



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



W-7509

Product Description

A semi-permanent, aqueous emulsion, external release agent that forms a uniform cured film on drying. Selective adhesion on the mold surface prevents the film from being torn off with de-molding.

Composition

Aqueous emulsion of proprietary resins and crosslinkers with various surfactants.

Features

Easy, spray or wipe-on
High gloss
No HAPS
No Nonylphenol based surfactants

Uses

Epoxy, Polyester, Rubber, Elastomeric & Rigid PU from steel and aluminum molds.

Handling

Keep this water-based product from freezing. Store below 100°F. Mix well before using.

Typical Properties

Solids	1-3%
Color	White / Off White
Specific Gravity	1.00 @25°C
Viscosity	<15cps @25°C
pH	ca. 3
Flash Point	Non Flammable
Shelf Life	12 months

Mold Preparation

In order for the release to work effectively, the mold must be thoroughly cleaned to remove previously used mold release and other surface contaminants which may be incompatible.

New molds should be cleaned with solvent to remove protective lubricants and coatings. Molds coated with other semi-permanent release agents can be cleaned with CX-200HS of high pH detergent. Then, wipe down the mold with a mild cleaning solvent and thoroughly dry the surface.

Application Instructions

1) Apply using a clean, woven, lint free cloth, such as the Scott Shop Towels On A Roll®, Kimberly-

Clark WorkHorse® rags or WypAll® wipes, or even a good, 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 until the film is uniformly dry without wiping marks.

Mold release may also be sprayed or brushed on. Apply at room temperature or preferably on warm molds (up to 165°C/330°F).

Multiple coats (2-4) are necessary to achieve proper, uniform application of the release. Allow 5 minutes drying time between applications.

Cure the mold release by heating for 30 minutes at the temperature at which the resin will subsequently be molded. Curing at higher temperature (up to 165°C/330°F), longer cure times (up to 60 minutes), or leaving the mold to post-cure overnight at ambient conditions after a thermal cure prior to molding can also be helpful in maximizing the number of releases.

Touch-up coats, when applied, should also be cured for at least 10 minutes at the molding temperature prior to restarting production.

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