



Technical Data Sheet

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XTEND® PR-GCP Mold Primer

Product Description:

For use on gloss tools where cosmetics are a high concern. Lower solids and slower flashing to aid application on high gloss surfaces. Must be used as a WOWO.

Anytime a primer is used in conjunction with a sealer or semi-permanent release agent parts will release easier and tool life will increase due to a smoother, harder surface that promotes adhesion of sealers and releases.

Use:

Used to condition the surface of rigid gloss tools such as PE, VE, epoxy gel coat, aluminum, steel, and plated tooling. This eliminates and minimizes porosity in most tooling substrate materials. For use under 250°F/121°C.

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

Review SDS before use.

Instructions for Use:

Follow AXEL's Stripping and Cleaning procedure. Mold surfaces should be clean and free of previously used mold releases and any/all surface contaminants. Examples of mold contamination include compounds, polishes, dust, wax, other release agents or sealers, etc. Dry ice blasting is recommended on heavily contaminated surfaces, followed by cleaning with XTEND CX-500.

Note: This product has no release properties and must be top coated with a mold release system.

WOBO (Wipe on Buff Off) Application:

High quality microfiber cloths with a polyester to polyamide ratio of 80/20 are recommended to speed buffing process.

Apply 1-2 coats of XTEND PR-GCP on high gloss tooling surfaces.

Work in patches, applying a smooth, continuous light film over an area approximately 2'-3' square (0.61m²), or a size that you can conveniently wipe before it dries. An even coat should be applied, but without runs, puddles, or drips.

As the XTEND PR-GCP starts to flash off, use a clean, dry microfiber cloth to buff the surface to a shine.

This is done in three steps.

- 1) Starting from the outside of the wet out area, and working towards the center, wipe over the area once.
- 2) Flip the cloth over to a dry side
- 3) Wipe over the surface again using a hand waving motion.

If any streaks remain after polishing the entire surface, simply re-wet the streaked area with XTEND PR-GCP Mold Primer and wipe the area vigorously, then wipe off with a second, dry microfiber cloth.

A second coat is recommended on gel coated tooling. Allow 20 minutes between coats, change to a new cloth after each coat. Allow one (1) hour of dry time before further coating or processing.

FEATURES:

Clear	High sealing capability
Minimal build	WOBO
Easy, quick application	Fast and hard cure

TYPICAL PROPERTIES:

COLOR	Clear/Straw
SPEC GRAVITY	0.75-0.79
FLASH POINT	<23 °C / <73.4 °F
SHELF LIFE	1 Year from date of manufacture
ODOR	Light solvent odor
COLOR	Clear/Straw