

Tech Table: Mold release agents

By Grace Nehls / Assistant Editor

➤ Mold release agents — arguably the products most responsible for long tool life — provide a critical barrier between the mold surface and the molded part. Whether for aerospace, automotive, marine, wind energy or any other end market, a properly applied mold release encourages easy separation of part from mold. An improperly applied mold release, or a mold release not applied at all, causes well-documented problems in demolding high-quality parts. It is no surprise, then, that release agents are a vital part of quality control during the composites fabrication process, and help guarantee proper mold care, making them a cost-effective strategy for manufacturers.

As a result, mold preparation and maintenance is not just common, it's mandatory. Suppliers of mold releases offer a variety of products designed to cater to specific materials, processes and applications, with factors like operator preference, plant safety and environmental impact in mind.

This table of mold release agents was built with data provided either directly by the supplier, or from published data. It should be noted that, due to the large variety of available release agents, the products in this table only represent external mold release products in each supplier's product line; internal release products, conditioners, cleaners, primers and sealers are not included. For more information on these and other composites industry products, use the CW SourceBook database to find and identify suppliers.

This is the second in a series of Tech Tables CW is publishing in 2020, each designed to provide as comprehensive a list as possible of suppliers, their products and selected product qualities. CW's first Tech Table, published in January 2020, [covers aerospace structural adhesives](#). [cw](#)

Supplier	Product	Chemistry	Application method(s)	Cure temperature (°F/°C)	Max service temperature (°F/°C)	Applied thickness, recommended coats	Material compatibility										Process compatibility								
							Polyester	Epoxy	Phenolic	Vinyl ester	Polyurethane	Bismaleimide	SMC/BMC	Polyamide	Thermoset resins	Thermoplastic resins	Spray-up	Hand/wet lay-up	Compression molding	Vaccum bagging	FRP	RTM	Filament winding		
AXEL Plastics	250SL series	SB	WOBO	RT			X			X							X								
	985JB	WB	SOLO	RT			X			X					X				X						
	EM-1212SF2	WB	SOLO/SOWO WOLO/ WOWO	RT or elevated			X	X	X						X					X					
	EM-303SF2	WB	SOLO/SOWO WOLO/ WOWO	RT or elevated			X	X	X						X					X					
	F-23A/NC	SB	SO, WOBO, WOLO	RT			X	X	X	X								X		X	X		X	X	X
	F-57NC	SB	SO, WOBO, WOLO	RT			X	X	X	X								X		X	X		X	X	X
	MWM	SB	SOLO	RT			X			X							X	X	X			X			
	Paste Wiz	Paste	WOBO				X	X		X	X							X	X					X	
	Paste Wiz 88	Paste	WOBO				X	X		X	X							X	X					X	
	WB-2700	WB	WOWO, SOWO, SOLO, WOLO		RT or elevated			X	X	X	X										X				

