

PRODUCT DATA

Chemlease® One FS™

Semi-Permanent Release Agent

Description

Chemlease® One FS™ is a solvent-based semi-permanent releasant for the composites industry which affords easy application in one step. The product should be applied to the mold surface *very lightly* and allowed to dry. The original mold surface finish appearance will be reproduced once the product is dry. Maximum durability will be achieved with this product.

Application

1. The mold surface must be cleaned before the application of Chemlease® One FS™ can be attempted (See datasheet for Chemlease® Mold Cleaner.)
2. Apply a small amount of product to a clean cotton cloth and wipe onto the mold surface to form a glossy, continuous film.
3. As soon as the wiping action appears not to be forming a film, add more product to the cloth, to ensure it wets the surface of the mold being wiped as in #2 above.
4. Continue working across the mold until its entire surface has been coated.
5. Allow the film to dry for ten minutes.
6. Using the same procedure, apply five complete coats.
7. Cure for a minimum of 30 minutes after the final coat has been applied.
8. Begin molding and continue until release-ease appears tight.
9. When release becomes difficult, clean the mold with Chemlease® Mold Cleaner, followed by one coat of Chemlease® One FS™. Allow to cure for 15 minutes and resume molding.

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 49°C/120°F. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures allow warming to room temperature before using.

Handling

We believe Chemlease® One FS™ has a low degree of hazard when used as intended. For more information, request a copy of Chem-Trend's Material Safety Data Sheet.

Packaging

Chemlease® One FS™ is available in 1-quart (1 liter), 1-gallon (4 liter), 5-gallon (20 liter) and 55-gallon (208-liter) container.

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.