



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet



# S-19C

### 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. 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

**CAUTION: Do not apply to hot molds (over 300°F/148°C)**

### Features

Recommended for new, green or recently compounded FRP molds. Also used on aluminum molds prior to applying XTEND 800 or 802  
HAPS free

### Uses

Mold sealer for FRP and metal tooling.

### Typical Properties

Effective Ingredients	<5%
Color	Clear/Pale Yellow
Specific Gravity	0.730 @25°C
Flash Point	<73°F / 23°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 mold releases and other surface contaminants.

### New or Green Molds Application Instructions

Apply 4-6 coats of S-19C allowing 30 minutes between coats and a minimum of 1 hour after the last coat. Apply 4-6 coats of release after the sealer has cured, allowing 15-30 minutes between coats and a minimum of 30 minutes after the last coat.  
Re-apply mold release after the first part is pulled.

### General Application Instructions

1) Apply to ambient temperature molds by wiping with a clean, woven 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. Apply a smooth, continuous light film.

2) Do not over apply. Wipe on and let dry. Do not rub or rework.

3) A minimum of 2 coats are recommended. Wait at least 15 minutes between each coat.

### Cure

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

### Removal

Use CX-200HS.

\* 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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