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PRODUCT BULLETIN 15

Formula Five® Clean N Glaze

Formula Five® Clean N Glaze is a mild buffing compound recommended as part of a multi-cycle process designed to ease the release of parts from gel-coated mold surfaces.

It is not a cutting compound and may be used safely on all production molds and plugs.

Formula Five® Clean N Glaze increases production efficiency by accomplishing two steps in one. Fine scratch marks and surface hazing are removed from the mold surface while at the same time a durable, high-luster foundation is laid for the releasing wax. It is recommended that **Formula Five® Mold Release Wax** be used in conjunction with **Formula Five® Clean N Glaze**.

Preparation of Mold Surface

Mold surface should be thoroughly clean and free of other parting agents prior to the application of **Formula Five Clean N Glaze**.

Formula Five Clean N Glaze is not recommended for use on high porosity mold surfaces such as plaster or wood.

Application of Formula Five® Clean N Glaze

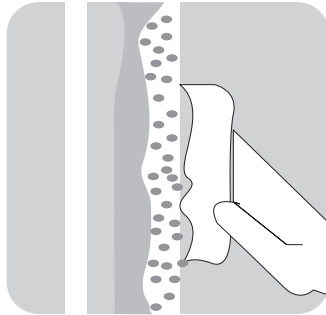
Using a clean dry rag and a circular motion, apply a thin even coat of **Formula Five® Clean N Glaze** to the surface of the mold. Cover sections measuring approximately six square feet at a time.

Excess should be wiped away with another clean dry rag.

Begin buffing immediately with a power buffer. It is recommended that the power buffer be equipped with a terry cloth or cotton pad.

Keep the power buffer moving constantly so as not to allow a buildup of friction that could burn through surface coating.

Surface should be buffed to a glossy finish. Any remaining haze or residue may be removed using a wet cotton cloth or sponge.



Formula Five® Mold Release Wax may be applied to mold surface following buffing. An occasional reapplication of **Formula Five® Clean N Glaze** will assist in maintaining a trouble free mold.

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 CO2 extinguisher) will free very rigid parts that cannot be flexed.

Parts should fall away easily from a well-conditioned mold. Using **Formula Five® Clean N Glaze** regularly can aid in the conditioning process, resulting in fewer parting problems and more efficient production cycles

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