



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet



# WSS

## Mold Release

### 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 of 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.

### Features:

Water-based  
Non-flammable  
High Slip

### Uses:

Especially for applications requiring high slip.  
Ideal for mold flanges, mold gates and as a replacement for edge wax.  
Will **not** yield a semi-cosmetic finish.

If XTEND WSS is used for New or Green Molds: Apply 2-3 coats of XTEND XTR mold sealer prior to application of XTEND WSS.

### Typical Properties

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

- 1) Apply with a clean, 100% cotton cloth. If available, paper shop towels / industrial grade paper towels is preferable.

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

For most processes, use 2 coats of WSS for initial mold preparation and re-apply 1-2 coats as required.

In high shear or abrasive processes like winding or pressing, more frequent application may be required.

### When Used for Mold Flanges & Edges and Gates:

- 1) Prepare the entire mold including the flange area with the chosen mold sealer and release system, then apply 1-2 coats of WSS to the mold flange.
- 2) Re-apply 1 coat of WSS to the flange, gate or edge areas before molding each part.
- 3) Be careful not to drip WSS into the interior of the mold. If this happens, immediately wipe out with a dry cloth and then use a cloth that is dampened with acetone to wipe the spill or drip area, and then dry with a clean cloth or towel.

NOTE: When used on flanges and edges WSS does not need to be dry before molding.

### Removal:

Use WCX or CX-200HS mold stripper, followed by a water wash and a good general purpose cleaner, such as AXEL's CX-500.

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