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Technical Data Sheet

MoldWiz® EM-303SF2 External Mold Release

Product Description:

A water-based external release agent with anti-rusting properties that dries at room temperature forming a monomolecular film which adheres by absorption to the mold walls and has no affinity for the resin or rubber. This selective adhesion prevents the film from easily being torn off by the demolded part resulting in numerous demoldings per release application without any necessity for washing the mold. Will not interfere with any secondary operations such as decorating, bonding, or painting.

Use:

SMC, Polyester, Epoxy, Rubber, Melamine & Phenolic.

Composition:

Proprietary resin emulsion of polyolefins and fluoropolymer in combination with wetting agents and surfactant in a water vehicle.

Handling:

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

MUST MIX WELL BEFORE USING.

Instructions for Use:

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 EM-303SF2 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.

If composite tooling is being used (epoxy, polyester, vinylester), we suggest application of XTEND PR-ACP or PR-GCP to condition the mold.

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

FEATURES:

Water-based	Anti-corrosive
Multiple demoldings per application	Non-Flammable
Will not negatively impact secondary bonding / painting	

TYPICAL PROPERTIES:

SOLIDS	2.5 – 3.5%
COLOR	Off white - White
SPECIFIC GRAVITY	0.970-1.010
PH	9.5 – 11.5
SHELF LIFE	1 year from manufacture date
VISCOSITY	<15 cps @ 25°C / 77°F