

technical data



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & INTERNAL LUBRICANTS

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MOLD WIZ

JB625

General: An external mold release agent specifically designed to eliminate commonly used organic solvents, including Hazardous Air Pollutants (HAPS), from the workplace. Especially effective for closed molding polyester and vinyl ester-based SMC/BMC off hot steel and aluminum surfaces. Water-based solutions offer rapid wetting and drying with excellent release properties. Exposure to hazardous volatiles is drastically reduced. Being non-acidic, it does not contribute to chemical corrosion of tool substrates.

Molded parts may be painted or bonded with no prior secondary surface preparation. Spilled material or accidental contamination is conveniently removed by washing with water.

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.

TYPICAL PROPERTIES:

SOLIDS:	6.00%
COLOR:	Light Yellow
SPECIFIC GRAVITY:	1.020 @ 25°C
VISCOSITY:	< 15 cps @25°C
pH:	8.21
FLASH POINT:	Non Flammable
SHELF LIFE:	Minimum of one year

Application Instructions:

Application Instructions: Spray

For best results we recommend spray applying the JB625. Spray JB625 with an HVLP spray gun and a pressure pot. Equipment: An 89 tip with a 95P fan for the HVLP gun attached to a pressure pot that has; air/water separator attached to an air regulator set to between 40-60 psi. Fluid pressure should be regulated to between 4 and 10 psi. Initial start-up settings at 5 psi fluid pressure and 50 psi air atomizing pressure recommended. The larger the mold cavity the higher the pressures can be

set to help aid in delivery of the JB625. It is recommended that an up and down fan pattern be used (usually a one-half turn from the LEFT on most HVLP guns will produce an excellent fan pattern). For the fluid, only a one-half, to three-quarters turn from the RIGHT is all that is necessary. It is NOT recommended to open the fluid orifice more than one whole turn. Use water to flush the gun after use.

Application Instructions: By hand

Apply JB625 solution to clean tool by brush or clean cotton cloth applying in two directions. Proceed to mold on the wet release film. Test to determine how many multiple demoldings are possible before reapplying release agent.

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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