

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

**XTEND**™  
Semi-Permanent Mold Releases

## WS-50

### Product Description

A semi-permanent aqueous mold sealer/primer that forms a uniform film on drying. This product is intended as a base coat for semi-permanent releases.

**DO NOT USE THIS PRODUCT AS A RELEASE AGENT.**

### Composition

Aqueous solution of proprietary resins and reactive surface modifiers.

### Handling

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

Mix well before using.

### Features

Easy wipe on

Solvent free

No odor

### Uses

Sealing and molds prior to application of XTEND W-7838D and other XTEND water-based mold releases or where specified.

Especially for sealing molds used for wind blade production.

Solids	7 – 9%
Optical Properties	Light Beige
Specific Gravity	1.00 @25°C
Viscosity	<15cps @25°C
pH	10.85
Flash Point	Non Flammable
Shelf Life	12 months in original unopened package

### 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. Use recommended cleaners and strippers.

If WS-50 and W-7838D have been used previously, WCX water-based stripper can be used to strip molds. Please refer to the technical data sheet for WCX stripper for detailed instructions.

### Application Instructions

- Hand Wiping:

1) Apply using a clean, woven, lint free cotton cloth.

Wet the cloth with release until it is damp but not dripping and wipe onto mold surface using smooth even strokes.

On large surfaces, a short fiber cotton mop can be used to apply release. Apply a light even coating. Do not puddle.

2) Allow 30 minutes at 70F/20C for drying and curing. Curing at process temperature or peak process exotherm for 15 minutes minimum, is preferred.

3) Apply a second coat of sealer using the same method as in step one. Wait 30 minutes at elevated temperature and 60 minutes at ambient for drying and curing before applying W-7838D mold release (or other XTEND water-based release when specified) following the application instructions for that product.

### NOTE

1) New molds or porous surfaces may require additional coats of sealer.

2) **DO NOT APPLY WS-50 OVER MOLD RELEASE.** Only re-apply WS-50 when the mold has been completely cleaned or stripped for re-conditioning.

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