

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

**XTEND**®  
Semi-Permanent Mold Releases

## PR-20SP

primer

### Product Description

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

### Composition

Proprietary resin solution in solvent blend.

### Handling

MOISTURE SENSITIVE. KEEP TIGHTLY SEALED.

CAUTION: Apply at ambient up to 135°F temperature.

### 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 spray-on base coat that is used prior to sealer and release. Yields a glossy finish on molds and reduces porosity providing extra mold protection. Also helps reduce mold build-up.

### Uses

Used to resurface worn epoxy and FRP molds or to seal porosity in plugs.

### Typical Properties

Effective Ingredients	<15%
Color	Clear colorless liquid
Specific Gravity	0.734@25°C
Flash Point	<73°F / <23°C (C.O.C)
Shelf Life	12 months in original unopened container
Odor	Characteristic

### Mold Preparation

Mold surfaces should be clean and free of previously used mold releases and other surface contaminants.

### Application

**Apply a minimum of 2 coats of XTEND PR-20SP allowing a minimum of 15 minutes between each coat. Allow a minimum of one (1) hour after the final coat before applying mold sealer or release. Surfaces with extra**

**porosity may require additional coats of primer. Do not under cure.**

Longer cure times between each coat and after the last coat may be needed in cold shop environments or where there is poor air movement. Under-cured PR-20SP can feel tacky (sticky) to the touch when under-cured.

**New composite molds will require mold sealer in addition to XTEND PR-20SP.**

### Application Method

**Spraying:** PR-20SP can also be spray applied to the mold surface. Please read AXEL's technical document, "Focus on Spraying Semi-Permanents" for additional details. AXEL recommends an HVLP Spray gun with a 1.0mm to 1.8mm fluid nozzle. Also, AXEL recommends a small pressure pot be used in conjunction with the HVLP spray gun. Venturi type spray systems should not be used. It is also critical to install a moisture trap directly to the pressure pot to ensure all incoming air is free of moisture, oils, etc. All components of the spray equipment should be cleaned (lines flushed) when the spray equipment will go unused for more than 15 minutes.

*Note: If applying to ambient tools offline, a wipe on application can also be used.*

**Wipe-on:** Fold a clean, 100% cotton cloth into a neat pad. Saturate this with PR-20SP primer and use this to wipe on to the mold in long even strokes with a minimum of overlap between each row. Do not wipe back and forth. To avoid streaking, work in small areas approximately 3' x 3' or 1 meter sq. The coating must go on wet, but not puddle. Re-wet the application cloth as needed to maintain a consistent wet application. Dispose of the cloth after each coat of primer is complete. If the surface is large and the cloth becomes gummy before the job is complete, switch to a new cloth.

3) Allow the first coat of that XTEND PR-20SP to air dry for a minimum of 15 minutes. Do not cover the mold during this time.

4) Apply at least a second coat of the XTEND PR-20SP.

5) The PR-20SP treated surface should no longer feel tacky to the touch.

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## Cure

After the final coat of primer, allow the coated mold to cure for 1 hour minimum at ambient temperature before applying mold sealer and/or release. The surface should also completely resist a solvent wipe and not change in appearance if fully cured.

\* 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 can be transferred into the type of container described above. Drum quantity customers are required to use a desiccant drier attachment to assure proper release performance.

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