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							Polyester	Epoxy	Phenolic	Vinyl ester	Polyurethane	Bismaleimide	SMC/BMC	Polyamide	Thermoset resins	Thermoplastic resins	Spray-up	Hand/wet lay-up	Compression molding	Vacuum bagging	FRP	RTM	Filament winding	
AXEL Plastics	WF-57	WB	SO, WOBO, WOLO	RT				X		X						X	X		X	X		X	X	
	WF-57NP	WB	SO, WOBO, WOLO	RT				X		X						X	X		X	X		X	X	
	XTEND 1080	SB, SP	WOLO	RT or elevated			X	X		X						X	X							
	XTEND 1110EP	SB, SP	WOLO	RT or elevated			X	X	X	X						X	X					X		
	XTEND 1140HS	SB, SP	WOLO	RT or elevated			X	X	X	X						X	X					X		
	XTEND 19RSS	SB, SP	WOLO, SOLO	RT			X	X		X	X												X	
	XTEND 818+	SB, SP	WOLO	RT or elevated			X	X		X						X	X							
	XTEND 838	SB, SP	WOLO	RT or elevated			X	X	X	X						X	X						X	
	XTEND W-460	WB, SP	WOW, WOLO	RT or elevated			X	X	X	X						X	X							
	XTEND W-HGS	SB, SP	WOLO	RT or elevated				X			X													X
Chem-Trend	Chemlease 2185	SB, SP	WOBO	RT	550/287	3-5 coats	X	X	X	X					X	X	X	X		X	X	X	X	
	Chemlease 258R	WB	WOLO	RT	390/200	3-5 coats	X	X	X	X					X	X		X	X					X
	Chemlease 2710	SB, SP	WOLO	RT	750/400	3-5 coats	X	X		X					X	X	X	X		X	X	X		
	Chemlease 2760W	WB, SP	SOLO	RT	500/260	3-5 coats	X			X		X			X	X	X	X	X	X	X			
	Chemlease 5075	SB	WOLO, SOLO	RT	390/200	3-5 coats	X	X		X		X			X	X		X			X			X
	Chemlease CPRe	SB, SP	WOWO	RT	750/400	3-5 coats	X			X			X		X	X	X	X		X	X	X		
	Chemlease One FS EZ	SB, SP	SOLO, WOLO	RT	750/400	3-5 coats	X			X					X	X	X	X		X	X	X		
	Chemlease PMR EZ	SB, SP	WOWO	RT	750/400	3-5 coats	X	X		X					X	X					X	X	X	
	Chemlease R&B EZ	SB, SP	WOWO	RT	750/400	3-5 coats	X	X		X		X		X	X	X	X	X		X	X	X		

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							Polyester	Epoxy	Phenolic	Vinyl ester	Polyurethane	Bismaleimide	SMC/BMC	Polyamide	Thermoset resins	Thermoplastic resins	Spray-up	Hand/wet lay-up	Compression molding	Vacuum bagging	FRP	RTM	Filament winding	
Chem-Trend	Zyvox 1042W	WB, SP	SOLO	RT	500/260	3-5 coats	X	X	X	X			X	X	X	X		X	X	X	X			
	Zyvox 1070W	WB	SOLO, WOLO	RT	500/260	2-4 coats	X	X	X	X	X			X	X		X		X	X	X	X		
	Zyvox Departure	WB, SP	WOWO	RT	500/260	2-4 coats		X		X				X	X		X	X	X		X	X		
	Zyvox EnviroShield	WB, SP	WOWO	RT	500/260	2-4 coats	X	X		X	X		X	X	X		X	X	X	X	X	X	X	
	Zyvox Flex-Z 1.0 - 6.0	SB, SP	SOLO, WOLO	RT	750/400	3-5 coats	X	X		X			X	X	X		X	X	X	X	X	X	X	
	Zyvox TakeOff	WB, SP	WOWO	RT	750/400	3-5 coats	X	X	X	X			X	X	X	X		X	X	X		X		
	Zyvox WaterShield	WB, SP	WOWO	RT	500/260	2-4 coats	X	X		X	X				X	X		X	X	X	X	X	X	X
Henkel	Frekote 44-NC	SB, SP		RT or elevated	752/400		X	X		X			X		X		X	X	X	X	X	X		
	Frekote 55-NC	SB, SP		RT	752/400			X		X			X		X		X	X	X	X	X	X		
	Frekote 700-NC	SB, SP		RT	752/400			X			X		X		X	X	X	X	X	X	X	X		
	Frekote 710-LV	SB, SP		RT	752/400		X	X		X			X		X		X	X	X	X	X	X		
	Frekote 720-NC	SB, SP		RT	752/400		X	X		X			X	X	X		X	X	X	X	X	X	X	X
	Frekote 770-NC	SB, SP		RT	752/400		X	X		X			X		X		X	X	X	X	X	X		
	Frekote C-600	WB, SP		RT	600/315			X							X		X	X	X	X	X	X	X	X
	Frekote Exit-EM	WB, SP		RT	500/260		X	X	X	X	X		X	X	X		X	X	X	X	X	X	X	X
	Frekote Frewax	SB, SP		RT	536/280		X								X		X	X	X	X	X			
	Frekote FRP-NC	SB, SP		RT	752/400		X			X			X		X		X	X	X	X	X	X	X	
	Frekote R-120	WB, SP	SO	302/150	600/315				X						X				X					
	Frekote R-150	WB, SP	SO	302/150	600/315				X						X				X					
	Frekote R-180	WB, SP	SO	302/150	600/315				X						X				X					
	Frekote R-220	WB, SP	SO	302/150	600/315				X						X				X					
	Frekote WOLO	SB, SP		RT	752/400		X			X					X		X	X	X	X	X	X	X	
Marbocote Ltd.	Marbocote 220	SB, SP	WO, spread	RT	482/250	4-6 coats	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X		
	Marbocote 227CEE	SB, SP	WO	RT	482/250	4-6 coats	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X		

