

CHEMLEASE MOULD RELEASE SYSTEMS

SOLID SURFACE & CULTURED MARBLE • FIBREGLASS-REINFORCED PLASTIC • RTM • ADVANCED COMPOSITES

CHEMLEASE® RTM RELEASE SYSTEM

Resin Transfer Moulding. 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
- Mould configurations and low shrink resins that mechanically abrade the release film
- Mould buildup and “scumming” that plague other release products

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

- Superior mould sealing capability, eliminating the effect of porosity
- Easier multiple releases for better production output
- No transfer to the moulded part, resulting in less post-mould cleaning
- More mould utilisation between touch-ups, vastly reduced downtime

TECHNICAL DATA

See individual Product Data Sheets and Material Safety Data Sheets for specific storage, handling and application instructions.

Step 1. Chemlease® IM-02: An internal release agent that retards mold buildup and assists the demoulding process for each part. Add 0.1-1.0% by weight IM02 to resin followed by a 15-minute mix. Always consult with your resin supplier before adding an internal release agent.

Step 2. Chemlease® Mould Cleaner: An aggressive solvent-based cleaner that removes contaminants such as paste wax, buffing compounds, soap, etc. Thoroughly clean mould with white 100% cotton cloths.

Step 3. Chemlease® MPP-2N: A mold prep and primer, MPP-2N is a heavy-duty, chemically inert sealer that has no release agent characteristics. The product is designed to fill areas with bad porosity, particularly new molds and repaired areas. Apply two coats.

Step 4. Chemlease® Sealer 15: A light-duty sealer that has some release characteristics and prepares the mould surface for the top coat of release agent. Apply two coats.

Either

Step 5. Chemlease® 70-90: A high-slip release agent that enhances the overall gloss of Class A surface finishes while the durable film provides multiple releases. Apply three coats.

Or

Step 5. Chemlease® 41-90: A high-slip release agent designed for non-cosmetic parts and multiple releases. 41-90 will mirror the surface of the mould closely, facilitating replication of highly diverse surfaces with a single release agent. Apply three coats.

Note: *These are only general application guidelines. We recommend you consult with your local Chemlease representative for specific application recommendations*

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.

COMPOSITE SELECTOR GUIDE

Process	Gel Coat High Gloss	Gel Coat Matte Finish	Non-Gel Coat High Gloss	Non-Gel Coat Matte Finish
Hand Lay-Up FRP	PMR / ONE FS SK2 / SK3	41	PMR-90	41-90
RTM	CL System*	CL System*	CL System*	CL System*
Cultured Marble	75	41	N/A	N/A
Solid Surface	N/A	41-90	N/A	41-90
Filament Winding	258-R	258-R	258-R	258-R
Marine	75 / SK3 PMR / ONE FS	41	PMR-90	41-90**
Cold (Press) Molding	PMR-90	41-90	PMR-90	41-90
Masters and Plugs	FC 500	FC 500	FC 500	FC 500
Pre-Preg Composites	N/A	41-90	2002	41-90
Hand Lay-Up Phenolic	N/A	41-90	41-90	41-90
Polymer Concrete	85T2	85T2	85T2	258-R
Mould Treatment / Sealing	MPP-2N RPM 712 Sealer 15	MPP-2N RPM 712 Sealer 15	MPP-2N RPM 712 Sealer 15	MPP-2N RPM 712 Sealer 15

Complementary Chemlease Products:

ONE FS™: A new wipe-on-only, solvent-borne semi-permanent release product that provides high gloss, low buildup and multiple release characteristics.

Chemlease® 2130AW: A new waterborne semi-permanent release agent that provides multiple releases, minimal transfer and Class A finish.

Chemlease® Cleaner 1000W: The newest environmentally friendly cleaner with the power and functionality of most solvent-based products.

Chemlease® MPP-2N / RPM 712: A heavy-duty mould preparative primer that seals mould porosity and imperfections; provides a sound base for semi-permanent release agents, but no release characteristics.

Chemwax SP™: Multi-purpose paste wax for FRP providing some multiple release characteristics.

SP L1: A hybrid liquid wax that provides a high-gloss finish and some multiple release capabilities.

* Use IM-02 internal release with suggested external release. ** Glass stringers require our high slip agents.

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