

AXEL

PLASTICS RESEARCH LABORATORIES, INC.
MOLD RELEASES & PROCESS ADDITIVES

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Technical Data Sheet

XTEND™
Semi-Permanent Mold Releases

WCX

Roto Mold Stripper

Product Description

A non-flammable, non-corrosive water-based stripper specifically designed for stripping mold release build-up or plate out of color on mold surfaces; May also be used on new molds to strip residue of cutting oils and blasting media that may remain as surface contaminants.

Composition

A complex formulation of surface-active and cleaning agents in combination with fine abrasive particles.

Handling

Keep this water-based product from freezing.
Use and store below 100°F / 39°C.
It is normal for this product to phase separate.
MIX OR SHAKE VERY WELL BEFORE USING.

Features

Water-based stripper

Uses

Recommended for light to medium build-up of mold release, or plate out from color. Also recommended for cleaning surface contaminants (cutting oils and blast media) from new molds before applying release.

NOT recommended for removing heavy buildup. If WCX is not effective, AXEL's CX-200HS stripper may be considered.

Use at ambient temperature.

Typical Properties

Color	White
Specific Gravity	Heavy liquid @ 25°C
Viscosity	Heavy Liquid
pH	8.9
Flash Point	Non-Flammable (>232°F)
Shelf Life	12 months in original unopened package
Packing	Plastic containers

Application Instructions

USE FULL STRENGTH. DO NOT DILUTE.

1) MIX/SHAKE VERY WELL. Apply liberally to mold at room temperature using a paper shop towel, clean cotton cloth, or, where suitable, a cleaning pad, such as 3M's Scotch Brite®

(note: these pads are available in a variety of styles, from low to high abrasion – select one that is appropriate for your mold surface) to work the cleaner over the surface. Firm pressure and a circular motion work best. If mold is not high gloss, brushes or other types of cleaning pads can be used. After working over the entire surface with stripper, the mold should appear wet with WCX but there should not be puddles.

2) Allow to stand for 10-20 minutes to penetrate. The mold may look greasy or hazy.

3) Use a clean paper cloth, or a clean cotton cloth to wipe off as much of this haze or residue of the stripper before proceeding to the next step. When wiping/polishing off, a firm circular motion works well. Also, turn the cloth frequently to a clean side as you wipe.

4) Use another clean cloth (cotton is preferred) and a bucket of water (hot water is preferred) to thoroughly water wash the mold. Rinse the cloth out frequently as you water wash in a firm circular motion. Initially, water droplets on the mold surface will be large in size, but as you continue to wash they will become smaller and smaller, indicating that you have completed the water wash process.

5) Next, dry the mold surface with paper shop towels or another clean cotton cloth.

6) Although WCX can be used as a stand-alone product, it can also be used in conjunction with other cleaners or strippers.

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