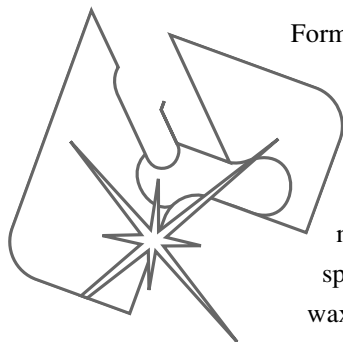


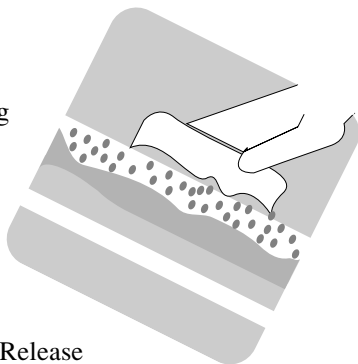
## PRODUCT BULLETIN

### FORMULA FIVE® MOLD RELEASE WAX



Formula Five® Mold Release Wax is a general purpose release agent that blends carnauba with modern polymers and special hydrocarbon waxes.

It is recommended as part of a multi-cycle process designed to ease the release of parts from gel-coated mold surfaces.



An occasional coating of Formula Five® Clean N Glaze is required on most mold surfaces before application of Formula Five® Mold Release Wax.

### 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 Formula Five® Mold Release Wax.

### Application of Formula Five® Mold Release Wax New and Unseasoned Molds

Apply Formula Five® Clean N Glaze according to instructions prior to use of mold release agent.

Using a clean dry rag, apply a thin even coat of Formula Five® Mold Release Wax to the surface of the mold. Excess should be wiped away with another clean dry rag.

When waxed surface is moderately dry (approximately 10 to 12 minutes after application), hand-buff surface using clean Turkish toweling. If Formula Five® Mold Release Wax wipes away easily or "balls-up" when buffing, wax has not been allowed to dry long enough.

Buff until high gloss appears. Mold surface should be smooth and free of any streaks or smudges.

To insure complete coverage of mold surface, apply 2 to 3 coats of Formula Five® Mold Release Wax during initial usage, and wait 10 to 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 Formula Five® Mold Release Wax every cycle thereafter until mold is broken in.

### Seasoned Molds

Using the same process described for new molds, apply one coat of Formula Five Mold Release Wax 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<sub>2</sub> extinguisher) will free very rigid parts that cannot be flexed.

On a well-conditioned mold, the part should loosen and fall away easily. Using Formula Five® Mold Release Wax regularly can aid in achieving a better-conditioned mold that minimizes tooling man-hours and maximizes production cycles.

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