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<small>SP: semi-permanent S: sacrificial</small> <small>WB: (water-based) and SB: (solvent-based)</small> <small>RT: room temperature WOTO: Wipe on, buff off</small> <small>WOLO: Wipe on, leave on WOWO: Wipe on, wipe off</small> <small>SOLO: Spray on, leave on SOWO: Spray on, wipe off</small> <small>SOBO: Spray on, buff off</small>							Material compatibility										Process compatibility						
Supplier	Product	Chemistry	Application method(s)	Cure temperature (°F/°C)	Max service temperature (°F/°C)	Applied thickness, recommended coats	Polyester	Epoxy	Phenolic	Vinyl ester	Polyurethane	Bismaleimide	SMC/BMC	Polyamide	Thermoset resins	Thermoplastic resins	Spray-up	Hand/wet lay-up	Compression molding	Vaccum bagging	FRP	RTM	Filament winding
Marbocote Ltd.	Marbocote Fastcoat	SB, SP	WO	RT	482/250	4-6 coats	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X	
	Marbocote PK4	SB, SP	WO, spread	RT	482/250	4-6 coats	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X	
	Marbocote Spraycote	SB, SP	SO	RT	482/250	4-6 coats	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X	
	Marbocote W1151B	WB, SP	SO; WO, spread	RT or 176/80	482/250	4-6 coats	X	X	X	X		X	X	X	X	X			X	X		X	
	Marbocote W501	WB, SP	SO	RT or 176/80	482/250	4-6 coats		X	X			X	X	X		X			X				
Maverix Solutions	Mavcoat 527ML	SB, SP; ceramic polymer	SO, WO, brush, mop	RT	1500/816	< 1 micron	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
	Mavcoat 954ML	SB, SP; ceramic polymer	SO, WO, brush, mop	RT	1500/816	< 1 micron	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
	Mavcoat C-451	WB, SP; fluoropolymer	SO, WO, brush, mop	No cure	780/416	< 1 micron		X	X			X		X	X	X	X	X	X	X	X	X	
	Mavcoat DHSR-24	SB, SP; hydrocarbon polymer	SO, WO, brush, mop	No cure	670/354	< 20 micron	X	X		X	X		X		X				X		X		
	Mavcoat EM	WB, SP; fluoropolymer	SO, WO, brush, mop	No cure	950/510	< 1 micron		X	X			X	X	X	X	X			X	X	X	X	
	Mavcoat EP-111	WB, SP; fluoropolymer	SO, WO, brush, mop	No cure	950/510	< 1 micron		X	X			X		X	X	X			X	X	X	X	
	Mavcoat EP-524	WB, SP; fluoropolymer	SO, WO, brush, mop	No cure	950/510	< 1 micron	X	X	X	X		X	X	X	X	X	X	X	X	X	X	X	
	Mavcoat FGR-4	SB, SP; ceramic polymer	SO, WO, brush, mop	RT	1500/816	< 1 micron	X			X			X		X	X	X	X	X	X	X	X	X
	Mavcoat GSMR	water-dilutable concentrate, SP; fluoropolymer	SO, WO, brush, mop	No cure	950/510	< 1 Micron	X	X	X	X	X	X	X	X	X	X			X				X
	Mavcoat KCP	SB, SP; ceramic polymer	SO, WO, brush, mop	RT	1500/816	< 1 micron	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X
	Mavcoat LBC	SB, SP; fluoropolymer	SO, WO, brush, mop	No cure	670/354	< 1 micron		X	X			X	X	X	X	X			X	X			
	Mavcoat MMR	WB, SP; fluoropolymer	SO, WO, brush, mop	No cure	950/510	< 1 micron	X	X	X	X	X	X	X	X	X	X			X				X
	Mavcoat PU-54	WB, SP; fluoropolymer	SO, WO, brush, mop	No cure	670/354	< 20 micron					X				X				X				X
	Mavcoat T-100	WB, SP; fluoropolymer	SO, WO, brush, mop	No cure	670/354	< 20 micron	X	X		X	X		X		X	X			X		X		
Mavcoat XD	SB, SP; ceramic polymer	SO, WO, brush, mop	RT	1500/816	< 1 micron	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	X	

