



PRODUCT DATA SHEET

FORMULA FIVE® Mold Release Wax

General Product Information

FORMULA FIVE® Mold Release Wax is a premium mold release wax that blends carnauba, nature's most durable protection, with modern polymers and hydrocarbon waxes. Formulated for high shine cosmetic parts from most thermoset casting resins on most mold and plug substrates. Polymers are added to provide easy application, extended open working time and positive multiple releases in even the most demanding demolding situations.

Recommended for use with companion product FORMULA FIVE® Clean 'N Glaze as a simple two-step fiberglass mold maintenance system to ease the release of gel-coated parts and maintain fiber reinforced plastic (FRP) mold surfaces. Also useful for non gel-coated composite casting.

FORMULA FIVE® Mold Release Wax is suitable for use with PARTALL® Film #10 and Coverall Film polyvinyl alcohol (PVA) parting films, allowing the PVA to wet-out the mold surface with no fisheyes or separation.

Preparing Mold Surface

Before application of FORMULA FIVE® Mold Release Wax to porous molds (i.e., plaster or wood) should first be sealed. Composites grade sealers and fairing compounds are recommended but a good surface on plaster or wood may be obtained with automobile type primer-sealers and lacquers. Clean and polish mold surface according to instructions with FORMULA FIVE® Clean 'N Glaze buffing compound.

Directions for Use

Using a clean dry cloth or applicator pad apply a small amount of FORMULA FIVE® Mold Release Wax to mold surface in a thin even coat. 0.5 - 1.0 gm is enough for about 1-square yard (1-m²). Excess should be wiped away. Hand-buff waxed surface using clean Turkish toweling when wax is moderately dry, approximately ten minutes after application. If wax wipes away easily or "balls up" when buffing, FORMULA FIVE® Mold Release Wax has not been allowed to dry long enough. Buff until high gloss appears. Power buffer equipped with a terry cloth or lamb's wool pad will reduce labor time on larger molds. Properly prepared mold surface should be smooth and free of streaks or smudges. Apply one coat of FORMULA FIVE® Mold Release Wax polishing to a shine following each cycle thereafter until mold is broken in. Re-wax mold as necessary throughout production. Complete surface coverage is more important than a thick film of wax. In order to insure complete coverage, repeat application and polishing process three times for initializing new or reconditioned molds or plugs. Alternate direction of application of each coat (i.e., zero degrees, 90-degrees, circular). Polish each coat before applying the next. Allow at least one hour for wax solvents to out-gas before applying PVA or casting parts.

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Removing Part from Mold

The best procedure for separating parts from a mold depends on the size and shape of the part. In most cases a part can be lifted from the mold after loosening around the edges. On large curved parts it may be necessary to first gently tap over the surface with a rubber mallet. A blast of compressed air, or a few squirts with a CO₂ extinguisher can aid in freeing very rigid parts that cannot be flexed.