



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



W-105

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, wipe-off
Glossy Finish
No Odor
HAPs free
Cures quickly at ambient temperature

Uses

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

Molding polyester, vinyl ester & epoxy.

Typical Properties

pH	10.0 – 12.0
Color	White
Specific Gravity	1.000 @ 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.

Mold Sealing

1) Apply XTEND XTR mold sealer prior to the application of the release to extend the productivity of the release coating.

Application Instructions

Hand Wiping:

- 1) Apply using a clean, woven, lint free cotton cloth, or paper towel such as Scott Shop Towels On A Roll® or a heavy-duty plain white paper towel. Wet the cloth with release until it is damp but not dripping and wipe onto mold surface using smooth even strokes.
- 2) As the release starts to flash off (on average 20 seconds to 1 minute), use a clean lightly textured cotton cloth to buff across the area, using a circular motion. If the surface clouds or appears foggy, move on to a new area and leave the first area to dry/cure a bit longer.
- 3) Wait 15 minutes and repeat the application as in 2).
- 4) Wait 30 minutes before molding.
- 5) Touch-up: apply one coat of release as needed.

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