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Technical Data Sheet

MoldWiz® JB5 External Mold Release

Product Description:

An external water-based mold release agent that enables multiple releases per application.

This product is suitable for closed molding polyester and vinyl ester-based SMC/BMC on hot steel and aluminum surfaces. Water-based solutions provide quick wetting and drying with effective release properties. Exposure to hazardous volatiles is minimized. As a non-acidic solution, it does not cause chemical corrosion of tool substrates.

Molded parts may be painted or bonded with no prior secondary surface preparation.

Use:

Unsaturated Polyester/Vinyl Ester-based SMC/BMC.

Composition:

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

Handling:

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

Mix/agitate well before using.

Application Instructions:

Mold should be at ambient/room temperature before starting application. Clean mold with XTEND CX-500. Apply mold release with a clean cotton cloth wiping in two directions, using a circular motion. Allow to dry to the touch prior to applying additional coats. Two (2) to three (3) coats should be applied the first time. The JB5 should be dry to the touch prior to molding.

When tooling temperature exceeds 120°F product should be applied by spraying a thin coat (fine mist to dry film) and allowing to dry completely with no moisture residue. In general terms, any sprayer that provides a fine mist or atomization should be suitable. Examples include Milwaukee Sure Shot® Sprayers, and HVLP spray systems.

Accelerate drying time by blowing hot air or by using heat lamps. Repeat whenever mold has been cleaned with XTEND CX-500, or as required to give mold release properties.

Review SDS before use. If you have any additional questions, reach out to your technical service representative for further guidance.

FEATURES

No HAPs	Water-based
Non-Flammable	Non-corrosive
Will not negatively impact secondary bonding or painting	

TYPICAL PROPERTIES:

NON-VOLATILE	3.20 – 3.80%
COLOR	Slightly Hazy
SPECIFIC GRAVITY	0.980 – 1.020
VISCOSITY	<15 cP @ 25°C / 77°F
PH	7.50 – 9.00
FLASH POINT	Non-Flammable
SHELF LIFE	1 year from manufacture date
SOLIDS	3.2-3.8%