



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet



# WS-25

### Product Description

A semi-permanent aqueous mold sealer/primer that forms a uniform film on drying. This product is intended as a base coat for semi-permanent releases.  
**DO NOT USE THIS PRODUCT AS A RELEASE AGENT.**

### 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  
Solvent free  
No odor

### Uses

Sealing and priming molds prior to application of XTEND gloss finish, water-based mold releases.

### Typical Properties

Solids	7 – 9%
Color	Off White / Light Beige
Specific Gravity	1.00 @25°C
Viscosity	<15cps @25°C
pH	10.85
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.

### Application Instructions

#### - Hand Wiping:

1) Apply using a clean cotton cloth or a high quality paper towel such as the Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags, or WypAll® wipes. Wet the cloth with release until it is damp but not dripping and wipe onto mold surface using smooth even strokes.  
For best results on large surfaces, work in small areas and minimize overlaps.

2) Allow 30 minutes at ambient temperature for drying and curing.

3) Apply a second coat of sealer using the same method as in step one. Wait 30 minutes at elevated temperature, or 60 minutes at ambient for drying and curing before applying XTEND water-based release.

### NOTE

- 1) New molds or porous surfaces may require additional coats of sealer.
- 2) DO NOT APPLY WS-25 OVER MOLD RELEASE

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