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							Polyester	Epoxy	Phenolic	Vinyl ester	Polyurethane	Bismaleimide	SMC/BMC	Polyamide	Thermoset resins	Thermoplastic resins	Spray-up	Hand/wet lay-up	Compression molding	Vaccum bagging	FRP	RTM	Filament winding
McLube	McLube 1038	SB	SO, WO, brush	RT or OT	700/371	2 coats; refresh as needed	X	X	X	X	X	X	X	X			X	X	X	X	X	X	X
	McLube 1123	SB	SO, WO, brush		600/316	2 coats; refresh as needed	X	X	X	X	X	X		X			X	X	X	X	X	X	X
	McLube 1212	WB (PTFE), SP	SO, WO, brush		550/288	2 coats; refresh as needed	X	X	X	X	X	X					X	X		X		X	
	McLube 1700L	SB (PTFE), SP	SO, WO, brush		550/288	2 coats; refresh as needed	X	X		X							suitable for most processes						
	McLube 1733H	SB (PTFE), SP	SO, WO, brush		550/288	2 coats; refresh as needed	X	X	X	X	X	X					X	X		X	X	X	X
	McLube 3013	WB	SO, WO, brush	OT	1000/538	2 coats; refresh as needed	X	X	X	X	X	X	X	X					X	X	X		X
	McLube 507	WB, SP	SO, WO, brush		600/316	2 coats; refresh as needed	X	X	X	X		X					X	X		X			X
	McLube 818	WB, SP	SO, WO, brush		600/316	2 coats; refresh as needed	X	X	X	X	X	X		X			X	X		X		X	X
	McLube 971	SB	SO, WO, brush	RT or OT	600/316	2 coats; refresh as needed	X	X	X	X	X	X		X			X	X	X	X	X	X	X
	McLube 973	WB, SP	SO, WO, brush	OT	1100/538	2 coats; refresh as needed	X	X	X	X	X	X	X	X		X			X	X	X		X
PRF Composites	AQ610	WB, SP	SO, WO, brush; polish	RT or 140/60		6 coats	X	X		X													
	AQ620R	SbP	SO, WO, brush; polish	RT or 140/60		6 coats										X							
	R370, R375, R377	SP	SO, WO, brush	RT or 140/60		5 coats	X	X	X	X													
	R380	SP	SO, WO, brush	RT or 140/60		5 coats	X	X		X													
	R400	SP	SO, WO, brush	RT or 140/60		5 coats										X							
	Silicone Shield		SO, WO, brush	RT or 140/60		1-4 coats	X	X		X													
Rexco	FORMULA FIVE Glossy Top Coat	SB, SP	WO	RT or 100/38	500/260	4 coats, more as needed	X	X	X	X							X	X	X	X	X	X	X
	FORMULA FIVE Matte Top Coat	SB, SP	SO, WO, WO	RT or 100/38	500/260	3 coats, more as needed	X	X	X	X	X						X	X	X	X	X	X	X
	FORMULA FIVE Mold Release Wax	SB; carnauba, silicone	WO	RT	100/38	3-4 coats, 1 per cycle	X	X	X	X	X	X		X		X	X	X	X	X	X	X	X

