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Technical Data Sheet

XTEND® 1620 External Mold Release

Product Description:

XTEND 1620 is an advanced composite release agent designed for epoxies and other thermoset resins. Typically applied between each moulding. Designed for minimum to no build up.

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

Wipe-On Leave-On Application:

Wet the paper towel with XTEND 1620 until it is wet but not dripping. Gently squeeze the towel into a ball to soak the AXEL XTEND 1620 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. 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 1620 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 semi-permanents 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 mold 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 coat – this time will vary depending on the mold 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.

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
Low transfer	

TYPICAL PROPERTIES:

COLOR	Clear
SPECIFIC GRAVITY	0.69-0.73
FLASH POINT	<23 °C / <73.4 °F
SHELF LIFE	1 Year from Date of Manufacture

Instructions for Use:

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

To maximize 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 1620. This further protects the tool from wear, especially when using aggressive resin systems.