

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

**XTEND**®  
Semi-Permanent Mold Releases

**XTR**  
Mold Sealer

### Product Description

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

### Composition

Proprietary resin solution in aliphatic solvent blend.

### Handling

MOISTURE SENSITIVE. KEEP TIGHTLY SEALED.  
CAUTION: Apply at ambient temperature, ideally above 65°F/18°C.  
DO NOT APPLY TO HOT MOLDS (OVER 350°F/ 177°C)  
Minimize exposure to atmosphere.  
Do not return exposed material to can.  
Store above freezing and below 100°F / 38°C.  
DO NOT DILUTE.

### Features

A wipe-on/wipe-off mold sealer that offers extra mold protection and enhances mold release performance.

Especially for new, green, or recently compounded FRP molds.

Recommended for treating mold repair areas.

### Uses

Mold sealer for FRP and metal tooling.

### Typical Properties

Effective Ingredients	<2%
Color	Clear/Pale Yellow
Specific Gravity	0.774 @25°C
Flash Point	90°F / 32°C (C.O.C)
Shelf Life	12 months in original unopened container
Solvents	Aliphatic Hydrocarbons
Odor	Paraffinic

### Mold Preparation

Mold surfaces should be clean and free of previously used sacrificial mold releases (like paste waxes, fluoropolymer releases etc.) and other surface contaminants, like dust, dirt, polishes, and residue from polishing or compounding.

Note: XTR sealer is compatible with most semi-permanent mold releases, and total stripping of molds is generally not required to apply XTR.

### Application

Apply 2 coats of XTR allowing approximately 15-20 minutes between each coat. Allow a minimum of 30 minutes before applying mold release.

Longer cure times between each coat and after the last coat is desirable, and should be considered when application is made at low temperature (below 60F/15C) or under cool temperatures with very high humidity.

Good cure is also important when using new molds; molding resin with long cure times; or working over repaired areas.

**New Molds, or porous molds (or porous repairs) may require one or more additional coats of mold sealer.**

### Application Method

1) Apply to ambient temperature molds by wiping with a clean, woven, paper 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.

2) Work in patches, applying a smooth, continuous light film over an area approximately 4'-6' (1.5 – 3 m) square, or a size that you can conveniently wipe before it dries. DO NOT OVER APPLY. The application should look just evenly wet – no puddles or drips.

3) As the sealer starts to flash off (on average 30 seconds to 1 minute), use a clean, dry paper cloth and wipe across the area using a circular motion and light to medium pressure. The goal is to simply even out the surface, not to totally dry, or polish it.

Wait until the remaining sealer is almost dry, approximately 30 seconds to 2 minutes, and then polish the area with a soft cotton cloth.

NOTE: The optimum time to polish will be affected by temperature and humidity. It will be easiest to polish the sealer while it is still slightly wet, however, if your polishing is difficult, or creates more streaks and smudges, you are polishing too soon - simply wait a bit longer and polish again.

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4) If any streaks remain after dry polishing the entire surface, simply use a paper cloth that is wet with sealer and wipe that area vigorously, then immediately wipe with the dry cloth and follow with dry polishing.

#### **Cure**

Allow the coated mold to cure for 30 minutes minimum ambient temperature before applying release.

#### **Removal**

May be removed by abrading (polishing), or, if chemical removal is preferred, CX-200HS Stripper or WCX water-based stripper are recommended.

\* 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.

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