

Chemlease®

Mold Release Systems



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

Chemlease® RTM Release System

Resin Transfer Molding. For all its many benefits, RTM creates the most difficult environment in release agent performance today.

Chemlease® has developed a revolutionary, leading-edge release system designed to address the following:

- The chemically abrasive RTM resins that destroy most release films
- Mold build-up and “scumming” that plague other release products
- Mold configurations and low-shrink resins that mechanically abrade the release film

The Chemlease® RTM Release System has the tenacity, chemical resistance, durability and lubricity required for RTM including:

- Superior mold sealing capability, eliminating the effect of porosity
- Easier multiple releases for better production output
- Virtually no transfer to the molded part, resulting in less post-mold cleaning
- Increased mold use between touch-ups, vastly reduced downtime

Application Data for Superior Release

Step 1: Clean (choose one)

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

Chemlease® Mold 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: Prime

Chemlease® MPP 2180 is a unique, heavy-duty mold primer and chemically inert sealer with no release agent characteristics. The product is designed to fill areas with bad porosity, particularly new molds and repaired areas.

Step 3: Seal

Chemlease® 15 Sealer EZ is a high-performance sealer formulated to condition mold surfaces, reducing porosity and acting as a protective barrier for new or reconditioned molds. This product does have multiple release characteristics

Step 4: Top Coat (choose one)

Chemlease® PMR-90 EZ is a high-slip release agent that enhances the overall gloss of Class A surface finishes while the durable film provides multiple releases.

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, which provides multiple releases.

Step 5: (Optional) Internal Release Agent

Chemlease® IM02 is an internal release agent that retards mold build-up and assists the demolding process for each part. Add 0.1-1.0% by weight IM02 to resin followed by a 15-minute mix. Always consult your resin supplier before adding an internal release agent.

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.

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® CPR	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 ^a	3 to 5	15	30
Chemlease® 41 EZ	wipe on ^a	3 to 5	15	30
Specialty Top Coats				
Chemlease® One FS™ EZ	spray on	3 to 5	0	30
Chemlease® 2191W	wipe on, buff off/wipe on only	5 minimum	15	60
Chemlease® 2196W	wipe on and buff for high gloss	5 to 7	15	60
Chemlease® Chemwax 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 2180	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® Mold Cleaner EZ	wipe on, wipe off	N/A	N/A	N/A
Chemlease® Mold Cleaner 1000W	wipe on, wipe dry	N/A	N/A	N/A

^a = Wiping off excess material will enhance part appearance

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 mold.

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.