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Technical Data Sheet

XTEND® PR-50ES Mold Primer

Product Description:

Proprietary resin solution that levels the mold surface, enhances gloss, and provides a better surface for Mold Sealers and Release Agents

Use: Used to protect new molds, especially b-sides, or rough surfaces, or molds with complex geometries. Also used to resurface worn epoxy and FRP molds, as well as to eliminate or minimize porosity in most composite and metal molds.

Composition:

Proprietary resin solution in solvent blend which crosslinks and form a primer film upon evaporation of the solvent carrier.

Handling:

MOISTURE SENSITIVE. KEEP TIGHTLY SEALED. Minimize exposure to atmosphere. Do not return exposed material to can. Store above freezing and below 100°F / 38°C. DO NOT DILUTE

Instructions for Use:

Mold surfaces should be clean and free of previously used mold releases and all/any other surface contaminants. Examples of mold contamination include compounds, polishes, dust, wax, other release agents or sealers, etc.

Application

Apply 1-3 coats of XTEND PR-50ES allowing one (1) hour between each coat. Allow a minimum of two hours after the final coat before applying mold sealer or release. For challenging mold geometries, or aggressive resin systems four hours or more (overnight) are recommended for cure. The surface should be completely dry and tack free before applying additional coats. Surfaces with extra porosity may require additional coats of primer. Do not under cure. A quick solvent wipe can be used to see if the surface is affected (aggressed) or not. The solvent wipe should have no effect on the PR-50ES surface.

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-50ES can feel tacky (sticky) to the touch when under-cured.

FEATURES:

Only 1-2 coats needed	Improves release performance
High Gloss	Lowers release usage
Reduces mold release/resin build-up	Lengthens mold life

TYPICAL PROPERTIES:

EFFECTIVE INGREDIENTS	<15%
COLOR	Straw colored liquid
SPECIFIC GRAVITY	0.87@25°C
FLASH POINT	<73°F / <23°C (C.O.C)
SHELF LIFE	Six (6) months after opening, or 12 months from the date of manufacture, or whichever comes first
ODOR	Characteristic

Application Method

APPLY AT AMBIENT or WARM TEMPERATURE. Cold and excessively damp conditions can impact cure.

Wipe-on: Fold a clean, 100% cotton cloth or industrial paper shop towel into a small square. Saturate with PR-50ES 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 sticky or rubbery before the application is complete, switch to a new cloth.

1. Allow the first coat of XTEND PR-50ES to air dry for one (1) hour. Do not cover the mold during this time. The coat of PR-50ES must be tack free.
2. For higher gloss mold surfaces only one coat may be necessary (a second coat may appear streaky) For matte or rough mold surfaces, apply a second coat of XTEND PR-50ES. Cure for 60 minutes before applying a third coat.
3. Allow a final cure of at least two hours at ambient. The PR-50ES treated surface should no longer feel tacky to the touch. The surface should also completely resist a solvent wipe and not change in appearance if fully cured.
4. When applying additional coats on porous surfaces, PR-50ES will start to bead during application when the maximum saturation point has been reached. On very porous tooling board, or sanding primers, for example, this can take as many as ten coats to fully saturate the surface, (although it is not always necessary to fully saturate the tooling surface).

Cure

After the final coat of primer, allow the coated mold to cure for 2-4 hours minimum at ambient temperature before applying mold sealer and/or release. AXEL suggests an overnight-cure whenever possible.

* 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.

Review SDS before use.