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Release Innovation™

PRODUCT DATA

Chemlease® PMR-90 EZ Semi-Permanent Release Agent

Description

Chemlease® PMR-90 EZ is a rapid curing semi-permanent mold release agent that provides multiple releases with minimal transfer to the molded part. Chemlease® PMR-90 EZ is the highest slip version of the Chemlease® PMR family; primarily for closed molding of abrasive or low draft parts.

Benefits

- HAPs Free*
- High thermal stability
- Easy to apply
- Multiple releases between applications.
- Reduces labor time and cost

* HAPs are not formula constituents of this product. Standard manufacturing processes may result in trace quantities [$<0.1\%$] of HAPs.

Chemlease® solvent carriers contain no Class I or II registered ozone depleting substances.

Mold Preparation

1. Clean mold surface to remove all traces of waxes, release agents and sealers.
2. Clean mold with Chemlease® Mold Cleaner EZ.
3. Apply the appropriate Chemlease® Sealer to new or porous molds (contact a Sales Rep or Distributor for details).

Application For Base Coats

1. Mold surface must be thoroughly cleaned to remove all traces of wax, release agents, and other sealers.
2. Surface should be dry and free of contaminants.
3. Saturate clean cotton cloth (not dripping) and wipe on a smooth continuous film. Apply no more than 0.6 meter² at a time.
4. When the film begins to evaporate at the edge, wipe the surface with a second clean dry cotton cloth. Use a circular motion from the outside, working inwards until film is left dry and clear. See **Notes**.
5. Repeat above procedures until entire mold surface has been covered.
6. Apply 4-5 coats, allowing 15 minutes between each complete coat.
7. Allow 30 minutes for full cure. Proceed with production.

Touch-Up Coats

Reapply one light coat as required and cure as for final coat.

Notes

Time will vary with room and mold temperature. Wipe off as the solvent begins to evaporate. If the release agent is left on too long, you may notice some smearing or streaking. To

remove the smear or streak, rub the affected area with the recommended Chemlease® release agent, and then simply remove the excess sooner than you had before.

Important

The recommended number of coats and cure times are a general guideline found to be more than sufficient in a broad spectrum of molding conditions. When molding products with extreme geometries or experiencing low-humidity conditions in the shop, the customer may find the need to extend the cure time between coats and increase the number of coats applied to the mold. The efficiency of a release film is best determined through a combination of tape tests and experimentation.

Storage

Do not store above 50°C. Keep container tightly sealed to prevent evaporation and/or contamination. If stored in cold temperatures, allow to warm to room temperature before using.

Packaging

Chemlease® PMR-90 EZ is available in 1 L, 5 L and 20 L containers.

Safety Data

Material Safety Data Sheets are available for all Chemlease® products and should be consulted prior to use of the product.

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.

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