

# AXEL

PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

**XTEND**®  
Semi-Permanent Mold Releases

## PR-10

primer

### Product Description

Proprietary resin solution comprising modified polymers which crosslink and form a primer film upon evaporation of the solvent carrier.

### Composition

Proprietary resin solution in solvent blend.

### Handling

MOISTURE SENSITIVE. KEEP TIGHTLY SEALED.

CAUTION: Apply at ambient temperature.

### Minimize exposure to atmosphere.

Do not return exposed material to can.

Store above freezing and below 100°F / 38°C.

### DO NOT DILUTE

### Features

A spray-on or wipe-on base coat that is used prior to sealer and release. Yields a glossy finish on molds and reduces porosity providing extra mold protection.

Used to resurface worn epoxy and FRP molds or to seal porosity in plugs.

### Uses

Matte base coat for FRP and other mold surface.

### Typical Properties

Effective Ingredients	<15%
Color	Clear colorless liquid
Specific Gravity	0.87@25°C
Flash Point	<73°F / <23°C (C.O.C)
Shelf Life	12 months in original unopened container
Odor	Characteristic

### Mold Preparation

Mold surfaces should be clean and free of previously used mold releases and other surface contaminants.

### Application

**Apply 2 coats of XTEND PR-10 allowing a minimum of 1 hour between each coat. Allow a minimum of 4 hours after the final coat before applying mold sealer or release. Surfaces with extra porosity may require additional coats of primer. Do not under cure.**

Longer cure times between each coat and after the last coat is desirable.

**New Molds will require mold sealer in addition to XTEND PR-10.**

### Application Method

APPLY AT AMBIENT TEMPERATURE. Cold and excessively damp conditions can impact cure.

**Wipe-on:** Fold a clean, 100% cotton cloth into a neat pad. Saturate this with PR-10 primer and use this to wipe on to the mold in long even strokes with a minimum of overlap between each row. Do not wipe back and forth. To avoid streaking, work in small areas approximately 3' x 3' or 1 meter sq. The coating must go on wet, but not puddle. Re-wet the application cloth as needed to maintain a consistent wet application. Dispose of the cloth after each coat of primer is complete. If the surface is large and the cloth becomes gummy before the job is complete, switch to a new cloth.

3) Allow the first coat of that XTEND PR-10 to air dry for 1 hour minimum. Do not cover the mold during this time.

4) Apply a second coat of that XTEND PR-10.

**Surfaces with extra porosity may require additional coats of primer. Do not under cure.**

### Cure

After the final coat of primer, allow the coated mold to cure for 4 hours minimum at ambient temperature before applying mold sealer and/or release.

**Spraying:** XTEND PR-10 can also be applied by spraying, rather than wiping on. Please read AXEL's technical documents on spraying semi-permanents. HVLP spray equipment with proper fluid tips to accommodate the higher viscosity of PR-10 should be used. Please consult with your equipment manufacturer for the best choice. It is also critical that all air lines are equipped with moisture traps. Equipment should be thoroughly cleaned after each use.

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\* Due to the unique properties of this material, we require a clean closed application container. The container we find best suited, is a HDPE bottle with a shampoo squeeze style cap, where only a small amount of air is transferred. Gallons can be transferred into the type of container described above. Drum quantity customers are required to use a desiccant drier attachment to assure proper release performance.

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