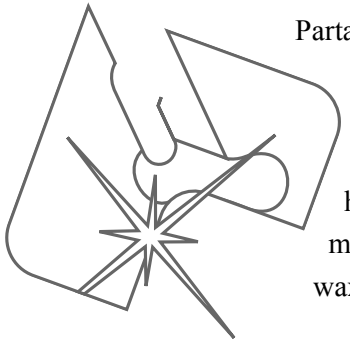
–TAP Plastics

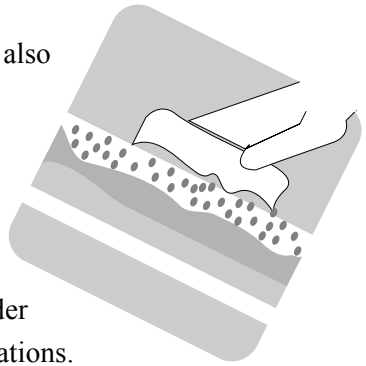
PRODUCT BULLETIN

PARTALL® PASTE #2



Partall® Paste #2 is a polishing compound made from a blend of hydrocarbon and microcrystalline waxes.

It is particularly recommended as a primer coat to create a smooth mold surface prior to application of TAP PVA Mold Release Liquid.



Partall® Paste #2 is also useful as a general purpose parting agent, especially on molds where standard silicone waxes hinder post-finishing operations. When waxing the edges of large molds, Partall Paste #2 is an inexpensive wax to use.

Preparation of Mold Surface

Porous molds (i.e., plaster or wood) must first be sealed with lacquer or similar coating. A good surface on plaster may be obtained with automobile type primer-sealers and lacquers. Plaster molds must be completely dried.

Mold surface should be thoroughly clean and free of other parting agents, especially those containing silicone, prior to application of Partall® Paste #2.

Application of Partall® Paste #2

New and Reconditioned Molds

Using a clean, dry rag, apply a thin, even coat of Partall® Paste #2 to the surface of the mold, covering 3 to 4 square foot sections at a time. Excess should be wiped away, also using a clean, dry rag.

Begin buffing immediately (approximately one minute after application), preferable using a power buffer equipped with a terry cloth or lamb's wool pad. Keep power buffer moving constantly so as not to allow a buildup of friction that could burn through the wax coating. Surface should be buffed to a glossy finish.

In order to insure complete coverage of mold surface, repeat entire process 3 to 4 times for initial molding cycle, waiting 10-15 minutes between coats. Alternate rubbing motions during application of each coat (i.e., up-down on one coat, left-right on another, circular on another).

Wait approximately one hour after application of final wax coat before proceeding. Apply one coat of Partall Paste #2 following every cycle thereafter until mold is broken in.

Seasoned Molds

Using the same process described for new molds, apply one coat of Partall Paste #2 to mold surface and buff. Rewax mold as necessary.

Removing Part from Mold

The best procedure for separating the part from the mold depends on the size and shape of the part.

In most cases the part can be lifted from the mold after loosening around the edges. A jet of air between the part and the mold at the edge is sometimes useful.

On large curved parts it may be necessary to first tap over the surface with a rubber mallet.

A very strong blast of air (or a few squirts with a CO_2 extinguisher) will free very rigid parts that cannot be flexed.

On a well-conditioned mold, the part should loosen and fall away easily. Using Partall® Paste #2 regularly can assist in the conditioning process, reducing parting problems and increasing production cycle efficiency.

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