

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ 985JB

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**General:** A 50% active, water-reducible external mold release agent specifically designed to eliminate commonly used organic solvents, including Hazardous Air Pollutants (HAPS), from the workplace. Especially effective for closed molding polyester and vinyl ester-based SMC/BMC off hot steel and aluminum surfaces. Water-based solutions offer rapid wetting and drying with excellent release properties. Exposure to hazardous volatiles is drastically reduced. Being non-acidic, it does not contribute to chemical corrosion of tool substrates. Molded parts may be painted or bonded with no prior secondary surface preparation. Spilled material or accidental contamination is conveniently removed by washing with water.

**Use:** **Unsaturated Polyester/Vinyl Ester-based SMC/BMC**  
**Deco Laminates. Particleboard. Chipboard.**

**Composition:** Proprietary synergistic blend of organic acids and esters with wetting agents, surfactants and emulsifiers in a water vehicle.

### TYPICAL PROPERTIES:

<b>SOLIDS:</b>	<b>36%</b>
<b>COLOR:</b>	<b>Yellow - Amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>1.03 @ 5°C</b>
<b>VISCOSITY:</b>	<b>175 cps @25°C</b>
<b>pH:</b>	<b>7.91</b>
<b>FLASH POINT:</b>	<b>Non Flammable</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### Application Instructions:

Mold-Wiz **985JB** may be easily diluted with water, or a water/isopropyl alcohol (for ambient or low temp tooling) combination to any desired solids content.

We recommend a solution containing 5% solids for SMC/BMC applications and 3-5% solids for Laminates and board presses. This can be obtained by adding water to **985JB** with minimal agitation. Dissolution in warm water is virtually instantaneous. Continuous agitation is not recommended nor required. Mixing is extremely easy, requiring low speed agitation (200RPM or less). Other molding processes, such as filament winding and wrapping may benefit from higher solids content.

### **Application Instructions: Spray**

For best results we recommend spray applying the 985JB. Spray 985JB with an HVLP spray gun and a pressure pot. Equipment: An 89 tip with a 95P fan for the HVLP gun attached to a pressure pot that has; air/water separator attached to an air regulator set to between 40-60 psi. Fluid pressure should be regulated to between 4 and 10 psi. Initial start-up settings at 5 psi fluid pressure and 50 psi air atomizing pressure recommended. The larger the mold cavity the higher the pressures can be set to help aid in delivery of the 985JB. It is recommended that an up and down fan pattern be used (usually a one-half turn from the LEFT on most HVLP guns will produce an excellent fan pattern). For the fluid, only a one-half, to three-quarters turn from the RIGHT is all that is necessary. It is NOT recommended to open the fluid orifice more than one whole turn. Use water to flush the gun after use.

### **Application Instructions: By hand**

Apply 985JB solution to clean tool by brush or clean cotton cloth applying in two directions. Proceed to mold on the wet release film. Test to determine how many multiple demoldings are possible before reapplying release agent.

All information given by us about our products is based upon our tests and experience. It is intended for use by persons having technical skill at their own discretion and risk, and we assume no liability in connection with their use.

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