ROTATIONAL MOULDING · WATER-BASED RELEASE AGENT

Mould Release WB-4

Water-based hybrid release agent for rotomoulding moulds

APPEARANCE
Milky white
water-based liquid

0.98–1.03 g/cm³	approx. 3–5 %	4.5–6.0	5–10 min	10–30 g/m²
Density (23 °C)	Active content	pH	Between coats	Consumption per coat

Product description

UNICA MOULD RELEASE WB-4 is a water-based hybrid release agent that forms a thin, homogeneous release film on metal moulds in rotomoulding. Its silicone-modified release phase and organofunctional surface technology create a low-surface-energy layer between polymer and mould.

Application areas

- Rotomoulded water tanks
- Plastic tank production
- Industrial hollow plastic parts
- HDPE and similar polyolefin rotomoulded products

Advantages

- Water-based system
- Low build-up tendency
- Clean application
- Thin, homogeneous film
- Stable release performance
- Easy part release, stable over production cycles

Position in the system

Polymer part
HDPE – rotational moulding

Release film — THIS PRODUCT
MOULD RELEASE WB-4 · 10–30 g/m² per coat

Metal mould
Clean, dry mould surface

Rotomoulding

Low-surface-energy release layer for metal moulds

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Technical data (at +20 °C)

Appearance	**Milky white liquid**	Interval between coats	**5–10 min**
Density (23 °C)	**0.98–1.03 g/cm³**	Wait before moulding	**10–20 min**
pH	**4.5–6.0**	Consumption	**10–30 g/m² per coat**
Active content	**approx. 3–5 %**	Storage temperature	**5–30 °C**
Carrier system	**Water-based**	Shelf life	**12 months**
Application method	**Wiping or spraying**		

Application procedure

01

Surface preparation

The mould must be free of oil, dust and old release residues. If needed, clean with a suitable mould cleaner and dry completely.

02

Mixing

Stir the product until homogeneous before use.

03

Application

Apply a thin, even film by wiping with a lint-free cloth or by low-pressure spray. On first use, two thin coats may be applied.

04

Waiting time

Wait 5–10 min between coats and 10–20 min before starting the moulding process.

Consumption
10–30 g/m²
Per coat – depends on mould surface, application method and operator technique.

Before moulding
10–20 min
Waiting time after the last coat.

Coats
1–2 thin coats
Two thin coats on first application if required.

Important: the values given are typical laboratory results – verify the suitability of the product under your own production conditions.

Packaging

- 5, 10 and 30 L plastic jerrycans

Storage

- Store in original packaging at 5–30 °C.
- Protect from frost and direct sunlight.
- Shelf life: 12 months under suitable conditions.

LEGAL NOTE

The explanations provided in this technical data sheet are based on test evaluations and results conducted according to relevant standards and are intended to guide applicators. As workmanship, weather conditions, construction, equipment used and other variables that may affect results are entirely beyond our control, UNICA does not provide any explicit or implicit warranty regarding this material. UNICA only guarantees that the material conforms to its product specifications, and its sole responsibility towards the buyer or user of this product is limited to the replacement value of the product in case of manufacturing defects. Under no circumstances shall UNICA be liable for any direct or incidental, special or consequential injury, loss or damage arising from the material or its application. UNICA shall not be held responsible in any way for any defects, alterations or changes in conditions in the substrate where its products are applied.

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