



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



W-HS

Mold Release

Product Description:

An air-drying, water-based, reactive resin solution that cures to provide a durable semi-permanent release coating. Permits multiple releases at both ambient and elevated temperatures.

Composition:

Proprietary resin solution comprising modified siloxane- based polymers which crosslink and form a release film upon evaporation of the solvent carrier.

Handling:

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

Features:

Water-based
Non-flammable
High Slip

Uses:

Especially for applications requiring high slip.
Ideal for mold flanges, mold gates and as a replacement for edge wax.
Will **not** yield a semi-cosmetic finish.

If XTEND W-HS is used for New or Green Molds: Apply 2-3 coats of XTEND XTR mold sealer prior to application of XTEND W-HS.

Typical Properties

| | |
|-----------------------|--|
| Effective Ingredients | 11% |
| Color | Off white |
| Specific Gravity | 1.005 @25°C |
| Flash Point | Non-Flammable |
| Shelf Life | 12 months in the unopened/original 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:

1)Apply with a clean, paper towel, such as the Scott Shop Towels On A Roll®, or a heavy-duty plain white paper towel, or clean, 100% cotton cloth.

2)Saturate the towel with release until it is wet but not dripping. Wipe onto mold surface using smooth even strokes. Apply a thin, uniform coating and allow the release to evaporate. Do not overwork the area or continue to wipe. Simply wipe on, and allow to dry.

For most processes, use 2 coats of W-HS for initial mold preparation and re-apply 1-2 coats as required.

In highly shear or abrasive processes like winding or pressing, more frequent application may be required.

When Used for Mold Flanges & Edges and Gates:

1)Prepare the entire mold including the flange area with the chosen mold sealer and release system, then apply 1-2 coats of W-HS to the mold flange.

2) Re-apply 1 coat of W-HS to the flange, gate or edge areas before molding each part.

3) Be careful not to drip W-HS into the interior of the mold. If this happens, immediately wipe out with a dry cloth and then use a cloth that is dampened with acetone to wipe the spill or drip area, and then dry with a clean cloth or towel.

NOTE: When used on flanges and edges W-HS does not need to be completely dry before molding.

Removal:

Use WCX or CX-200HS mold stripper, followed by a water wash and a good general purpose cleaner, such as AXEL's CX-500.

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