

## Solutions for Composites: External Mold Releases

- Polymeric Mold Releases
  - Semi-Permanent Mold Releases
  - Paste Wax
  - Mold Sealers
  - Cleaners & Strippers
- Uses Include:
    - Open Molding
    - Marble & Solid Surface
    - RTM
    - Compression Molding
    - Infusion
    - Filament Winding
    - SMC/BMC



**SOLO:** Spray on, leave on  
**SOWO:** Spray on, wipe off  
**SOBO:** Spray on, buff off

**WOLO:** Wipe on, leave on (let dry on its own)  
**WOWO:** Wipe on, wipe off  
**WOBO:** Wipe on, buff off

## External Mold Releases

	Carrier	Slip	Product No.	Application Method	Application Temperature		
			Product Name	Application	Thermoset Resins	Description	
<b>XTEND® Semi-Permanent Mold Releases</b>	Solvent-based Mold Release	Lower - Higher	1140HS	WOWO	All	Highest slip and longevity. Even better when used with XTR.	
			1110EP	WOWO/SOLO	Epoxy, phenolic, most PE/VE as well	Best for epoxies and phenolics. A thorough buffing/wiping of the surface is not necessary; only a light wipe/single pass.	
			838	WOWO	All	Excellent medium-high slip for most composite applications.	
			1080	WOLO	Polyester, VE	Highest slip, WOLO. Less longevity.	
			818+	WOLO	Polyester, VE	Excellent for balance of slip, longevity. Mold Sealer will extend longevity by up to 4x.	
			859	SOLO/WOLO	Polyester, VE	Spray on, Class A, semi-permanent	
	Water-based Mold Release		W-455HP	WOWO	All	High solids, high performance for maximum releases before reapplication	
			W-440HG	WOWO	All	Medium solids, Class A, semi-permanent water-based release. Easy to buff to a high shine.	
			<b>Mold Sealers - Solvent-based</b>				
	Solvent-based			AMS	WOWO	PE, VE	Easy application for new or repaired molds, difficult part shapes, or aggressive resins.
			XTR	Wipe on, rewet, wipe off	All	Same as above. Excellent for extending release agent longevity.	
			PR-20	WOLO	All	Mold Primer for sealing porosity, reconditioning old molds, and reducing mold build-up.	
<b>MoldWiz® Polymeric /Sacrificial</b>	Solvent-based		F-57 Series	WOBO	All	Fluoropolymer. Easy application, for use up to 250°C/482°F. Good for most thermoset applications. Gel coat, non-gel coat, filament winding, compression molding, etc.	
			F-23a/NC	WOWO	All	Primarily used for filament winding.	
		<b>Non gel-coated / Primer gel-coat /Painted Parts</b>					
	Water-based		WB-2700	WOWO/SOWO	All	Non-cosmetic. Excellent for non-gel coat thermoset applications. Compression molding, cold/hot press molding, filament winding, etc. High performance.	
			EM-Series	WOLO/WOWO/ SOLO/SOWO	All	Non-cosmetic. Low cost for compression molding, infusion, etc. Available in various solids levels.	
			JB5/985JB	SOLO	Polyester	Low cost mold release for SMC/BMC on chrome molds. 985JB is 50% concentrate.	
	<b>Mold Conditioner</b>						
Solvent		Melax 3F/NC	WOBO	All	Wipe on, polish off while wet. Excellent for sealing molds prior to using waxes and other polymeric.		
<b>PasteWiz®</b>		<b>Paste Wax</b>					
	Solvent-based		PasteWiz 88	WOBO	All	Easiest to use. Replaces other formulations in most cases. Good for all climates.	
			PasteWizHC	WOBO	All	Developed for hot climates.	
			PasteWiz	WOBO	All	General purpose paste wax.	

These products reflect only a small portion of what we have to offer. Please contact us for more information. 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 the 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 occur from the use or non-use of AXEL products or information supplied by the Company or its appointed representatives. ISO 9001 Registered. REACH Compliant. MoldWiz®, XTEND®, PasteWiz® and CleanWiz® are registered trademarks of Axcel Plastics Research Laboratories Inc. ©2016 Axcel Plastics Research Laboratories, Inc. All rights reserved.

# AXEL



For technical data sheets or free samples contact:

Axel Plastics Research Laboratories, Inc.  
 50 Cambridge Drive  
 Monroe, CT 06468 USA  
 1-800-332-AXEL (2935) in USA & Canada  
 1-203-590-2000  
 Fax: 1-718-565-7447  
 www.axelplastics.com  
 info@axelplastics.com