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Technical Data Sheet

MoldWiz[®] 462EPU External Mold Release

Product Description:

A liquid, external release agent that is ideally suited for molding polyurethane foam, epoxy resin and other composites molding applications.

May be used with FRP, PU, metal and wood molds and is ideal for porous tooling, effectively sealing the surface and contributing to smoother parts. Some transfer of 462EPU is normal, therefore some secondary bonding and painting will need cleaning of the parts before post bonding and/or painting.

Composition:

Proprietary resin emulsion of release agents in a solvent solution.

Use: PU foams and elastomers, Epoxy resins. Various types of open and closed molding operations.

Handling:

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

There are 2 approaches that may be used for mixing 462-EPU:

1. Hand mixing using a stainless steel paddle for a drum, a paint spatula for a 5 gallon pail, or hand shaking for a gallon.
2. Drive agitation using a pneumatic or electric drive with a shaft and blades, a drum mixer for drums, or a drill mixer for pails.
3. The material is mixed for at least 5 minutes until the solution is homogenous.
4. The solution is mixed at a speed high enough to form a vortex in the middle of the vessel and the solution is moving in a circular direction at the edge of the container.
5. This material will stay homogenous for several weeks (approximately a month).
6. As a precaution, 462-EPU should be mixed on a weekly basis. The material should be a single phase, slightly viscous homogeneous mixture with no haze or settling.

FEATURES:

Minimal amount needed - high actives	Clean release
Low odor	Excellent surface finish

TYPICAL PROPERTIES:

COLOR	Clear - Hazy
SPECIFIC GRAVITY	0.830 – 0.855 @ 25°C / 77°F
FLASH POINT	>61°C / >141°F
VISCOSITY	0 – 60 cp @ 25°C / 77°F
SHELF LIFE	One year from date of manufacture

Instructions for Use:

MoldWiz 462EPU can be wiped, brushed, or sprayed on. For wiping on, apply mold release with a 100% cotton cloth or blue paper shop towel. Wipe on uniformly using a circular motion. In many cases a spray application will achieve a more uniform application of the 462EPU on the mold surface.

AXEL recommends a spray system be used that can create a uniformly atomized spray pattern, such as: a HVLP spray gun or a Milwaukee Sure Shot Sprayer. 462EPU can also be applied by brush. Please contact AXEL if further application suggestions are needed.

Also available in aerosol spray cans.

Review SDS before use.

Mixing Instructions: