



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



W-7838

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
No Odor
HAPs free
Cures quickly at ambient temperature

Uses

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

Molding polyester, vinyl ester & epoxy .

Typical Properties

pH	9.5 – 11.5
Color	Off White
Specific Gravity	1.005 @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

Applying WS-47 or WS-50 mold sealer prior to the application of the release may extend the productivity of the release coating.

Application Instructions

Hand Wiping:

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.

Spraying:

Many molders prefer to apply the semi-permanent release with a hand pump spray bottle. Using this method, a 2 – 3 square foot area can be misted and then lightly wiped with a clean cloth to distribute the release consistently across the surface.

2) After approximately 2 minutes, and before the release dries, lightly wipe over the surface with a clean cloth. Do not rub.

3) Wait approximately 15 minutes before applying the next coat of release. Allow this to dry and cure.

4) Allow a minimum of 15 additional minutes before molding. Allowing a longer time for the release to cure or heating the release coated mold will enhance release durability and performance.

5) A minimum of two coats of release are recommended for conditioned molds that have used a sealer prior to the release. If no sealer has been used, 4-6 coats of release should be applied.

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