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Release Innovation™

## PRODUCT DATA

# Chemlease® 5051

## Release Agent

### Description

Chemlease® 5051 is formulated specifically for releasing composite thermoset parts made on mandrels.

### Mold Preparation

For best performance, Chemlease® recommends that mandrels should be free of all contaminants including previous release agents, resin, etc. This can be accomplished with the appropriate Chemlease® Mold Cleaner and an abrasive pad (i.e., Scotch Brite®).

Also, Chemlease® 15 Mold Sealer EZ can be used to further increase/enhance performance.

### Application

Chemlease® 5051 can be spray or wipe applied, although the wipe method is considered to be the most effective. When wiping on the material, saturate a clean, cotton cloth with Chemlease® 5051 and apply to the mandrel. Initially, two to three even coats should be applied to ensure proper coverage, with a few minutes of dry time between each coat. Do not heat cure Chemlease® 5051 prior to molding.

After de-molding the part, reapply Chemlease® 5051 as required (typically one coat). A noted increase in performance and ease of application will occur if Chemlease® 5051 can be applied on a warm surface. However, a (high) heat cure/dry is *not* recommended. When spraying on the material, be sure to spray a uniform coat over the entire surface of the mandrel. Any running, puddling, or excess should be wiped off. It is important that a fine mist spray system be used. Reapply as necessary.

*Note: Chemlease® 5051 should not build up unless substantially over applied.*

### 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 at temperatures above 100°F/38°C. Keep container tightly sealed to prevent evaporation and/or moisture contamination. If stored in cold temperatures, allow product to warm to room temperature prior to use.

### Safety Data

Consult the MSDS prior to using this or any Chemlease® product.

### Packaging

Chemlease® 5051 is available in one (1), five (5) and 55 gallon containers.

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.