

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ

### F-75NC

No chlorinated solvents

**General:** A liquid external release agent that dries at room temperature forming a monomolecular film which adheres by adsorption to the mold walls and has no affinity for the resin. 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 parts. Will not interfere with any secondary operations such as decorating, bonding, or painting.

**Use:** Polyester Vinyl ester  
Epoxy Phenolic  
Spray-up RTM Cold Press  
Prepregs Casting  
Vacuum Bag Molding

**Composition:** Proprietary resin solution of polyolefins in combination with fluorotelomer in hydrocarbon solvents.

#### TYPICAL PROPERTIES:

<b>SOLIDS:</b>	5.25 – 6.75%
<b>COLOR:</b>	Off White
<b>SPECIFIC GRAVITY:</b>	0.820 @ 25°C
<b>VISCOSITY:</b>	10 - 170 cps @ 25°C
<b>REFRACTIVE INDEX:</b>	1.458
<b>FLASH POINT:</b>	<73°F / <23°C (C.O.C)
<b>SHELF LIFE:</b>	Minimum of one year

#### Application Instructions:

Clean mold with CleanWiz®. Porous FRP mold surfaces may require Melax® mold sealer and conditioner. Apply mold release with a 100% cotton cloth. (Solvents in the mold release may dissolve synthetic fiber leaving a deposit or streaks on the mold). Wipe on uniformly using a circular motion. Allow to haze dry. Without polishing, wipe on a second coat in a small area. With a dry cotton cloth, immediately polish the wet area. Wet polishing will result in an easy-to-polish high gloss surface. After wet polishing the entire mold, repeat a second time. Wait at least a half hour before beginning to mold. Repeat wet polish application between parts gradually working up to multiple releases before re-application of the mold release.

**Note:** Polishing is optional. For matte finish, do not polish.

All information given by us about our products is based upon our tests and experience. It is intended for use by persons having technical skill at their own discretion and risk, and we assume no liability in connection with their use.

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