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Rexco	MARBALEASE Polymer Concrete Release	SB	SO, brush	RT	100/38	1-2 coats												X	X	X		X			
	MARBALEASE Slurry Wax	SB	Brush	RT	100/38	1-2 coats												X	X	X		X			
	PARTALL Coverall Film	Polyvinyl alcohol liquid coating	SO, brush, roll	RT	300/149	1-2 mils seasoned molds; 2-4 mils new or reconditioned molds	X	X	X	X	X							X	X	X		X			
	PARTALL Film #10	Polyvinyl alcohol liquid coating	SO	RT	300/149	1-2 mils seasoned molds; 2-4 mils new or reconditioned molds	X	X	X	X	X							X	X	X		X			
	PARTALL Hi-Temp Wax	SB; contains PTFE	WOBO	RT	350/177	3-4 coats, 1 per cycle	X	X	X	X	X	X				X			X	X	X	X	X	X	X
	PARTALL One Coat	Polyvinyl alcohol liquid coating	SO, brush, roll	RT	300/149	1-2 mils seasoned molds; 2-4 mils new or reconditioned molds	X	X	X	X	X							X	X	X		X			
	PARTALL Paste #2	SB; silicone-free	WOBO	RT	100/38	3-4 coats, 1 per cycle	X	X	X	X	X	X				X			X	X	X	X	X	X	X
Stoner Molding Solutions	G494	SB, SP	WOBO	RT	800/427	.10 g/sq ft	X	X		X								X	X		X	X			
	G495	SB, SP	WOBO	RT	800/427	.10 g/sq ft	X	X		X								X	X		X	X			
	Honey edge wax	SB, S	WOBO	RT	250/121	.2-3 g/sq ft																			
	Honey plus wax	SB, SP	WOBO	RT	482/250	.2-3 g/sq ft	X	X		X	X							X	X					X	
	Honey slurry wax	SB, S	WO	RT	250/121	.2-3 g/sq ft																			
	Honey wax	SB, SP	WOBO	RT	250/121	.2-3 g/sq ft	X	X		X	X							X	X					X	
	Honey wax 100	SB, S	WOBO	RT	250/121	.2-3 g/sq ft	X	X		X	X							X	X					X	
	Honey wax 250	SB, S	WOBO	RT	250/121	.2-3 g/sq ft	X	X		X	X							X	X					X	
	Honey wax hydro speed	WB, S	WO, SO	RT	250/121	.2-3 g/sq ft	X	X		X															
Honey wax liquid	SB, S	WOBO	RT	250/121	.2-3 g/sq ft	X	X		X								X								

