



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



WSS/2

Product Description

An air-drying, water-based, reactive resin solution that cures to provide a durable semi-permanent release coating. Permits multiple releases at both ambient and elevated temperatures.

Composition

Proprietary resin solution comprising modified siloxane-based polymers which crosslink and form a release film upon evaporation of the solvent carrier.

Handling

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C.
DO NOT DILUTE

Features

Water-based
Non-flammable
High Slip

Uses

Especially for applications requiring high slip. Ideal for mold flanges and as a replacement for edge wax. Will yield a semi-cosmetic finish.

If XTEND WSS/2 is used for New or Green Molds:

Apply 2-4 coats of XTEND XTR mold sealer prior to application of XTEND WSS/2.

Typical Properties

Effective Ingredients	11%
Color	Off white
Specific Gravity	1.005 @25°C
Flash Point	Non-Flammable
Shelf Life	12 months in unopened/original container

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

Apply with a clean, paper towel, such as the Scott Shop Towels On A Roll® or a heavy-duty plain white paper towel or cotton cloth.

Saturate the towel with release until it is wet but not dripping. Wipe onto mold surface using smooth even strokes. Apply a thin, uniform coating and allow the release to evaporate. Do not overwork the area or continue to wipe. Simply wipe on, and allow to dry.

- 1) When working on a large surface area, apply to one section at a time, working from one end of the tool surface to the other.
- 2) 2 coats of release are recommended for a clean well-conditioned tool. New tools and repaired area should be handled with special care.
- 3) Allow a minimum 15 minutes for each coat of release to dry and cure before applying the next coat. Low ambient temperatures (below 70°F / 20°C) may necessitate longer cure times.
- 4) Always use a fresh, clean towel for each coat of release.
- 5) 30 minutes cure time after the final coat is applied is generally adequate.
- 6) To maximize productivity, a break-in procedure can be beneficial. A good method is to apply a light re-wipe of release to the mold surface following the first pull.
- 7) Reapply release as needed, sheer edges radius points and high abrasion areas will require more frequent touch up.

Removal: Use CX-200HS, followed by a water wipe and a good general purpose cleaner, such as AXEL's CX-500.

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