

# Stoner

## Releasomers™ XK-22 LV.1 (G472) Semi-Permanent Solvent Based Mold Release

### Product Description

**Stoner® Releasomers™ XK-22 LV.1** 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.

### Releasomers™ XK-22 LV.1 ADVANTAGES:

- Non-silicone, non-contaminating release surface.
- Operates easily above 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® Releasomers™ XK-22 LV.1** is designed to release epoxy or phenolic resins when compression molding, resin transfer molding, or vacuum infusing.

### Direction 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® Mold Cleaner**. The cleaned surface should be completely dry. Then apply 2 coats of **KantStik® Sealer 1.0** following the instructions on the **KantStik® Sealer 1.0** TDS.
2. **XK-22 LV.1** can be applied by spraying, brushing, or wiping with a clean cotton rag. Make sure of complete and uniform coverage of the surface.

3. 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.
4. 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® Releasomers™ XK-22 LV.1** 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® Releasomers™ XK-22 LV.1** is available in:

- |                  |                     |
|------------------|---------------------|
| • 1-gallon       | Part # G472GLSTON01 |
| • 5-gallon pails | Part # G472PLSTON01 |
| • 55-gallon drum | Part # G472DRSTON01 |

### Technical Assistance

Call: 800-227-5538 or 1 (717) 786-7355  
Email: [TimeSaver@StonerSolutions.com](mailto:TimeSaver@StonerSolutions.com)  
Visit: [StonerSolutions.com](http://StonerSolutions.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.

