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Technical Data Sheet

XTEND® PR-ACP Mold Primer

Product Description:

A high-gloss tool primer that maximizes surface sealing and eliminates substrate porosity.

Use:

Used to condition the surface of CFRP Molds & FRP Molds. Epoxy/PU & Hybrid tooling boards including 3D printed tooling. This eliminates and minimizes porosity in most tooling substrate materials. Can be used to resurface or recondition old or worn tooling.

Composition:

Proprietary resin solution in solvent blend.

Handling:

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

SOLO (Spray on Leave on) Application

Apply, at room temperature, 2-6 coats of XTEND PR-ACP depending on the porosity of the tooling substrate, allowing a minimum of 15 minutes between each coat. The surface should be completely dry and tack free before applying additional coats. Surfaces with extra porosity may require additional coats of primer.

Allow a minimum of one hour after the final coat before applying mold sealer or release

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

FEATURES:

Clear	High sealing capability
High gloss	SOLO & WOLO
Easy, quick application	Fast cure

TYPICAL PROPERTIES:

COLOR	Clear/Straw
SPEC GRAVITY	0.76-0.8
FLASH POINT	<23 °C / <73.4 °F
SHELF LIFE	1 Year from date of manufacture
ODOR	Light solvent odor

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 Equipment

Spray gun: HLVP or equivalent
 Gun pressure: to not exceed 40-60 Psi
 Nozzle diameter: between 0.8mm - 1.3mm
 Spray fan: Set to medium
 Apply at a distance: 100mm/4 inch from substrate

WOLO (Wipe on Leave On) Application

Apply 2-6 coats of XTEND PR-ACP depending on the porosity of the tooling substrate. Use a clean lint free cloth or paper towel, wipe on in a straight line overlapping between applied edges. Ensure to change cloth each coat. Allowing a minimum of 15 minutes between each coat at room temperature. The surface should be completely dry and tack free before applying additional coats. Surfaces with extra porosity may require additional coats of primer. Allow a minimum of one hour after the final coat before applying mold sealer or release

Review SDS before use.