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## Technical Data Sheet

# XTEND<sup>®</sup> ACR-HS External Mold Release

### Product Description:

XTEND ACR-HS is an advanced composite release agent. Specifically designed for composite patterns, tooling and highly visual components. Giving high slip, high gloss surface finish for complex parts, made using epoxies and other thermoset resins. Typically applied between each moulding.

### Use:

Epoxies, Polyesters, Vinyl-esters, Phenolics & most thermoset resins, suitable for ambient, autoclave and elevated temperature moulding.

### Composition:

Proprietary resin solution comprising modified siloxane-based polymers which crosslink and form a release 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:

To achieve high levels of gloss and surface finish, AXEL advises using XTEND PR-ACP Primer to the tooling substrate prior to release agent application.

To maximise release performance and to reduce mould wear and build up, 1-2 coats of XTEND UMS mold sealer is recommended prior to application of XTEND ACR-HS. This further protects the tool from wear, especially when using aggressive resin systems.

### Wipe On & Quick Wipe Off Application:

Wet the paper towel with XTEND ACR-HS until it is wet but not dripping. Gently squeeze the towel into a ball to soak the AXEL XTEND ACR-HS throughout the towel. Wipe on to the mold surface using smooth even strokes. Apply a thin, uniform coating and allow the release agent to evaporate. Then using a clean cloth lightly wipe over the surface removing any excess release agent. Curing time is dependent on environmental conditions such as tool and room temperature, 15-20 min between coats is advised.

2-3 coats of AXEL XTEND ACR-HS is recommended for most applications. Followed by 1 touch up coat between parts.

### Spray Application:

Use an HVLP or similar spray gun suitable for spraying low viscosity solvents. Air lines must be moisture and contaminant free (use an air/water filter separator). Please consult AXEL if you are not familiar with applying by spray before attempting.

Adjust spray equipment to deliver a light spray mist. Whenever possible, spray at approximately 9-15" (roughly 20-45 cms) away from the mould surface. The spray pattern should be setup and adjusted using cardboard or craft paper to determine a completely atomized spray with as little over-spray as possible.

Apply 3-5 light to moderate coats depending on process and resin. Do not apply heavy coats. Allow each coat to dry and cure before applying the next

### FEATURES:

Wipe on leave on Spray on Leave on	Low odor
Quick application	Can apply by hand/cloth to at least 160°C/320°F
High Gloss surface finish	

### TYPICAL PROPERTIES:

<b>COLOR:</b>	Clear
<b>SPECIFIC GRAVITY:</b>	0.710 – 0.730 @ 25°C / 77°F
<b>VISCOSITY:</b>	0 – 15 cps @ 25°C / 77°F
<b>FLASH POINT:</b>	<23°C / <73.4°F (C.O.C.)
<b>SHELF LIFE:</b>	One year from date of manufacture

coat – this time will vary depending on the mould temperature.

**FINAL CURE:**

After the final coat allow 60 minutes cure time at room temperature. Elevated mould temperatures will reduce final cure time.

Review SDS before use.