

**Stoner** Molding  
Solutions®  
You Mold It. We Release It.™

## G471 Releasomers™ XK-22GLV.5 Semi-Permanent Solvent Based Mold Release

### G471 Releasomers™ XK-22LV.5 Carbon Fiber Release Success

A molder of carbon fiber bike parts had issues with mold release and epoxy buildup on precision steel tools. After an extended search for an improved release, Stoner Releasomers XK-22LV.5 was chosen to improve the process. Molders saw an increase in the number of parts released prior to mold cleaning and improvement in the number of parts produced.

**G471 Releasomers™ XK-22LV.5** is a solvent based release containing a unique resin for carbon fiber molding. The solvent carrier is optimized for coating precision tools used to produce high value parts. Finishing is easier since XK-22LV.5 does not transfer to finished parts due to the durable properties of the cured resin.

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

- Non-silicone, non-contaminating release surface.
- Operates easily above 850°F.
- Tough, abrasion resistant film.
- Cures at ambient temperatures.
- Excellent adhesion to mold surfaces.
- Can be applied by wiping or brushing on.
- No need to wipe off after applying.
- Stable resin solution - good shelf life.



Item # G471



Stoner XK-22LV.5 keeps molds cleaner longer.

#### Directions for use:

(General directions for molding. These may be adapted as needed to your process.) On a new steel tool, clean tool carefully to remove any oil or rust preventative. Perform a tape test to assure that the surface is clean. Apply release in long even strokes to make a thin wet film. Allow solvent to evaporate, then allow 5 minutes for the resin to cure. Buff lightly with a soft clean cloth and allow to cure another 5 minutes. Repeat process to build from 2-6 coats of XK-22LV.5 on the tool. Allow 30 minutes to cure after the final coat. Repeat tape test to assure that coating is fully cured.

Previously used tooling should be cleaned with Buffaway 2000 or a similar mold polish to a smooth clean finish. After cleaning, apply release as described above.

**StonerMolding.com**

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Made  
in USA