



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



WS-86 series

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 specifically to fill in porosity in metal tools.

WS-86	For application to ambient molds
WS-86M	For application to warm molds 115°F - 150°F
WS-86G	For application to hot molds 150°F and above

Composition

Aqueous solution of proprietary surface modifiers.

Handling

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

MIX WELL BEFORE USING

Features

HAPs free
Low or no odor

Uses

Sealing and priming metal molds prior to application of XTEND semi-permanents.

Typical Properties

Solids	8-9%
Color	White
Specific Gravity	1.01 @25°C
Viscosity	<15cps@25°C
pH	8.5
Flash Point	Non Flammable
Shelf Life	12 months in original unopened package

Mold Preparation

Conditioned & Metal Molds:

Mold surfaces should be clean and free of previously used mold releases and other surface contaminants.

Application Instructions

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. Also, 100%, bleached white cotton cloths can be used (T-shirt or Terry cloth with no synthetic fibers).

1. Wet the cloth liberally with WS-86 and rub into the mold surface using a circular motion. Allow to stand for one to three minutes depending on type of mold and temperature conditions.

2. After waiting one to three minutes, take a second, dry, clean cloth and in a circular motion, buff off the excess. The dry rag will feel a slight bit of resistance to the WS-86 "film". It will feel almost like buffing off paste wax that has dried to a haze. Buff off the sealer until there is no more excess being removed (you will no longer feel the cloth resist or drag on the tool surface). For molds with higher the surface quality, and where good cosmetic results are desired, excess sealer should be buffed off more quickly; otherwise streaking or hazing can occur on the mold surface.
3. Allow 30 minutes at ambient temperature for curing.
4. Apply a second coat of primer/sealer. Wait 30 minutes at elevated temperature or 60 minutes at ambient (overnight is even better) for curing before applying XTEND mold release, following the application instructions for that product.

NOTE:

- 1) Very porous molds may require additional coats of sealer.
- 2) DO NOT APPLY WS-86 OVER MOLD RELEASE

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