

Chemlease®

Mould Release Systems



Solid Surface & Cultured Marble | Fiberglass-Reinforced Plastic | RTM | **Advanced Composites**

Chemlease® Advanced Composites Release System

Manufacturers of advanced composite products know the importance of delivering finished parts of high structural integrity and ideal surface quality. In addition, they need to make parts efficiently and profitably. Chemlease® mould release systems help on both counts.

Chemlease® brand products offer:

- Unparalleled priming/sealing capabilities
- Easily removable buildup
- Extremely low mold build-up
- Semi-permanent or conventional top coats
- Virtually no transfer to part
- Water-based options
- Excellent release of all prepreg types
- High thermal stability

Technical Data

For each step, choose the product that best suits your applications (see individual Product Data Sheets and Material Safety Data Sheets for specific storage, handling and application instructions)

Step 1: Clean (Choose One)

Chemlease® Mould Cleaner EZ: A chemically aggressive solvent-based cleaner that will remove organic materials such as waxes and will “freshen” surfaces coated with old semi-permanent products.

Chemlease® Mould Cleaner 1000W: User-friendly, water-based cleaner that will remove waxes, old semi-permanent products and light resin build-up.

Step 2: Prime

Chemlease® MPP 712 EZ: For the real tough sealing jobs on extremely porous composite and metal surfaces. This product can also be used to restore the surface to worn composite tooling.

Step 3: Seal (Optional)

Chemlease® 15 Sealer EZ: For light duty sealing of tool surfaces with micro-scale porosity.

Step 4: Top Coat (Choose One)

Chemlease® 2191 W: A unique water-based semi-permanent product suitable for most epoxy-based pre-pregs. Very low transfer to the moulded part.

Chemlease® 41 EZ - series: Extremely versatile solvent-based semi-permanents that will de-mold any type of pre-preg. Dash-90 variant provides excellent slip for deep-drafted parts.

Chemlease® R&B EZ is a high slip release agent designed for non-cosmetic parts where resin is in direct contact with the mold surface providing multiple releases.

Note: These are general application guidelines. Please consult your local Chemlease representative and individual product Data Sheets and Material Safety Data Sheets for specific storage, handling and application instructions.

COMPOSITE SELECTOR GUIDE

Product Application

	application type	number of coats	cure time between coats (minutes)	final cure time prior to molding (minutes)
Top Coats – Class A Finish (High Gloss)				
Chemlease® PMR-90 EZ	wipe on and wipe dry for high gloss	3 to 5	15	30
Chemlease® PMR EZ	wipe on and wipe dry for high gloss	3 to 5	15	30
Chemlease® One FS™ EZ	wipe on, allow to dry	3 to 5	15	30
Chemlease® 2185	wipe on, buff off	5	dry	30
Chemlease® 75 EZ	wipe on and wipe dry for high gloss	3 to 5	15	30
Chemlease® 2172	wipe on and wipe dry for high gloss	3 to 5	15	30
Top Coats – Non-Class A Finish				
Chemlease® R&B EZ	wipe on ^o	3 to 5	15	30
Chemlease® 41 EZ	wipe on ^o	3 to 5	15	30
Specialty Top Coats				
Chemlease® One FS™ EZ	spray on	3 to 5	0	30
Chemlease® 2191W	wipe on ^o	3 to 5	10	60
Chemlease® 2196W	wipe on and buff for high gloss	5 to 7	15	60
Chemlease® FC-500	spray on only for masters and plugs	5	dry	dry
Sealers and Primers				
Chemlease® 15 Sealer EZ	wipe on and wipe dry for high gloss	1 to 2	15	60
Chemlease® MPP 712 EZ	wipe on and wipe dry for high gloss	1 to 2	30	60
Internals				
Chemlease® IM02	add to resin	N/A	N/A	N/A
Cleaners				
Chemlease® Mould Cleaner EZ	wipe on, wipe off	N/A	N/A	N/A
Chemlease® Mould Cleaner 1000W	wipe on, wipe dry	N/A	N/A	N/A

^o = Wiping off excess material will enhance part appearance

bold green = The highlighted products are the first recommendation for Advanced Composites, however the choice is not restricted to these upon the process parameters and requirements. Please consult with the Chem-Trend representative for advice before choosing the right system.

Note: When experiencing low humidity conditions in the shop, the customer may find the need to extend the time between coats and increase the number of coats applied to the mould.

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. Please refer to individual data sheets for further application, safety and handling information.

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Release Innovation™