

# Chemlease®

Mould Release Systems



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

## Chemlease® FRP and Marine Applications

With the broadest and most comprehensive semi-permanent product line in the industry,

Chemlease® is the answer to your most difficult release concerns. Whether it's plugs and masters, small part production, hulls or decks, or open or closed moulding, Chemlease® technology delivers the right product for your application.

## Chemlease® Semi-Permanent Technology Delivers:

- Multiple releases
- High thermal stability
- Virtually no transfer
- High-slip
- Easy release on the most aggressive composite resins
- Easy touch-up aggressive composite resins
- High-gloss or non-cosmetic finish
- Low to no buildup
- Easy application including spray-on-only and wipe-on-only fast application
- Products that can virtually eliminate pre-lease on large mouldings such as boat hulls

## Clean, Seal, and Top Coat for Superior Release

### Step 1: Clean (Choose One)

Chemlease® Mould Cleaner 1000W is a water-based cleaner formulated to remove waxes, buffing compounds and semi-permanents including sealers and topcoats.

Chemlease® Mould Cleaner EZ is a heavy duty, solvent-based cleaner formulated to dissolve waxes and buffing compounds without removing the semi-permanent coating layer.

### Step 2: Seal

Chemlease® 15 Sealer EZ is a high-performance sealer formulated to condition mould surfaces by reducing porosity and acting as a protective barrier for new or reconditioned moulds.

### Step 3: Top Coat (Choose One)

Chemlease® 2172 is a high gloss release specifically formulated for large parts and hulls where pre-release may be a concern.

Chemlease® 75 EZ is a multiple-release formula for large parts and hulls or where pre-release may be a concern. Chemlease® 75 EZ is a HAPS-free, higher release option for Chemlease® 2172.

Chemlease® PMR EZ is our most popular high-gloss multiple-release formula for composite moulding specifically designed for smaller parts and decks.

Chemlease® One FS™ EZ is an easy-to-apply, wipe-on-only or spray-on only, multiple-release formula for high-gloss composite moulding.

Chemlease® PMR-90 EZ is a higher slip version of Chemlease® PMR EZ for parts with deep drafts or difficult release.

Chemlease® 2196W is a water-based multiple-release formula for high-gloss composite applications.

## Ancillary Products

Chemlease® MPP 712 EZ is a unique heavy-duty mould primer that seals mould porosity, brings worn tooling back to life, and increases top coat durability.

Chemlease® FC-500 is a liquid wax-based release agent formulated to allow rapid production of moulds from plugs.

Chemlease® 2185 is a hybrid liquid wax and semi-permanent formulation providing a high-gloss finish with multiple release capabilities.

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

<sup>o</sup> = Wiping off excess material will enhance part appearance

**bold green** = The highlighted products are the first recommendation for Fiberglass-Reinforced Plastic, 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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