



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

MoldWiz®

WB-4707

Mold Release

Product Description:

A water-based external release agent that adheres to the mold walls and has no affinity for the resin. Multiple releases for each application can be achieved.

Composition:

A proprietary resin emulsion comprising modified siloxane-based polymers which crosslink and form a release film on evaporation of the water carrier.

Handling:

Non-flammable.
Store above freezing.
SHAKE/MIX WELL BEFORE USING.

Features:

Easy to use. Can be applied by spraying, wiping, or dipping.

Uses:

Very high slip mold release for rotational molding. Especially suitable for pins, threads, inserts, cores, flanges, etc.

Typical Properties:

Solids:	11%
Color:	Off -white
Specific Gravity:	< 15cps @25°C
Viscosity:	1.005
Flash Point:	Non-flammable (C.O.C)
Shelf Life:	1 year minimum

Mold Preparation:

For the best effectiveness, molds, pins, flanges, threads, etc. should be free of contaminants and previous mold release agents.

For light to moderate removal of mold release or contaminants, XTEND WCX stripper is generally

effective. For heavier build-up, XTEND CX-200HS mold stripper can be considered. After using mold stripper, it is important to thoroughly water wash all mold areas, and/or parts where the mold stripper has been used, to completely remove the residue from the stripping process.

Application:

Wipe-On: Apply using a clean, woven, lint free cotton cloth, or a high quality paper towel such as: Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes. Saturate the cloth or paper towels with release until completely wet, but not dripping, and wipe onto the mold. It is best if application is made to a warm mold surface (<150°F/65°C). Apply using smooth even strokes until the film is uniformly dry without wiping marks.

Spray-On: Mold release may also be sprayed on using HVLP, and other types of pressured systems. If hand pumped spray applicators are used rather than pressurized spray equipment, it may be necessary to wipe the mold to create a uniform film and to avoid puddling.

Dipping: Parts like pins, cores, or threaded components can also be dipped or put in a tray of WB-4707 to soak. After dipping or soaking, shake off excess and allow to dry before molding.

1-2 coats are recommended depending on the mold geometry, material being molded, and process. For more difficult shapes or conditions, use more coats, or increase the frequency of re-application.

Heat curing, or dry cycling, WB-4707 is not required.

Touch-up:

Apply additional coats of release as needed. Extra attention should be focused on the problem areas that need extra slip.

Removal:

Use WCX or CX-200HS to strip the release from the molds when desired. These strippers will remove plate-out, mold release build-up, color build-up, etc.

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