



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

MoldWiz®

MWM

External Mold Release

Product Description

A film forming matte finish release agent and barrier coat that dries at room temperature and imparts a permanent, non-transferring matte finish to the molded parts . For use on all types of molds. MWM is a sacrificial release that must be applied before each part is molded.

Handling

MIX OR SHAKE WELL PRIOR TO USE. PERIODICALLY AGITATE DURING USE.

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C.
DO NOT DILUTE

Features

Temporary creation of a matte surface
Easy release for many types of resin
Easy to remove from molds after use.

Uses

Ideal for open molding, such as sink or counter applications that require occasional matte finish parts from glossy FRP molds.
polyester, vinyl ester and other resins.

New or Green Molds:

Should be conditioned prior to using MWM for production

Typical Properties

Solids	Approx.. 10%
Color	Milky White
Specific Gravity	1.01 @25°C
Flash Point	<73°F / <23°C (C.O.C.)
pH	9.75
Flash Point	Non-flammable
Shelf Life	1 yr. minimum in original closed container

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.

Application Instructions

Spraying:
To create a consistent matte release surface on glossy FRP molds, it is required that the MWM be applied by spray. Pressurized spray pots, conventional spray

guns, gravity feed HVLP or other types of HVLP equipment will provide the best results. Electrostatic spray guns and hand pumped spray bottles are not suitable for application.

Application

Spray on a light coat (pass) of MWM and let dry. When completely dry apply a second coat. 2-3 coats are usually recommended. Light coatings or passes are better. A medium or heavy application will produce runs, puddles, or drips. Wait a minimum of 30 minutes after the last coat is completely dry before molding. Drying time can be accelerated with fans or heat.

Re-Application

If the surface of the mold looks acceptable, reapply a coat of the MWM and allow to cure as described above.

If the surface of the mold is unacceptable, then remove any traces of MWM by wiping with a mixture of isopropyl alcohol and water (a mixture of 1part IPA and 1 part water is generally good). The remains of release should be easy to remove, but repeat the cleaning if necessary.

Dry the mold completely and reapply as before.

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