



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- Wipe-On Method.

1. The mold surface must be cleaned before the application of Chemlease® One FS™ can be attempted. Use the appropriate Chemlease® Mold Cleaner (Contact your Chemlease Sales Representative for a recommendation).
2. Apply a small amount of product to a clean cotton cloth and wipe a light coat onto the mold surface to form a glossy, continuous film. 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.
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 15 minutes.
6. Using the same procedure, apply five complete coats. For a new mold or difficult to release part, apply an additional 2 coats for a total of 7 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 reapply 1 coat of Chemlease® One FS™. Allow to cure for 15 minutes and resume molding.

Application- Spray-on method

1. The mold surface must be cleaned to remove all traces of wax, release agents, and other sealers before application of Chemlease® One FS™ can be attempted. Use the appropriate Chemlease® Mold Cleaner (Contact your Chemlease Sales Representative for a recommendation).
2. Use an HVLP spray gun to apply a light, even coat to the mold surface. 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.

3. Keep the spray gun 8-10 inches away from the mold surface while spraying approximately two linear feet (.6 meter) per second. We recommend 7-10 psi for the fluid pressure and 20-30 psi for the air pressure as a general guideline.
4. Apply 5 coats one after another. No waiting between coats is necessary. For a new mold or difficult to release part, apply an additional 2 coats for a total of 7 coats.
5. After last coat is applied, allow 30 minutes for cure before gel coating. Begin molding.
6. When release becomes reapply 1 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.