



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

Mailing: Box 77 0855 Woodside, NY 11377 USA
Shipping: 58-20 Broadway, Woodside, NY 11377 USA
Phone: 718-672-8300 • Fax: 718-565-7447
E-mail: info @axelplastics.com

www.axelplastics.com

Technical Data Sheet

MoldWiz®

MWM

Product Description

A film-forming combination matte finish release agent and barrier coat that dries at room temperature and imparts a permanent, non-transferring matte finish to the molded parts. For use on all types of molds. MWM is a sacrificial release that must be applied before each part is molded.

Handling

MIX OR SHAKE WELL PRIOR TO USE. PERIODICALLY AGITATE DURING USE.

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C.
DO NOT DILUTE

Features

Temporary creation of a matte surface gloss surface
Easy release for many types of resin
Easy to remove from molds after use

Uses

Ideal for open molding, such as sink or counter applications that require occasional matte finish parts from glossy finish FRP molds.
Molding polyester, vinyl ester and other resins.

New or Green Molds:

Should be conditioned prior to using MWM for production

Typical Properties

Solids	Approx. 10%
Color	Milky White
Specific Gravity	1.01 @25°C
Flash Point	<73°F / <23°C (C.O.C.)
pH	9.75
Flash Point	Non-flammable
Shelf Life	1 yr. minimum in original closed container

Mold Preparation

New & Green FRP Molds:
Read AXEL publication FocusOn New & Green Molds.
Conditioned & Metal Molds:
Mold surfaces should be clean and free of previously used mold releases and other surface contaminants.

Application Instructions

Spraying:
To create a consistent matte release surface on glossy FRP molds, it is recommended that MWM be applied by spraying. Pressurized spray pots, conventional spray guns or HVLP equipment will provide the best

results. Electrostatic spray guns and hand pumped spray bottles are not suitable for application.

Spray on a light film of MWM and let dry. When completely dry apply a second coat. 2-3coats are recommended depending on how heavily the spray has been applied. Light coatings are better. Wait a minimum of 30 minutes after the last coat is completely dry before molding. Drying time can be accelerated with fans or heat.

Hand Wiping:

MWM can also be applied by hand wiping on to the mold surface. If this method is preferred, a 100% cotton cloth should be totally saturated with release and then wiped across the mold to create an even wet film of MWM.

When the first coat is completely dry, repeat the process. When applying the second coat it is best to apply in the opposite direction (i.e. horizontal stokes for one coat; and vertical coats for the second.) It is also important not to rub hard when applying the second coat, as this can damage the first layer of release.

After 2 coats have been applied, the mold surface should be totally matte. If there are any spots that are glossy, you have missed applying to this area, or wiped on MWM with a cloth that was not wet enough. Wait a minimum of 30 minutes after the second coat is completely dry before molding. Drying time can be accelerated with fans or heat.

Re-Application

Remove any traces of MWM by wiping with a mixture of isopropyl alcohol and water(a mixture of 1part IPA and 1 part water is generally good). The remains of release should be easy to remove, but repeat the cleaning if necessary.

Dry the mold completely and reapply as before.

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