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Technical Data Sheet

XTEND[®] W-9165 Mold Release

Product Description:

An air-drying, **water-based**, release agent that cures to provide a durable semi-permanent release coating. Provides multiple releases at both ambient and elevated temperatures. Ideal for production of high gloss parts. Also, ideally suited for low to medium slip applications.

Use:

XTEND W-9165 is recommended for the release of epoxies, polyesters, vinyl-esters, phenolics, and most thermoset resins. Especially for production of highly cosmetic parts. If XTEND W-9165 is used for New, Green, or Composite Molds: Apply 1-2 coats of XTEND UMS mold sealer prior to application of XTEND W-9165.

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 container closed when not in use. Store above freezing and below 100°F/38°C when possible. **DO NOT DILUTE** Some phase separation is normal – shake or remix.

Instructions for Use:

Mold Preparation

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

APPLICATION



Wipe-On Use a 100% white cotton cloth. Water-based sealers and release agents do not easily absorb into a cotton cloth as solvent-based sealers and release agents do.

AXEL suggests forming the cloth in your hand into the shape of a cup or bowl. The W-9165 is then poured into the center of the cloth and then a soft squeeze is used to wet the W-9165 throughout the cloth. Paper or cheesecloth/muslin towels are not recommended. Wipe onto mold surface using smooth even strokes. A circular application motion is suggested until the W-9165 is evenly wet-out on the mold surface.

For high gloss applications, lightly buff the surface using a microfiber towel before the W-9165 begins to evaporate. When the gloss is not important, the W-9165 can be wiped off with a paper towel or cotton cloth.

When working on a large surface area, apply to one section at a time, working from one end of the tool surface to the other. 2-3 coats of release are recommended for a clean, sealed, well-conditioned tool. Allow a minimum 30 minutes for each coat of release to dry and cure before applying the next coat. Low ambient temperatures (below 68°F / 20°C) require longer cure times. Always use a fresh, clean towel for each coat of release. Please allow at least 60 minutes cure time after the final coat is applied. Longer cure times will provide more parts before reapplication is needed.

To maximize productivity, a break-in procedure can be beneficial. A good method is to apply a light re-wipe of release to the entire mold surface following

FEATURES:

Water-based	High gloss
Non-flammable	High Slip
Low VOCs	No HAPs

TYPICAL PROPERTIES:

SOLIDS:	8.10 %
COLOR:	White
SPECIFIC GRAVITY:	0.990 @ 25° / 77°F
VISCOSITY:	0 – 15 cps @ 25° / 77°F
pH:	8.10 @ 25° / 77°F
FLASH POINT:	Non-flammable
SHELF LIFE:	One year from date of manufacture

the first pull. After the first part, reapply release as needed to shear edges radius points and high abrasion areas (these may require a more frequent touch up). Reapply to the entire mold as needed.

Removal: Use Aqua-Clean 220, followed by a water wash/dry, and then a high-performance cleaner, such as AXEL's CX-500, CX-501, or CX-502.

Review SDS before use.