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### Technical Data Sheet

# MoldWiz®

## WB-4909R

### Mold Release

#### Product Description:

A water-based external release agent that adheres to the mold walls and has no affinity for the resin. Multiple releases for each application can be achieved.

#### Composition:

A proprietary resin emulsion comprising modified siloxane-based polymers which forms a release film on evaporation of the water carrier.

#### Handling:

Non-flammable.

Store above freezing.

SHAKE/MIX WELL BEFORE USING.

#### Features:

Easy, spray or wipe on

#### Uses:

Especially suitable for rotational molding of water tanks and similar shapes where high slip and excellent flow are needed for threads, as well as minimal to no warpage for the main tank area. Recommended for rotational molding of LLDPE, LDPE, MDPE, and HDPE.

#### Typical Properties:

Solids:	2.5 – 4.5%
Color:	Off-White
Specific Gravity:	1.000 @25°C
Viscosity:	< 15cps
Flash Point:	Non-flammable
Shelf Life:	Minimum of 1 year

New molds should be cleaned to ensure that machining oils, media blasting materials, etc. are completely removed from the tool prior to application of the WB-4909R. One effective method is the use of mineral

spirits to clean the media blasted mold. Then clean with acetone or AXEL CX-500 Mold Cleaner.

For light removal of mold release or plate-out, XTEND WCX stripper is generally effective. For moderate build-up, XTEND CX-200HS mold stripper can be considered. After using mold stripper, it is important to thoroughly water wash the mold to completely remove the residue from the stripping process.

#### Application:

**Wipe-On:** Apply using a clean, woven, lint free cotton cloth, or a high quality paper towel such as: Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes. **For ambient molds**, saturate the cloth or paper towels with release until completely wet, and wipe onto the mold. (<150°F/65°C). Apply using smooth even strokes until the film is uniformly dry without wiping marks. At ambient the mold can be soaked and thoroughly saturated with WB-4909R. **For warm molds**, 125°F/50°C and above, saturate the cloth or paper towels with release until completely wet, but not dripping, and wipe onto the mold. Wipe the release in to the mold.

**Spray-On:** Mold release may also be sprayed on using HVLP, and other types of air sprayed systems. If hand pumped spray applicators are used, it may be necessary to wipe the mold after spraying to create a uniform film and to avoid drips or puddling.

1-3 coats are recommended depending on the mold geometry, material being molded, and process. For more difficult mold shapes, use more coats.

Heat curing, or dry cycling, WB-4909R is not required, however the release should be dry before charging the mold.

**Touch-up:**

Apply additional coats of release as needed either to the entire mold, or only to problem areas, such as ribs or threads. Release does not require heat cure, but should be dry before molding.

**Removal**

Use WCX or CX-200HS to strip the release from the molds when desired. These strippers will remove plate-out, mold release build-up, color build-up, etc. WCX is effective for mild to medium build-up. CX-200HS is used for medium to heavy build-up.

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