

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet



# W-4005B/HT1

### Product Description

Proprietary resin emulsion comprising modified polymers which crosslink and form a release film upon evaporation of the water carrier.

### Composition

Aqueous emulsion of proprietary resins and crosslinkers with various surfactants.

### Handling

Keep this water-based product from freezing and store below 100°F / 39°C.  
Mix well before using.

### Features

Easy, spray or wipe on  
No HAPS  
No odor

### Uses

Specifically designed for rubber, Thermoplastic and Thermoset Resins processed at temperatures up to 1000°F

### Typical Properties

Solids	3 - 5%
pH	8.5
Color	Off White
Specific Gravity	1.00 @25°C
Viscosity	<15cps @25°C
Flash Point	Non Flammable
Shelf Life	12 months in original unopened package

### Mold Preparation

In order for the release to work effectively, the mold must be thoroughly cleaned to remove previously used mold release and other surface contaminants which may be incompatible.

New molds should be cleaned with solvent to remove protective lubricants and coatings. Molds coated with other semi-permanent release agents can be cleaned with CX-200HS of high pH detergent. Then, wipe down the mold with a mild cleaning solvent and thoroughly dry the surface.

### Application Instructions

The release performs best when sprayed on hot molds (preferably 80°C/180°F or higher).

Apply using a clean, woven, lint free cloth, such as the Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes, or even a good, heavy-duty plain white paper towel. Wet the cloth with release until it is damp but not dripping and wipe onto preferably warm mold surface using smooth even strokes until the film is uniformly dry without wiping marks.

Mold release may also be sprayed on.

Multiple coats (2-4) are necessary to achieve proper, uniform application of the release. Allow the coating to dry between applications.

Cure the mold release by heating for 1 hour at 375°F/190°C. Best results are attained when the coating is cured for 1 hour at molding temperature.

Touch-up coats, when applied, should be cured for about 5 minutes at elevated temperature prior to restarting production.

### Removal

Use CX-200HS to strip the release from the molds when desired.

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