

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet

**XTEND**™  
Semi-Permanent Mold Releases

# W-HGS

### Product Description

An air-drying, water-based, reactive resin solution that cures to provide a durable semi-permanent release coating. Provides multiple releases 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 carrier.

### Handling

Keep container closed when not in use.  
Store above freezing and below 100°F / 38°C.  
DO NOT DILUTE

### Features

Water-based  
Non-flammable  
High Slip

### Uses

Especially for applications requiring high slip. Ideal for mold flanges and as a replacement for edge wax. Also for use as mold release for EVA, polyurethane and epoxy. Will yield a semi-cosmetic finish.

If XTEND W-HGS is used for New or Green Composite Molds:

Apply 2-4 coats of XTEND XTR mold sealer prior to application of XTEND W-HGS.

### Typical Properties

Effective Ingredients	11.4%
Color	Off white
Specific Gravity	1.000 @25°C
Flash Point	Non-Flammable
Shelf Life	12 months in unopened/original container

### Mold Preparation

New & Green Composite Molds: Read AXEL publication Focus On 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, paper towel, such as the Scott Shop Towels On A Roll® or a heavy-duty plain white paper towel or cotton cloth.

#### In Mold APPLICATION:

Saturate the towel with release until it is wet but not dripping. Wipe onto mold surface using smooth even strokes. A circular motion is suggested until an even coating is applied free of standing droplets.

#### Flange or Edge APPLICATION:

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.

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. 2 coats of release are recommended for a clean well-conditioned tool. New tools and repaired area should be handled with special care.

Allow a minimum 15 minutes for each coat of release to dry and cure before applying the next coat. Low ambient temperatures (below 68°F / 20°C) may necessitate longer cure times. Always use a fresh, clean towel for each coat of release. Please allow at least 30 minutes cure time after the final coat is applied.

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 pull. Reapply release as needed, sheer edges radius points and high abrasion areas will require more frequent touch up.

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

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