

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

**XTEND**®  
Semi-Permanent Mold Releases

## AMS

### 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. Semi-permanent mold sealer.

#### 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. Also recommended for treating mold repair areas.

#### Uses

Mold sealer for FRP and metal tooling for most thermoset resin systems. Especially suited for polyester resins, such as: Iso, ortho, DCPD, and PET, as well as vinyl-ester resins.

#### Typical Properties

Effective Ingredients	<3%
Color	Straw
Specific Gravity	0.72 @25°C
Flash Point	<73°F / <23°C (C.O.C) TBD
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, over-spray, and residue from polishing or compounding.

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

#### Application

**Apply 2 coats of AMS 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 temperatures (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. Air movement is recommended for high humidity environments while the AMS is curing.

**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. 100%, bleached white, cotton cloths can also be used.

2) Work in patches, applying a smooth, continuous light film over an area approximately 4'-6' (0.3-0.8m<sup>2</sup>) square, or a size that you can conveniently wipe before it dries. A nice wet coat should be applied, but without runs, puddles, or drips.

3) As the sealer starts to flash off (3-15 seconds), use a clean, dry paper cloth, or cotton cloth to wipe the surface to a shine. This is done in three steps. a) Starting from the outside of the wet out area, and working towards the center, **wipe** over the area once. Then b) **flip** the cloth over to a dry side, and then c) wipe over the surface again using a hand **waving** motion. Firm, strong pressure is not necessary for a streak free, high gloss cosmetic (shine).

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4) If any streaks remain after polishing the entire surface, simply re-wet the streaked area with AMS Mold Sealer and wipe the area vigorously, then wipe off with a second dry cloth.

#### **Cure**

Allow the coated mold to cure for 30 minutes minimum at ambient temperature before applying release. Longer cure times should also be considered for new or repaired molds. Overnight cure for new molds is ideal.

#### **Removal**

May be removed by abrading (polishing), or, if chemical removal is preferred, XTEND CX-200HS Mold Stripper or XTEND WCX water-based Mold 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 an 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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