PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

XTEND™
Semi-Permanent Mold Releases

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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.
Minimize exposure to atmosphere.
Do not return exposed material to can.
Store above freezing and below 100ºF / 38ºC.
DO NOT DILUTE

CAUTION: Do not apply to hot molds (over 300ºF/148ºC)

Features
Easy, wipe on
No wipe off or polishing required
High Gloss

Uses
Ideal for all gel coated parts, or for molding processes that require a class “A” finish.

Molding polyester, vinyl ester & epoxy.

Typical Properties

Effective Ingredients	<2%
Color	Clear
Specific Gravity	0.766 @25˚C
Flash Point	<73°F / <23°C (C.O.C.)
Shelf Life	12 months in unopened/original container
Solvents	Aliphatic Hydrocarbons Blend

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

Hand Wiping

Apply with a clean cotton cloth, or a heavy-duty paper towel.
1) Wet the cloth with release until it is damp but not dripping. 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. Simply wipe on, and allow to dry.

2) 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. Overlap slightly between each row or section.

3) After release is totally dry, lightly buff any areas that have any haze or streaks. This should be done by hand, using a soft, lightly textured cotton cloth and minimal pressure.

4) A minimum of 3 coats of release should always be applied to a clean well-conditioned tool. New & green tools should be handled with special care (see Focus On: New & Green Molds. At least 2 coats of XTR sealer are recommended for new or reconditioned molds or repaired areas.)

5) Allow a minimum 15 minutes minimum for each coat of release to dry and cure before applying the next coat. Application at low ambient temperatures (below 70ºF / 20ºC) may necessitate longer cure times.

6) Always use a fresh, clean cloth for each coat of release. If streaking occurs, replace your cloth with a clean one. Also make sure that the cloth is not too saturated, as heavy applications of release can streak (see FAQ’s Semi-Permanent Mold Releases & FRP Molds). Most streaks can be removed by waiting for the release to cure and then lightly buffing the surface with a clean, dry cloth.

7) Wait a minimum of 30 minutes cure time after the final coat is applied before gel coating of molding.

8) To maximize productivity, a break-in procedure can be beneficial. A good method is to apply a light re-wipe of release to the mold surface following the first de-molding. It is a good idea to do more frequent touch ups on sheer edges, radius areas, and high wear sections. This will improve release performance and provide the best protection for the mold.

* 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

Reapply mold release as necessary. CX-500 cleaner may be used to remove minor buildup, which occurs during molding. Always reapply release after using cleaner. If excessive styrene buildup occurs use CX-525 styrene stripper followed by CX-500. Reapply mold release. If mold have been cleaned aggressively, or compounded, both sealer and release should be applied.