AXEL
PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

Mailing: Box 77 0855 Woodside, NY 11377 USA
Shipping:58-20 Broadway, Woodside, NY 11377 USA
Phone: 718-672-8300 • Fax: 718-565-7447
E-mail: info @axelplastics.com

www.axelplastics.com

Technical Data Sheet

XTEND®
Semi-Permanent Mold Releases

PR-20
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.
Minimize exposure to atmosphere.
Do not return exposed material to can.
Store above freezing and below 100ºF / 38ºC.
DO NOT DILUTE

Features
A 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. Also helps reduce mold build-up.

Uses
Used to resurface worn epoxy and FRP molds, as well as to eliminate or minimize porosity in most composite and metal molds.

Typical Properties

Effective Ingredients	<15%
Color	Clear colorless liquid
Specific Gravity	0.87@25ºC
Flash Point	<73ºF / <23ºC (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 a minimum of 2 coats of XTEND PR-20 allowing a minimum of 15 minutes between each coat. Allow a minimum of one(1) 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 may be needed in cold shop environments or where there is poor air movement. Under-cured PR-20 can feel tacky (sticky) to the touch when under-cured.

Application Method
APPLY AT AMBIENT or WARM TEMPERATURE. Cold and excessively damp conditions can impact cure.

Wipe-on: Fold a clean, 100% cotton cloth into a small square. Saturate this with PR-20 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 XTEND PR-20 to air dry for a minimum of 15 minutes. Do not cover the mold during this time.

4) Apply a second coat of XTEND PR-20.

5) Allow a final cure of at least one hour at ambient. The PR-20 treated surface should no longer feel tacky to the touch. The surface should also completely resist a solvent wipe and not change in appearance if fully cured.

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

6) When applying additional coats on porous surfaces, PR-20 will start to bead during application when the maximum saturation point has been reached. On very porous tooling board, or sanding primers, for example, this can take as many as ten coats to fully saturate the surface, (although it is not always necessary to fully saturate the tooling surface).

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PR-20

Primer

Cure

After the final coat of primer, allow the coated mold to cure for 1 hour minimum at ambient temperature before applying mold sealer and/or release.

New composite molds will require mold sealer in addition to XTEND PR-20.

* 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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