

# G471 XK-22 LV.5 Releasomers™

## Semi-Permanent Solvent Based Mold Release



### Product Description

Stoner<sup>®</sup> G471 XK-22 LV.5 Releasomers™ is a unique, highly effective semi-permanent mold release agent designed to release epoxy and phenolic resin systems. It combines fast cure with outstanding chemical and abrasion resistance. It gives a smooth, continuous film with unmatched adhesion to the mold.

#### XK-22 LV.5 ADVANTAGES:

- Non-silicone, non-contaminating release surface.
- Application temperature up to 400°C (750°F).
- Tough, abrasion resistant film.
- Cures at ambient temperatures.
- Excellent adhesion to mold surfaces.
- Can be applied by wiping, spraying, or brushing.
- No need to wipe off if applied to a heated mold.
- Stable resin solution - excellent shelf life.

### Uses

Stoner<sup>®</sup> G471 XK-22 LV.5 is designed to release epoxy or phenolic resins when compression molding, resin transfer molding, or vacuum infusing.

### Directions for Use

#### Recommended Procedure

1. The mold surface should be thoroughly cleaned of all contaminants such as oils, grease, wax, dirt, or previous release agents by dry ice cleaning, abrasive pads,

or compounds followed by KantStik<sup>®</sup> Mold Cleaner. The cleaned surface should be completely dry. Then apply 2 coats of KantStik<sup>®</sup> Sealer 1.0 following the instructions on the KantStik<sup>®</sup> Sealer 1.0 TDS.

2. XK-22 LV.1 can be applied by wiping with a clean cotton cloth. Make sure of complete and uniform coverage of the surface. Wait approximately 30-60 seconds after applying and wipe the excess release agent with a clean, dry cotton cloth or microfiber towel. If applying onto a heated mold (minimum 100°C), there is no need to buff the coating.
3. Apply a total of 5 coats of XK-22 LV.1, allowing each coat to cure for 15 minutes prior to applying the subsequent coat. Wait at least 30 minutes after the final coat before placing the mold into production.

**Note: An overnight cure will substantially increase the number of release cycles before a touch up is required.**

### Storage and Handling

Stoner<sup>®</sup> Releasomers™ XK-22 LV.5 is supplied in solvent solution.

**CAUTION: FLAMMABLE.** Use with adequate ventilation. Keep away from heat, sparks, and open flames. Avoid prolonged or repeated breathing of vapors. Avoid prolonged or repeated skin contact. Keep container closed when not in use.

### Packaging

Stoner<sup>®</sup> G471 XK-22 LV.5 Releasomers™ available in:

- 1-gallon Part # G471GLSTON01
- 5-gallon pails Part # G471PLSTON01
- 55-gallon drum Part # G471DRSTON01

### Technical Assistance

Call: 800-227-5538 or 1 (717) 786-7355  
Email: CustomerService@StonerMolding.com  
Visit: StonerMolding.com

**NO RISK GUARANTEE.** Stoner Molding guarantees 100% satisfaction or your money back. If you're ever dissatisfied with any Stoner Molding product, simply return the unused portion for a full refund.

