



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet



# WS-47

### 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  
No polishing required  
HAPs free  
Low or no odor

### Uses

Sealing and priming molds prior to application of XTEND W-7837D.

### Typical Properties

Solids	5 – 7%
Color	Off White/Beige
Specific Gravity	1.00 @25°C
Viscosity	<15cps @25°C
pH	10.85
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

#### - 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. Wet the cloth with release until it is damp but not dripping and wipe onto mold surface using smooth even strokes.
- 2) Allow 15-20 minutes at ambient temperature for drying and curing.

Apply a second coat of primer/sealer. Wait at least 30 minutes at room temperature 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-47 OVER MOLD RELEASE

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