



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



W-7838D

Product Description

Proprietary resin emulsion comprising modified siloxane-based polymers which crosslink and form a release film upon evaporation of the water carrier.

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 (optional spray)

Matte Finish

No Odor

HAPs free

Cures quickly at ambient temperature

Uses

Ideal for open molding and other processes where uniform matte finish parts are required and a water-based release is desired. Ideal for wind blade production.

Molding polyester, vinyl ester & epoxy .

Typical Properties

pH	9.5 – 11.5
Color	Off White
Specific Gravity	1.005 @25°C
Viscosity	<15cps @25°C
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 strippers to thoroughly clean.

If the mold is being re-conditioned after using WS-50 sealer and W-7838D release, WCX water-based mold stripper can be used. Please refer to the technical data sheet for WCX stripper for full instructions on use.

Mold Sealing

Application of 2 coats of WS-50, water-based mold sealer prior to the application of the W-7838D is recommended.

Please refer to the technical data sheet for WS-50 sealer for full instructions on use.

Application Instructions

Hand Wiping:

1a) 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.

For large surfaces, short fiber cotton mops may be used to apply release. Remember to apply a thin film and not to puddle release on the mold.

Spraying:

1b) If spray application is preferred, the release should be applied in as fine a mist as possible. If the spray application beads on the mold surface, rather than wetting it evenly, a clean cloth should be used to lightly wipe the surface and ensure even distribution of the release.

2) Apply a total of 3 coats of release, waiting a minimum of 15 minutes between each application. It is important that each coat dry and cure before applying the next coat of release.

3) Allow a minimum of 30 additional minutes before molding.

4) For optimum results, heat curing the mold after all of the coats of release have been applied is recommended. 15-30 minutes at the molding temperature, or at the peak process exotherm is recommended.

5) A minimum of two coats of release are recommended for conditioned molds that have used a sealer prior to the release. If no sealer has been used, 4-6 coats of may be required.

In Process

Re-apply mold release as needed. Shear edges and area where sharp angles are present may require more frequent application. Wait a minimum of 30 minutes before beginning to mold again. If the mold is heated after application, this time can be reduced to 10 minutes.

Stripping and Re-Conditioning

When molds require cleaning or re-conditioning, WCX water-based mold stripper is recommended. Please refer to the technical data sheet for WCX mold stripper for full instructions on use.

AXEL

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XTENDTM
Semi-Permanent Mold Releases

W-7838D

After molds have been completely stripped clean, application of both mold sealer and release should be applied according to the previous directions.

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