



PLASTICS RESEARCH LABORATORIES, INC.  
MOLD RELEASES & PROCESS ADDITIVES

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## Technical Data Sheet



# XTEND 19RSS

### Product Description

External mold release. An air-drying reactive resin solution that cures to a cross-linked semi-permanent coating, which provides multiple release without transfer.

### Composition

Proprietary resin solution in aliphatic hydrocarbon solvent blend.

### Handling

MOISTURE SENSITIVE. KEEP TIGHTLY SEALED.  
Minimize exposure to atmosphere.  
Do not return exposed material to can.  
Store above freezing and below 100°F / 39°C.  
DO NOT DILUTE

### Features

Very High slip coating.  
Fast curing.  
No sealer required.  
Highly durable coating

### Uses

Designed for use in Solid Surface molding, open and closed molding and non-cosmetic gel coated applications or non-gel coated applications.  
400°F/204°C with Modar®, Polyester, Vinyl Ester DCPD, Epoxy, Natural & Synthetic Rubber, & Polyurethanes.  
Excellent for most thermoset applications that do not require a high gloss, Class "A" type finish.

### Typical Properties

Effective Ingredients	1-3%
Color	Clear/Pale yellow
Specific Gravity	0.73 @ 25°C
Flash Point	<73°F / <23°C (C.O.C.)
Shelf Life	12 months in unopened/original container
Solvents	Aliphatic Hydrocarbons

### Mold Preparation

New & Green FRP Molds:  
Read AXEL publication FocusOn New & Green Molds.  
Conditioned & Metal Molds:  
Mold surfaces should be clean and free of previously used mold releases and other surface contaminants.

### Application Instructions

May be applied by wiping or spraying.

#### WIPE-ON

Wet a clean, woven, lint free cloth, such as the Scott Shop Towels On A Roll®, Kimberly-Clark WorkHorse® rags or WypAll® wipes, or a heavy-duty plain white paper towel with release.

Working in small areas, wipe on a smooth light film. Do not over apply. Do not rub or rework. Allow to dry. Continue application until entire mold is coated.

Apply 3 coats of release allowing approximately 15 minutes between each for drying and curing.

#### 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 9-15" 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 2-3 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.

#### Cure

XTEND 19RSS should be cured for 30-60 minutes at ambient after all initial coats have been applied.

#### Break In

Apply one coat of release after the first part. This will extend release productivity.

#### Touch Up

Wipe or spray on touch up coats as needed.

\* Due to the unique properties of this material, we require a clean closed application container. For hand application, 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 should be transferred into the type of container described above.

At your request we can supply a sample and source. Drum quantity customers are required to use a desiccant drier attachment to assure proper release performance.

### **Maintenance**

Minor buildup can sometimes be removed by using XTEND 19RSS to dissolve and remove residue.

If the residue does not dissolve, lightly work over the tool with a Scotchbright<sup>®</sup> pad wet with XTEND 19RSS, then apply one coat of release.

If build up persists: Wipe off with AXEL's CX-500 cleaner and a Scotchbright<sup>®</sup> pad. (This cleaner is designed to take off the residual buildup without removing the base coat of release.) Then wipe on 1 to 2 coats of XTEND 19RSS, waiting 10 minutes between each coat.

In extreme scumming conditions, or for warm molds (usually associated with closed molding applications): Strip the tool with CX-525 (a cleaner especially formulated to remove resin and release build up). Re-apply mold release after use.

Removal: Use CX-200HS, followed by a water wipe and a good general purpose cleaner, such as AXEL's CX-500.

The key to easy, consistent releases is maintaining molds through balanced use of release and cleaner. To further optimize the closed molding process we also recommend using an internal mold release.

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