



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](http://www.axelplastics.com)

## Technical Data Sheet



# WS-37

### 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, spray or wipe on  
No polishing required  
HAPs free  
Low or no odor

### Uses

Sealing and priming molds prior to application of XTEND W-7837D and other XTEND water-based mold releases when specified.

### Typical Properties

Solids	14 – 16%
Color	Off White
Specific Gravity	1.02 @25°C
Viscosity	<15cps@25°C
pH	11.50
Flash Point	Non Flammable
Shelf Life	6 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

#### - Spray on:

- 1) Place the spray gun to approximately 10 inches from the mold surface.
- 2) Spray lightly moving north-south. After drying, spray east-west to insure complete coverage.
- 3) Do not spray a heavy coat – a thin film is adequate and most efficient.
- 4) Allow 15 minutes for drying and curing at elevated temperature and 30 minutes at ambient.

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

Apply a second coat of primer/sealer. Wait 30 minutes at elevated temperature and 60 minutes at ambient for drying and curing before applying W-7837D mold release (or other XTEND water-based release when specified) following the application instructions for that product.

#### NOTE

- 1) Porous molds may require additional coats of sealer.
- 2) It is not necessary to buff the sealer prior to applying the mold release. Minor surface imperfections which may be apparent in the sealer will be resolved with the application of the mold release.
- 3) DO NOT APPLY WS-37 OVER MOLD RELEASE

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.

(061102)