

## MOLD WIZ

### WB-4303

### Water-based Release for Rotomolding

**General:** A water-based external release agent with anti-rusting properties that dries at room temperature forming a monomolecular film that 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 in mold graphics or secondary operations such as decorating, bonding, or painting.

**Use:** Especially for rotational molding LLDPE, LDPE, HDPE, XLPE.

**Composition:** Proprietary resin emulsion of polyolefins, organic fatty acids and siloxane based polymer in combination with wetting agents and surfactant in a water vehicle.

#### TYPICAL PROPERTIES:

<b>SOLIDS:</b>	<b>4 – 5%</b>
<b>COLOR:</b>	<b>Off white</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.996 @ 25°C</b>
<b>VISCOSITY:</b>	<b>&lt;15 cps @ 25°C</b>
<b>pH:</b>	<b>9.5 – 11.5</b>
<b>FLASH POINT:</b>	<b>Non Flammable</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

#### Application Instructions:

**Mold Preparation:** Before initial application, molds should be clean and free of previous used release agents, machine oils and any other surface build-up or contamination.

Release may be applied by hand wiping or spraying. It is recommended that 1-2 coats be applied, wiping these into the surface of the mold and assuring that no puddles, or drips remain. Following this application, “dry cycle” the mold (run through heat cycle without charging with resin). After “dry cycling”, and while the mold is still warm (100-200°F/40-95°C), open the mold and apply an additional coat of release. For maximum performance, dry cycle this coat as well, this will enhance ease of release and the number of demoldings that can be achieved before reapplication is required. For simple part geometries where release is easy, or where part warpage is a concern, it is not critical to heat cure the second application of release.

**Touch-up:** Additional coats of release can be applied as required either to the entire mold, or only to problem areas such as ribs. It is not necessary to “dry cycle” the mold after touch-ups.