

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

XTENDTM
Semi-Permanent Mold Releases

W-7806R

Product Description

Proprietary resin emulsion comprising modified polymers which crosslink and form a semi-permanent release film upon evaporation of the water carrier, which provides multiple release without transfer. Water-based, semi-permanent mold release.

Composition

Aqueous emulsion of proprietary resins and cross-linkers with various surfactants.

Handling

Keep this water-based product from freezing and store below 100°F / 39°C.

Mix/agitate well before using.

Features

Easy spray or wipe on

Uses

Designed for use in all composite applications where high slip is needed, such as: RTM, Infusion, Solid Surface, etc.

Excellent for Modar®, Polyester, Vinyl Ester DCPD, Epoxy, Natural & Synthetic Rubber, & Polyurethanes
Non-cosmetic when applied by hand

Typical Properties

Solids	6.0%
pH	6.9
Color	Off-white
Specific Gravity	1.00 @25°C
Viscosity	<15cps @25°C
Flash Point	Non Flammable
Shelf Life	12 months in original unopened package

Mold Preparation

Mold surfaces should be clean and free of other surface contaminants. Previous mold release can be removed with CX-200HS Mold Stripper. Resinous build-up should be stripped using either AXEL CX-525 or CX-530 Mold Strippers for heated metallic molds, or CW-10NC for composite tools. After stripping the mold surface, AXEL CX-500, CX-501, or CX-502 should be used to remove any remaining residue from the mold surface.

Application Instructions – By Hand

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. AXEL also recommends 100%, bleached white, cotton cloths.

Wet the cloth with release until it is saturated but not dripping and wipe onto the mold surface using smooth even strokes until the film is uniformly applied without wiping marks. Application by hand to molds over 180°F/82°C should be avoided as the W-7806R will start to cure in place and leave a build-up on the mold surface. For temperatures over 180°F/82°C the W-7806R should be spray applied.

2 – 4 coats are recommended when applying for the first time. Allow the coating to dry between applications. However, it is not necessary for long cure times due to the chemistry of the W-7806R.

Application Instructions – By Spray

W-7806R can be sprayed. Spraying on molds over 180°F/82°C should only be done with quality spray equipment that properly atomizes the W-7806R in to a finely atomized film on to the mold surface. Plastic spray bottles or other lower quality spray equipment should only be used for lower temperature application (poor atomization on hot molds can result in a milky white build-up and dried drip or run marks which will then be difficult to remove). A cotton cloth or paper towel should be kept handy to wipe off any excess spray. HVLP type spray guns should be used for tools over 180°F/82°C

Touch-up coats (reapplication), when applied, should be cured for about 5 minutes at elevated temperature prior to restarting production. The W-7806R should, at a minimum, always be dry to the touch prior to molding.

Seasoned Tools with previous release agents:

For molds that are not stripped of previous mold release, one to two light coats can be applied to the mold and allowed to dry. XTEND W-7806R will work right over the top of most other semi-permanent release agents. Just a light coat, when necessary, is all that is needed.

Touch-up coats can be applied as needed depending on part geometry, size, tooling, etc.

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