



PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet



W-440HG

Product Description

An air-drying, water-based, release agent that cures to provide a durable semi-permanent release coating. Provides multiple releases at both ambient and elevated temperatures. Ideal for production of high gloss parts. Also, ideally suited for low to medium slip applications.

Composition

Aqueous emulsion of proprietary resins and crosslinkers with various surfactants.

Handling

Keep container closed when not in use.
Store above freezing and below 100°F / 38°C when possible.
DO NOT DILUTE

Features

Water-based
Non-flammable
High gloss
Slip

Uses

XTEND-W-440HG is recommended for the release of epoxies, polyesters, vinyl-esters, phenolics, and most thermoset resins. Especially for production of highly cosmetic parts.

If XTEND W-440HG is used for New or Green Composite Molds: Apply 1-2 coats of XTEND XTR or AMS mold sealer prior to application of XTEND W-440HG.

Typical Properties

Effective Ingredients	4.7%
Color	white
Specific Gravity	0.999
Flash Point	Non-Flammable
Shelf Life	12 months in unopened/original container

Mold Preparation

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

APPLICATION

Apply with a clean, paper towel, such as the Scott Shop Towels On A Roll, or a heavy-duty plain white paper towel or cotton cloth. Saturate the towel with release until it is wet but not dripping. Wipe onto mold surface using smooth even strokes. A circular application motion is suggested until the W-440HG is evenly wet-out on the mold surface.

For high gloss applications, lightly buff the surface using a microfiber towel within 1-2 minutes of application. When the gloss is not important, the W-440HG can be wiped off with a paper towel or cotton cloth.

When working on a large surface area, apply to one section at a time, working from one end of the tool surface to the other. 2-3 coats of release are recommended for a clean, well-conditioned tool.

Allow a minimum 15 minutes for each coat of release to dry and cure before applying the next coat. Low ambient temperatures (below 68°F / 20°C) require longer cure times. Always use a fresh, clean towel for each coat of release. Please allow at least 30 minutes cure time after the final coat is applied. Longer cure times will provide more parts before reapplication is needed.

To maximize productivity, a break-in procedure can be beneficial. A good method is to apply a light re-wipe of release to the entire mold surface following the first pull. After the first part, reapply release as needed to sheer edges radius points and high abrasion areas (these may require a more frequent touch up). Reapply to the entire mold as needed.

Removal: Use CX-200HS, followed by a water wipe, and then a high-performance cleaner, such as AXEL's CX-500, CX-501, or CX-502.

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