

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet

**XTEND**™  
Semi-Permanent Mold Releases

# W-3236

### Product Description

A semi-permanent, aqueous emulsion, external release agent that forms a uniform cured film on drying. Selective adhesion on the mold surface prevents the film from being torn off with de-molding.

### Composition

Aqueous solution of proprietary resins and reactive surface modifiers.

### Features

Easy, spray or wipe-on  
High gloss  
No HAPS

### Uses

Specifically designed for hot molding of elastomers including silicone, polyacrylate, EPDM, fluororubbers, and polyurethanes for all molding surfaces.

### Typical Properties

Effective Ingredients	< 3%
Color	Off white
Specific Gravity	1.00 @25°C
Viscosity	<15cps @25°C
pH	7.0 – 9.0
Flash Point	Non Flammable
Shelf Life	6 months

### Mold Preparation

In order for the release to work effectively, the mold must be thoroughly cleaned to remove previously used mold release and other surface contaminants, which may be incompatible.

New molds should be cleaned with solvent to remove protective lubricants and coatings. Molds coated with other semi-permanent release agents can be cleaned with CX-200HS of high pH detergent. Then, wipe down the mold with a mild cleaning solvent and thoroughly dry the surface.

### Application Instructions

- 1) Mix/shake well product before using.
- 2) Apply using a clean, woven, lint free cloth, such as the Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes, or even

a good, heavy-duty plain white paper towel. Wet the cloth with release until it is damp but not dripping and wipe onto mold surface using smooth even strokes until the film is uniformly dry without wiping marks.

Mold release may also be sprayed or brushed on. Apply at room temperature or preferably on warm molds (up to 165°C/330°F).

The release performs best when sprayed on hot molds (preferably 80°C/ 180°F or higher). Multiple coats (2-4) may be necessary to achieve proper, uniform application of the release. Allow the coating to dry between applications. Best results are attained when the initial application is allowed to cure at 200F-400°F/ 93-200°C prior to the first release.

Curing at the higher temperatures, longer cure times (up to 60 minutes), or leaving the mold to post-cure overnight at ambient conditions after a thermal cure prior to molding can also be helpful in maximizing the number of releases.

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