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Technical Data Sheet

XTEND® ACR-WB Mold Release

Product Description: A water-based semi-permanent mould release, which provides multiple releases prior to reapplication for advanced composite applications.

Use:
 Designed for use in advanced composite applications where high slip and high surface finish is required. Suitable for epoxy prepreg laminates, resin infusion and compression moulding.

Composition:
 Aqueous emulsion of proprietary resins and cross-linkers with various surfactants, which crosslink and form a semi-permanent release film upon evaporation of the water carrier.

Handling:
 Keep this water-based product from freezing. Use and store below 100°F/39°C. MIX OR SHAKE WELL BEFORE USING. Review SDS before use.

followed by a water-wash, and then AXEL CX-500 Mold cleaner. This will remove any remaining residue from the mold surface.

Hand application Instructions –
 Apply using a clean, woven, lint free cloth, heavy-duty plain paper towel or microfibre cloth, AXEL also recommends bleached white, 100%, cotton cloths.

Wet the cloth with release until it is saturated but not dripping and wipe onto the mold surface using smooth even strokes until the film is uniformly applied without wiping marks. If the cloth becomes overly saturated, a second or new cloth can be used to wipe off any excess. Wait 15 mins before applying the next coat. 3 coats maximum. After the 3rd coat is applied, buff the tool surface with a clean cloth or microfibre cloth, until the tool is to the desired gloss level.

After 1-3 parts removal only one (1) re-application coat is needed.

Spray application Instructions –
 XTEND® ACR-WB can be sprayed. Spraying on molds over 180°F/82°C should only be done with quality spray equipment that properly atomizes the XTEND® ACR-WB to a finely atomized film onto the mold surface. Plastic spray bottles or other lower quality spray equipment should only be used for lower temperature applications (poor atomization on hot molds can result in a milky white build-up and dried drip or run marks which will then be difficult to remove). A cotton cloth or paper towel should be kept handy to wipe off any excess spray. HVLP type spray guns should be used for tools over 180°F/82°C, XTEND ACR-WB can also be used at ambient temperatures.

Touch-up coats (reapplication), when applied, should be cured for about 5 minutes at elevated temperature prior to restarting production. The XTEND® ACR-WB should, at a minimum, always be

FEATURES:

Non-flammable	Easy spray or wipe on
Water-based	High Slip

TYPICAL PROPERTIES:

SOLIDS:	4.5 – 6.5%
COLOR:	Off-white
SPECIFIC GRAVITY:	0.990 - 1.010 @ 25°C/77°F
VISCOSITY:	0 – 15 cps @ 25°C / 77°F
pH:	6.5 – 8.5
FLASH POINT:	Non-flammable
SHELF LIFE:	One year from date of manufacture

Instructions for Use:

Mold Preparation

Mold surfaces should be clean and free of other surface contaminants. Previous mold release can be removed with AXEL's Aqua-Clean Mold Stripper,

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dry to the touch prior to molding. A 30-minute minimum cure time is recommended for ambient cure.

Seasoned Tools with previous release agents:

For molds that are not stripped of previous mold release, one to two light coats can be applied to the mold and allowed to dry. XTEND® ACR-WB will work right over the top of most other semi-permanent release agents. Just a light coat, when necessary, is all that is needed.

Touch-up coats can be applied as needed depending on part geometry, size, tooling, etc.

Review SDS before use.