

### Product Description

External mold release: An air-drying reactive resin solution that cures to provide a durable semi-permanent coating. Permits multiple releases without transfer at both ambient and elevated temperatures.

### 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.  
DO NOT Agitate/Shake  
Minimize exposure to atmosphere.  
Do not return exposed material to can.  
Store above freezing and below 100°F / 38°C.  
DO NOT DILUTE

### Features

Easy, wipe on  
No polishing required  
High Gloss  
No HAPs

### Uses

Ideal for open molding, high yield applications such as tub/shower and Marine that require class "A" finishes.  
Molding polyester or vinyl ester resin..

**For initial application, 2 coats of XTEND XTR mold sealer is recommended prior to application of XTEND 1080.**

### Typical Properties

Effective Ingredients	<2%
Color	Clear
Specific Gravity	0.72 @25°C
Flash Point	<73°F / <23°C (C.O.C.)
Shelf Life	12 months in unopened/original container
Solvents	Aliphatic Hydrocarbons Blend

### New Molds

We recommend reading AXEL publication Focus-On New & Green Molds. Conditioned & Metal Molds: Mold surfaces should be clean and free of previously used mold releases, buffing and polishing compounds, and other surface contaminants.

AXEL strongly recommends the use of a Mold Stripper/Remover when buffing compounds or polishing compounds are used that contain animal fats, silicones, (pine) oils, etc. AXEL's water-based WCX or solvent based CW10-NC can be used. After thoroughly removing the buffing compounds, a hot water wash (then dry), and then cleaning with AXEL CX-500 should be completed prior to applying AXEL XTR Mold Sealer and AXEL XTEND 1080.

### Application Instructions for XTEND 1080: Wipe On, Leave On

Apply with two clean, woven, lint free paper towels, folded together into quarters, such as the Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes, or a heavy-duty plain white paper towel. Wet the paper towel with release until it is damp but not dripping. Squeeze the towel in to a ball to soak the 1080 throughout the towel. Wipe onto mold surface using smooth even strokes. Apply a thin, uniform coating and allow the release to evaporate. Do not overwork the area or continue to wipe – do not wipe over the same area more than twice. Simply wipe on, and allow to dry.

1) When working on a large surface area, apply to one section at a time, working from one end of the tool surface to the other. Alternate the starting point on ensuing coats.

2) 3-6 coats of release are recommended for a clean well-conditioned tool. New tools and repaired area should be handled with special care (see Focus On: New & Green Molds. At least 2 coats of XTR sealer are recommended for new and repaired molds. )

3) Allow a minimum of 15 minutes for each coat of release to dry and cure before applying the next coat. Low ambient temperatures (below 70°F / 20°C) may necessitate longer cure times.

4) Always use a fresh, clean cloth for each coat of release. If streaking occurs, replace your cloth with a clean one. Make sure that the cloth does not start to dry out during application, as this can cause the release to streak or haze – this is more common on large molds (see FAQ's Semi-Permanent Mold Releases & FRP Molds). Most streaks can be removed right away by re-wetting the streak and then wiping immediately after. Or, if the streak is missed it can be removed by waiting for the release to cure and then lightly wiping or buffing the surface with a clean, dry cotton cloth or microfiber cloth.

5) 60 minutes cure time after the final coat is applied is *generally adequate. Once again, the longer you wait, the better. Temperatures below 70°F/20°C should cure for 60 to 120 minutes. Cure time for new molds or repaired areas should be 60 minutes minimum and preferably longer. Longer cure times are also helpful when the mold has sharp angles, difficult geometry, and/or a challenging resin or gel coat will be molded.*

6) To maximize productivity, a break-in procedure can be beneficial. A good method is to apply a light coat of release to the mold surface following the first pull, another after the third, and another after the fifth part. It is also a good idea to do more frequent touch ups on sheer edges, radius areas, and high wear sections (referred to as a spot touch-up). This will improve release performance and provide the best protection for your tool. AXEL ALWAYS recommends one touch-up (re-application) after the first part is molded.

\* Due to the unique properties of this material, we require a clean closed application container. The container we find best suited, is a quality HDPE bottle with a shampoo squeeze style cap, where only a small amount of air is allowed to enter the bottle. 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.

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