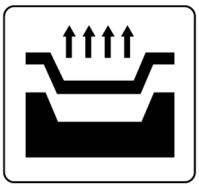
Chem Trend
Release Innovation™

PRODUCT DATA SHEET



Chemlease® A2191W

Water-based semi permanent composite release agent

Description

Chemlease® A2191W is a semi permanent water-based release agent, which is effective for composite molding including processes using vacuum bagged epoxy carbon fiber prepreg components. It gives minimal transfer of release agent and multiple releases. Chemlease® A2191W is ready-to-use as shipped.

Application

Chemlease® A2191W can be applied on cold molds in a wipe-on mode or may be spray applied on to cold or hot molds. It is not recommended for application on cold steel molds as corrosion may occur. Certain mold surface textures, notably high gloss finishes, can cause the applied film to form into beads rather than a smooth, even film. This is normal and the special application instructions below should be followed in these cases

Mold Preparation

Thoroughly clean the mold with the appropriate Chemlease® mold cleaner to remove the previous release agent or other contamination. Wipe dry with a clean cloth.

Wipe on/ leave on application

Soak a clean, lint-free soft cotton cloth with Chemlease® A2191W. Apply three to five light* uniform coats to the clean mold surface. The film should proceed to dry evenly at ambient temperature. If the film appears to form beads, the wet wiping cloth should be used to spread the beads over the mold surface until the film appears smooth. In the case of high gloss finish molds, gently buff the smoothed film to a shine using a clean dry cotton cloth. Let the coats toughen for at least 10 minutes after each application. After the final coat, allow to cure for minimum one hour before starting production.

Spray on/ leave on application

Using a finely-atomized spray, apply three to five light* uniform coats of Chemlease® A2191W to the clean mold surface. The film should proceed to dry evenly at ambient temperature. If the film appears to form beads, a wiping cloth wetted with Chemlease® A2191W should be used to spread the beads over the mold surface until the film appears smooth. In the case of high gloss finish molds, gently buff the smoothed film to a shine using a clean dry cotton cloth. Let the coats dry 10 minutes after each application. After the final coat, allow to cure for minimum one hour before starting production.

Reapplication

Reapply a light coat of Chemlease® A2191W when required to maintain desired release. Allow to cure for one hour before starting production. To prevent buildup, avoid over application.
*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 in it. Runs in the film indicate too heavy an application.

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 lowhumidity 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

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determined through a combination of tape tests and experimentation in order to ensure optimum performance.

Storage

Do not store at temperatures above 38°C. Prolonged exposure to higher temperatures may reduce product stability and/or performance. Do not allow to freeze. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures, allow product to warm to room temperature and shake well prior to use. Do not use, if the use-by date has been exceeded (see label on container).

Handling

We recommend all fluid handling equipment and piping be made of stainless steel or plastic. Brass, copper or aluminium is not suitable. For further information on storage, handling, hazards etc., please consult the Material Safety Data Sheet.

Packaging

Product is available in a variety of packaging. Please contact our customer service team for details.

Safety Data

For more information on storage, handling, hazards, etc., please request a copy of Chem-Trend's Material Safety Data Sheet, which must be consulted prior to use of this product.

Further Information

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

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