



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



W-7859

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 emulsion of proprietary resins and crosslinkers with various surfactants.

Each component in this formulation has been certified by USDA for plastics or films having indirect food contact.

U.S.F.D.A. SANCTIONED 21 CFR 175.105

Handling

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

Features

Easy, spray or wipe-on
High gloss
No HAPS

Uses

Specifically designed for molding polyester and rubber from steel. May also be used in prepreg and epoxy applications.

Typical Properties

| | |
|------------------|---|
| Solids | <2% |
| pH | 9.5 – 11.5 |
| Color | Off White |
| Specific Gravity | 1.00 @25°C |
| Viscosity | <15cps @25°C |
| Flash Point | Non Flammable |
| Shelf Life | 12 months in original unopened package |

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, WCX, or a high pH detergent. Then, wipe down the mold with a mild cleaning solvent and thoroughly dry the surface.

Application Instructions

Mold release may be applied by spraying or wiping.

WIPE ON: 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.

SPRAY ON: Apply with equipment that is capable of delivering a light even mist, preferably an HVLP spray gun.

- 1) Apply at room temperature or preferably on warm molds (up to 165°C/330°F).
- 2) Multiple coats (2-4) are necessary to achieve proper, uniform application of the release. Allow 5 minutes drying time between applications.
- 3) 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.
- 4) 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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