PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

XTEND™
Semi-Permanent Mold Releases

19SAM

Product Description
External mold release. An air-drying reactive resin solution that cures to a cross-linked semi-permanent coating, which provides multiple release without transfer.

Composition
Proprietary resin solution comprising modified siloxane-based polymers which crosslink and form a release film upon evaporation of the solvent carrier.

Handling
MOISTURE SENSITIVE. KEEP TIGHTLY SEALED.
Minimize exposure to atmosphere.
Do not return exposed material to can.
Store above freezing and below 100ºF / 39ºC.
DO NOT DILUTE

Features
Very High slip coating.
Fast curing.
No sealer required.
Highly durable coating

Uses
Designed for use in Solid Surface molding, open and closed molding non-gel coated applications where the release is applied in the ambient to 120F/50C range and processes occur above ambient temperatures and less than 400°F/204°C with Modar™, Polyester, Vinyl Ester DCPD, Epoxy, Natural & Synthetic Rubber, & Rigid Polyurethanes. Excellent for any molding application that does not require a high gloss, Class A type finish.

Typical Properties

Effective Ingredients	1-3%
Color	Clear
Specific Gravity	0.730 @25˚C
Flash Point	<73°F / <23° C (C.O.C.)
Shelf Life	12 months in unopened/original container
Solvents	Aliphatic Hydrocarbons

Mold Preparation
New & Green FRP Molds:
Read AXEL publication FocusOn New & Green Molds.
Conditioned & Metal Molds:
Mold surfaces should be clean and free of previously used mold releases and other surface contaminants.

Application Instructions

1) Wet a clean, woven, lint free cloth, such as the Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes, or a heavy-duty plain white paper towel with release.

2) Working in small areas, wipe on a smooth light film. Do not over apply. Do not rub or rework.

3) Allow to dry. Continue application until entire mold is coated.

4) Apply 3 coats of release allowing approximately 15 minutes between each for drying and curing.

Break In
Apply one coat of release after the first, and third release. This will extend release productivity.

Touch Up
Wipe on touch up coats as needed.

* Due to the unique properties of this material, we require a clean closed application container. The container we find best suited, is a HDPE bottle with a shampoo squeeze style cap, where only a small amount of air is transferred. Gallons should be transferred into the type of container described above. At your request we can supply a sample and source. Drum quantity customers are required to use a desiccant drier attachment to assure proper release performance.

Maintenance
If sticking begins: Wipe the problem area of the mold with XTEND 19SAM to dissolve and remove residue. Continue molding. If the residue does not dissolve, lightly work over the tool with a Scotchbright® pad wet with XTEND 19SAM, then apply one coat of release.

If build up persists: Wipe off with AXEL's CX-500 cleaner and a Scotchbright® pad. (This cleaner is designed to take off the residual buildup without removing the base coat of release.) Then wipe on 1 to 2 coats of XTEND 19SAM, waiting 10 minutes between each coat.

In extreme scumming conditions (usually associated with closed molding applications): Strip the tool with CX-525 (a cleaner especially formulated to remove styrene build up), CX-200HS stripper and by buffing the tool. This will remove all scumming, buildup and the release. It will also condition the mold for break-in. Start from step 1 to recondition the mold.

Removal: Use CX-200HS, followed by a water wipe and a good general purpose cleaner, such as AXEL's CX-500.

The key to easy, consistent releases is maintaining molds through balanced use of release and cleaner. To further optimize the closed molding process we also recommend using an internal mold release.

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