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Stoner Molding Solutions	KantStik Cure Fast 1.0	SB, SP	WOBO	RT	800/427	.10 g/sq ft	X	X		X							X	X		X	X								
	KantStik SPC 1.0	SB, SP	WOBO	RT	800/427	.10 g/sq ft	X	X		X							X	X		X	X								
	LM 35 wax emulsion	WB, S	SO, WO	RT	350/177	.2-.3 g/sq ft	X	X		X									X										
	Miracle Gloss M0811	SB, S	WOBO	RT	250/121	.2-.3 g/sq ft	X	X		X							X	X		X	X								
	Miracle Gloss M8711	SB, S	WOBO	RT	250/121	.2-.3 g/sq ft	X	X		X	X						X	X		X	X								
	Miracle Gloss M8811	SB, S	WOBO	RT	482/250	.2-.3 g/sq ft	X	X		X	X						X	X		X	X	X	X						
	P229 Poly Iso Release	WB, S	SO, WO	RT	350/177	.2-.3 g/sq ft	X	X		X	X																		
	P313	WB, S	SO, WO, brush	RT		.2-.3 g/sq ft	X			X									X										
	TraSys 9825	WB, SP	SO	250/177	350/177	.10 g/sq ft	X	X	X	X									X										
	XK-22 LV.5 (G471)	SB, SP	WOBO	RT	800/427	.10 g/sq ft	X	X	X	X								X	X	X	X	X	X						
TR Industries	TR-100 Gold Paste Wax	SB, S	WO	RT	200/93	6-8 coats	X	X		X					X	X	X		X	X			X						
	TR-102 Regular Paste Wax	SB, S	WO	RT	200/93	6-8 coats	X	X		X					X	X	X		X	X			X						
	TR-104 High-Temp Paste Wax	SB, S	WO	RT	235/113	6-8 coats	X	X		X	X				X	X	X		X	X	X	X	X						
	TR-108 Basic Paste Wax	SB, S	WO	RT	200/93	6-8 coats	X	X		X					X	X	X		X	X	X								
	TR-110 Seal Wax	SB, S	WO, brush	RT	180/82	1-2 coats	X	X		X							X	X			X								
	TR-111 Slurry Wax	SB, S	WO, brush	RT	165/64	1-2 coats	X			X							X	X			X								
	TR-210 Self-Stripping Liquid Wax	SB, S	SO, WO	RT	200/93	1-2 coats	X			X							X	X			X								
	TR-214 Regular Liquid Wax	SB, S	SO, WO	RT	200/93	1-2 coats	X	X		X							X	X		X	X	X							
	TR-214PC Polymer Liquid Wax	SB, SP	SO, WO	RT	500/260	4 coats	X	X		X	X					X	X	X	X	X	X	X	X	X					

SP: semi-permanent S: sacrificial WB: (water-based) and SB: (solvent-based) RT: room temperature WOBO: Wipe on, buff off WOLO: Wipe on, leave on WOWO: Wipe on, wipe off SOLO: Spray on, leave on SOWO: Spray on, wipe off SOBO: Spray on, buff off							Material compatibility										Process compatibility							
Supplier	Product	Chemistry	Application method(s)	Cure temperature (°F/°C)	Max service temperature (°F/°C)	Applied thickness, recommended coats	Polyester	Epoxy	Phenolic	Vinyl ester	Polyurethane	Bismaleimide	SMC/BMC	Polyamide	Thermoset resins	Thermoplastic resins	Spray-up	Hand/wet lay-up	Compression molding	Vacuum bagging	FRP	RTM	Filament winding	
TR Industries	TR-216 High-Temp Liquid Wax	SB, SP	SO, SO	RT	225/107	1-2 coats	X	X		X	X					X	X	X		X	X	X	X	
	TR-800 Multi-Pull	SB, SP	SO, WO	RT or 284/140	550/288	4-6 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-810 Multi-Pull	WB, SP	SO, WO	180/356	600/315	4-6 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-820 Multi-Pull	WB, SP	SO, WO	RT	600/315	3-5 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X	X	
	TR-900 Multi-Pull	SB, SP	WO	RT	750/400	3-4 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-920 Multi-Pull	SB, SP	WO	RT	900/482	3-4 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-930 Multi-Pull	SB, SP	SO, WO	RT	750/400	3-4 coats	X	X	X	X	X	X	X	X		X	X	X	X	X	X	X	X	X
	TR-930HS Multi-Pull	SB, SP	SO, WO	RT	750/400	3-4 coats	X	X	X	X	X	X	X	X		X	X	X	X	X	X	X	X	X
	TR-940 Multi-Pull	SB, SP	SO	RT	750/400	6-8 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-950 Multi-Pull	SB, SP	WO	RT	750/400	4-6 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-955 Multi-Pull	SB, SP	WO	RT	750/400	4-6 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-960 Multi-Pull	SB, SP	SO, WO	RT	750/400	3-4 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		
	TR-960FD Multi-Pull	SB, SP	SO, WO	RT	750/400	3-4 coats	X	X	X	X		X	X	X		X	X	X	X	X	X	X		