



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

50 Cambridge Drive, Monroe, CT 06468

Phone: 718-672-8300 • Fax: 718-565-7447
E-mail: info@axelplastics.com

www.axelplastics.com

Technical Data Sheet



W-7838/HTA

Product Description

Proprietary resin emulsion
Keep this water-based product from freezing and store below 100°F / 39°C.
Mix well before using.

Features

Designed for application to hot molds (up to 392°F/200 °C)
Low odor

Uses

Ideal for closed molding or compression molding at elevated temperatures

Molding phenolic, polyester, vinyl ester & epoxy ,rubber

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. Use recommended strippers to thoroughly clean.

Application Instructions

Spraying:

1a) Apply a fine mist of mold release directly on the heated mold surface. If the spray application beads on the mold surface, rather than wetting it evenly, a clean cloth should be used to lightly wipe the surface and ensure even distribution of the release. Do not puddle the release on the mold.

Hand Wiping:

1a) Apply using a clean, woven, lint free cotton cloth. Wet the cloth with release until it is damp but not dripping and wipe onto mold surface using smooth even strokes.

For large surfaces, short fiber cotton mops may be used to apply release. Remember to apply a thin film and not to puddle release on the mold.

2) Apply a total of 3 coats of release, waiting a minimum of 5 minutes between each application. It is important that each coat dry and cure before applying the next coat of release.

3) After the last coat of release, cure at process temperature for a minimum of 15 additional minutes before molding.

In Process

Re-apply mold release to hot molds as needed. Shear edges and area where sharp angles are present may require more frequent application. For best results, wait a minimum of 5 minutes before beginning to mold again.

Stripping and Re-Conditioning

When molds require cleaning or re-conditioning, WCX water-based mold stripper, CX-525 solvent-based stripper, compounding, or dry ice cleaning is recommended. Please refer to the technical data sheet for WCX mold stripper mold and CX-525 mold stripper for full instructions on use.

After molds have been completely stripped clean, application three coats of release should be applied according to the previous directions.

XTEND, MoldWiz & PasteWiz are registered trademarks of Axel Plastics Research Laboratories.

This information is supplied for technically skilled professionals working at their own risk. AXEL believes the information to be accurate, although the Company assumes no liability in the validity of this information for any specific process or application. Moreover, AXEL will assume no liability from any direct and/or consequential damages of any kind that may arise from the use or non use of AXEL products or information supplied by the Company or its appointed representatives.

(120423)