

Chem-Trend Product Guide: Composites



	Slip high medium low	Product Application				Application Guide By Market					Comments
		application type	number of coats	cure time between coats (minutes)	final cure time prior to use (minutes)	open moulding	RTM	cultured marble & solid surface	marine	advanced composites	
Top Coats - Class A Finish (High Gloss)											
Chemlease® PMR / EZ	high	wipe on & buff dry for high gloss	3 to 5	15	30	preferred		**	preferred	**	- high slip, high gloss release system for use where high quality finish is required
Chemlease® One FS™ / EZ	mid	wipe/spray on, leave on	3 to 5	15	30	preferred		**	preferred	**	- single step, easy to apply release system which allows the original mould surface finish to be reproduced once dry
Chemlease® 75 EZ	mid-low	wipe on & buff dry for high gloss	3 to 5	15	30			preferred		**	- mid slip, hi gloss semi permanent release system
Chemlease® CPR	low	wipe on & buff dry for high gloss	4 to 5	15	30	preferred			preferred		- semi permanent release developed for applications where pre-release is a concern such as large flat or concave shaped moulds
Top Coats - Non-Class A Finish											
Chemlease® 41-90 EZ	high	wipe/spray on #	3 to 5	15	30	**	preferred	preferred	**	preferred	- high slip release primarily used for closed moulding for abrasive or low draft parts
Chemlease® R&B EZ	high	wipe/spray on #	4 to 5	15	30		preferred		**		- primarily used in closed moulding of abrasive, low draft parts where quality finish is still required
Mould Sealer											
Chemlease® 15 Sealer EZ	N/A	wipe/spray on & buff dry	1 or 2	15	60	preferred	required	preferred	preferred	preferred	- high performance sealer developed to seal mould surfaces, reduce porosity and act as a base for new or reconditioned moulds
Mould Primer											
Chemlease® MPP 2180	Nil	Resurfacing - wipe on & leave. Sealing - wipe on & buff dry^	1 or 2	30	60 - 120	where needed	where needed	where needed	where needed	where needed	- unique primer for sealing of FRP and Advanced Composites tooling including polyester, gelcoat and non gelcoat, epoxy, phenolic and most metal moulds
Mould Cleaners											
Chemlease® Mould Cleaner EZ	N/A										- solvent based cleaner - removes waxes, silicones, contaminants and resin build-up
Chemlease® Hydrolease Cleaner	N/A										- water based cleaner - removes sealers, primers and topcoats from most mould surfaces
Mold Cleaner 501	N/A										- solvent based cleaner - removes waxes, silicones, contaminants and resin build-up
Mould Cleaner 201B	N/A										- blended powerful stripping agents - easy to handle resin remover for removal of thermoset and thermoplastics from moulds

- wiping/buffing off excess material will enhance part appearance.

** suitable / recommended

^ for sealing purposes, Chemlease 15 Sealer EZ is generally preferable to MPP2180

Note: When experiencing low humidity conditions in the workshop, it may be necessary to extend the time between coats and increase the number of coats applied to the mould. These are general application guidelines. Please consult your local Chemlease representative and particular Product Data Sheets and Material Safety Data Sheets for specific storage, handling and application instructions.

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