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Technical Data Sheet



WB-4606

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 of polyolefins, organic fatty acids and siloxane-based polymer in combination with wetting agents and surfactant in a water vehicle.

Handling:

Non-flammable.

Store above freezing.

SHAKE/MIX WELL BEFORE USING.

Features:

Especially for rotationally molding XLPE. Also suitable for LLDPE, LDPE, MDPE, and HDPE

Uses:

Rotational molding, especially to resolve surface defects like pock marks, or "coining" that often occur when molding XLPE.

Typical Properties:

Solids:	8.0 – 9.0 %
Color:	Off -white
Specific Gravity:	< 15cps @25°C
Viscosity:	0.996@ 25°C
Flash Point:	Non-flammable (C.O.C)
Shelf Life:	1 year minimum in the original sealed container

Mold Preparation:

For the best effectiveness, the mold should be free of contaminants and previous mold release agents, machine oils and any other surface build-up or contamination.

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 will be necessary to wipe the mold to create a uniform film and to avoid puddling or white spots on the mold surface.

One to two coats are typically applied a few minutes apart to an ambient or warm mold. Once the last coat is dry, the mold can then be loaded with resin and molded. A heat cure or "dry-cycle" is not recommended for WB-4606.

Touch-up:

Apply additional coats of release as needed, applying either to the entire mold, or focusing on problem areas like ribs

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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