

Chemlease® PMR EZ

Release Agent

Description

Chemlease® PMR EZ is a unique semi permanent mold release system developed specifically for the composites industry, for use where a high quality finish is required.

Benefits

- HAPs free*
- Multiple releases between applications
- Easy to apply
- Eliminates the use of wax
- Reduces labor time and costs
- Provides excellent gloss
- High temperature stability
- Does not build up on the mold surface
- Minimal transfer to molded part

* HAPs are not formula constituents of this product. Standard manufacturing processes may result in trace quantities [$<0.1\%$] of HAPs.

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

Mold Preparation

1. Mold surfaces should be thoroughly cleaned to remove all traces of wax, release agents, sealers and buffing compounds.
2. Do a final cleaning of mold surface with Chemlease® Mold Cleaner EZ.
3. Seal mold with the appropriate Chemlease® Sealer.

Application For Base Coats

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and other sealers.
2. Surface should be dry and free of contaminants.
3. Saturate clean cotton cloth (not dripping) and wipe on a smooth continuous film. Apply no more than 0.6 meter² at a time.
4. When the film begins to evaporate at the edge, approximately 15-20 seconds, wipe the surface with a second clean dry cotton cloth. Use a circular motion from the outside, working inwards until film is left dry and clear. See **Notes**.
5. Repeat above procedures until entire mold surface has been covered.
6. Apply 4-5 coats, allowing 15 minutes between each complete coat.
7. Allow 30 minutes for full cure. Proceed with production.

Notes

Time will vary with room and mold temperature. Wipe off as the solvent begins to evaporate. If the release agent is left on too long, you may notice some smearing or streaking. To remove the smear or streak, rub the affected area with the recommended Chemlease® release agent, then simply remove the excess sooner than you had before.

Test To Ensure Proper Application

Attach a small strip of masking tape to different areas of the mold. There should be very little resistance when removing the tape if proper release is applied. Compare to an untreated mold. (Tape should adhere to untreated mold).

Touch-Up Coats

Once in production the release film will begin to wear. Rather than applying a touch-up coat once the parts begin to stick, it is better to do preventative maintenance. For example, if trials determine that 20 releases are obtainable between touch-up coats, it is better to reapply a touch-up coat after every 15 cycles or at the end of every second shift if you are, for example, turning the molds 8 times per shift. The above described action will keep the molds in production longer and help establish a routine of quality preventative maintenance.

Coating Patch Repairs

For patch repair, please refer to Coating Patch Repair Technical guide.

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.

Packaging

Chemlease® PMR EZ is available in containers with 0,69 kg, 3,4 kg and 13,9 kg. The material should always be clear. If cloudiness is detected, please contact a Chemlease® technical representative.

Storage

Do not store at temperatures above 50°C. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures allow warming to room temperature before using.

Safety Data

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

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.

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