-5 coats per the above instructions.
4. Allow final coat to cure for 30 minutes at room temperature. Cure is instant at 250°F or higher.

Touch-Up Coats

Reapply one light coat as required and cure as for final coat.

Tips

If final time can be extended to one hour or longer at room temperature or mold can be heated to 150°F or higher for 30 minutes, this will further enhance the quality of release and the number of releases between applications.

Packaging

Chemlease® 71-90 is available in aerosols, 1, 5 and 55-gallon quantities.

Safety Data

Material Safety Data Sheets are available for all Chemlease® products and should be consulted prior to use of the product.

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