



TAP Plastics • tapplastics.com

## PRODUCT BULLETIN 17

### 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

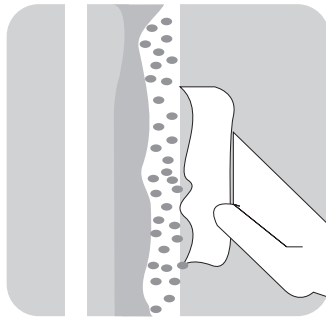
Porous molds (i.e., plaster or wood) must first be sealed with lacquer or similar coating. A good surface on plaster may be obtained with automobile type primer-sealers and lacquers. Plaster molds must be completely dried.

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. Re-wax 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 CO2 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.

The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable. No guarantee of their accuracy is made, however, and the products discussed are sold without warranty, express or implied, and upon conditions that the purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses.

View all of TAP's how-to videos on plastic, fiberglass, mold-making, window films, and more at:

[http://www.tapplastics.com/product\\_info/videos](http://www.tapplastics.com/product_info/videos)



the fantastic plastic place

Visit us online at [tapplastics.com](http://tapplastics.com)  
for store locations.