

## technical data

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & INTERNAL LUBRICANTS

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## MOLD WIZ FFIH-15P

**General:** A film forming combination release agent and barrier coat that dries at room temperature. For use on all types of molds. When used on RTV molds, acts as a protective barrier coat greatly extending the life of the molds. The film which is formed on the mold transfers to the molded foam during the curing cycle and acts as a primer for subsequent painting or can be washed off in a water bath, if desired. Does not contain any silicones or waxes and will not interfere with any secondary operations such as decorating, bonding, plating, etc. No necessity for washing of molds between applications.

**Use:** Polyurethane  
Polyester - Casting off Silicone  
RTV and Polyurethane Molds.

**Composition:** An alcohol-water dispersion which evaporates leaving a polymeric barrier coat / release agent film.

### TYPICAL PROPERTIES:

<b>SOLIDS:</b>	<b>3.5 – 4.0%</b>
<b>COLOR:</b>	<b>Light amber</b>
<b>SPECIFIC GRAVITY:</b>	<b>0.84 @ 25°C</b>
<b>VISCOSITY:</b>	<b>500 cps max. @ 25°C</b>
<b>FLASH POINT:</b>	<b>60°F / 15.6° C (C.O.C.)</b>
<b>SHELF LIFE:</b>	<b>Minimum of one year</b>

### Application Instructions:

**General:** FFIH-15P may be applied to all types of molds, hot or cold, by spraying, wiping or brushing. Spraying with a fine mist setting at 25-30 lbs of pressure is preferable as this results in the smoothest finish and fastest drying time. Shake well before using. 1. Clean molds with **CleanWiz** the first time the mold is used. 2. Spray a thin coat and allow to dry completely. 3. Cast and demold one part. 4. Without washing mold, re-spray FFIH-15P.

**Miscellaneous:** On certain RTV Silicone mold formulations (not polyurethane or rubber RTV), it may be necessary to prepare the mold in the following manner to ensure a uniform film: either wash the mold with a weak (1-2%) detergent solution or pre-heat the mold for five minutes prior to applying FFIH-15P.

Pigments may be added to FFIH-15P resulting in base color film being transferred to molded foam which becomes an integral part of the foam and is not water soluble. The transferred film readily accepts all finishing coats, lacquers, etc. without any special preparation required.

\***CleanWiz:** AXEL's line of solvents and water based mold cleaners.

All information given by us about our products is based upon our tests and experience. It is intended for use by persons having technical skill at their own discretion and risk, and we assume no liability in connection with their use.

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