



# Chemlease®

ADVANCED COMPOSITES

## Chemlease® Advanced Composites Release Systems

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® mold release systems help on both counts.

### CHEMLEASE® BRAND PRODUCTS OFFER:

- Unparalleled priming/sealing capabilities
- Easily removable buildup
- Extremely low mold buildup
- Semi-permanent or conventional topcoats
- Virtually no transfer to part
- Water-based options

### APPLICATION DATA FOR SUPERIOR RELEASE

#### Step 1: Clean (Choose one)

- Chemlease® Mold 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® Mold Cleaner 1009W:** A water-based cleaner effective in removing most contaminants and semi-permanent release coatings. Can also be used to prepare parts for secondary bonding or painting for non-cosmetic surfaces or molds.

#### Step 2: Prime (Choose one)

- Chemlease® MPP 712 EZ:** For the really tough sealing jobs on extremely porous composite and metal surfaces. This product can also be used to restore the surface of worn composite tooling.
- Chemlease® MPP C2684W:** Water-based mold primer formulated for sealing and priming a wide variety of tooling substrates.

#### Step 3: Seal (Choose one)

- Chemlease® 15 Sealer EZ:** For light-duty sealing of tool surfaces with microscale porosity.
- Chemlease® Sealer 2697:** A high-gloss, solvent-based, semi-permanent sealer which affords easy application in one step using a wipe-on-only technique.

#### Step 4: Topcoat (Choose one)

- Chemlease® PMR EZ Series:** Extremely versatile solvent-based semi-permanents that will de-mold any type of pre-preg. Chemlease® PMR-90 EZ provides excellent slip for deep-drafted parts.
- Chemlease® 2710:** A high-gloss, multiple release product formulated to handle challenging release applications and affords easy application in one step wipe-on-only technique.
- Chemlease® R&B EZ:** A high-slip release agent designed for non-cosmetic parts where resin is in direct contact with the mold surface, providing multiple releases.
- Chemlease® 5094W:** Water-based, high-slip that allows for effortless release with minimal buildup on the mold.
- Chemlease® 5097W EU:** Non-silicone, water-based release agent. No cure time required. Ideal for autoclave molding and laying up with epoxy pre-pregs.
- Chemlease® 2754W:** Water-based, semi-permanent compatible for releasing a variety of thermoset resins. Provides minimal transfer of release agent and high temperature stability. Perfectly suited for high temperature compression molding.

# Composite Selector Guide

APPLICATION TYPE		NUMBER OF COATS	CURE TIME BETWEEN COATS (MINUTES)	FINAL CURE TIME PRIOR TO MOLDING (MINUTES)
<b>TOPCOATS Class A Finish (High Gloss)</b>				
Chemlease® PMR EZ	Wipe on, wipe off for high gloss	3 to 5	15	30
Chemlease® 2710	Wipe on, let dry	5 to 7	15	30
Chemlease® 41-90 EZ	Wipe on, wipe off for high gloss	3 to 5	15	30
<b>TOPCOATS Non-class A Finish</b>				
Chemlease® 41-90 EZ	Wipe on, let dry*	3 to 5	15	30
Chemlease® R&B EZ	Wipe on, let dry*	3 to 5	15	30
<b>SPECIALTY TOPCOATS</b>				
Chemlease® 2754W	Spray on, let dry	3	Allow to evaporate	Allow to evaporate
Chemlease® 5097W EU	Wipe on, let dry or spray on, let dry	3 to 5	Allow to evaporate	Allow to evaporate
Chemlease® 5094W	Wipe on, let dry	3 to 5	Allow to evaporate	Allow to evaporate
<b>SEALERS</b>				
Chemlease® 15 Sealer EZ	Wipe on, wipe off for high gloss	2 to 3	15	30
Chemlease® Sealer 2697	Wipe on, let dry	2 to 3	15	30
<b>PRIMERS</b>				
Chemlease® MPP 712 EZ	Wipe on, wipe off for high gloss	Varies based on surface roughness	30	60
Chemlease® MPP C2684W	Wipe on, let dry for high gloss	Varies based on surface roughness	30	60
<b>CLEANERS</b>				
Chemlease® Mold Cleaner EZ	Wipe on, wipe off	N/A	N/A	N/A
Chemlease® Mold Cleaner 1009W	Buff on, rinse off	N/A	N/A	N/A
<b>INTERNALS</b>				
Chemlease® IC-25	Add to resin	N/A	N/A	N/A

\* Wiping off excess material will enhance part appearance

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.

Contact Chem-Trend to find out more about how our release agents and specialty products can improve your composites operations.

