

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

XTEND™
Semi-Permanent Mold Releases

W-3236R

Product Description

A semi-permanent, aqueous emulsion, external mold release agent that forms a uniform cured film on drying. Selective adhesion on the mold surface prevents the film from being torn off with de-molding.

Composition

Aqueous solution of proprietary resins and reactive surface modifiers.

Features

Easy, spray or wipe-on
High gloss
No HAPS

Uses

Specifically designed for hot molding of elastomers including silicone, polyacrylate, EPDM, fluororubbers, and polyurethanes for all molding surfaces.

Typical Properties

| | |
|-----------------------|-------------------|
| Effective Ingredients | < 3% |
| Color | Translucent White |
| Specific Gravity | 1.000 @25°C |
| Viscosity | <15cps @25°C |
| pH | 7.0 – 9.0 |
| Flash Point | Non Flammable |
| Shelf Life | 6 months |

Mold Preparation

In order for the release to work effectively, the mold must be thoroughly cleaned to remove previously used mold release and other surface contaminants, which may be incompatible.

New molds should be cleaned with solvent to remove protective lubricants and coatings. Molds coated with other semi-permanent release agents can be cleaned with CX-200HS of high pH detergent. Then, wipe down the mold with a cleaning solvent, such as: AXEL CX-500, and thoroughly dry the surface.

Application Instructions

- 1) Mix/shake well product before using.
- 2) Apply using a clean, woven, lint free cloth, such as the Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes, or even

a good, heavy-duty plain white paper towel. Wet the cloth with release until it is damp but not dripping and wipe onto the mold surface using smooth even strokes until the film is uniformly dry without wiping marks. Apply at room temperature or preferably on warm molds (up to 165°C/330°F).

The release performs best when sprayed on hot molds (preferably 80°C/ 180°F or higher). A very fine atomized spray should be used. The W-3236R should be applied in a thin even film.

Multiple coats (2-4) may be necessary to achieve a proper, uniform base coat of the release. Allow the coating to dry between applications – no cure time is necessary. Best results are attained when the initial application is allowed to cure at 200F-400°F/ 93-200°C prior to the first release. Only a few minutes of cure is necessary.

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