



PRODUCT BULLETIN 16

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**.

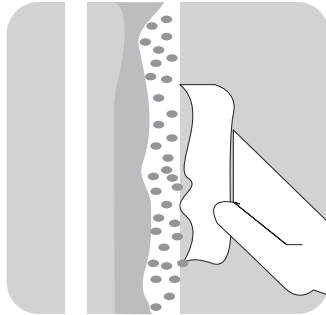
Application of Formula Five® Mold Release Wax

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.

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



Seasoned Molds

Using the same process described for new molds, apply one coat of Formula Five Mold Release Wax 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 **Formula Five® Mold Release Wax** regularly can aid in achieving a better-conditioned mold that minimizes tooling man-hours and maximizes production cycles.

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.



- | | | |
|---|------------------------|--------------|
| <input type="checkbox"/> Bellevue WA | 12021 NE Northup Way | 425 861-0940 |
| <input type="checkbox"/> El Cerrito CA | 10760 San Pablo Avenue | 510 778-9057 |
| <input type="checkbox"/> Fremont CA | 5160 Mowry Avenue | 510 796-3550 |
| <input type="checkbox"/> Lynnwood WA | 4232 196th St. SW | 425 977-4440 |
| <input type="checkbox"/> Mountain View CA | 312 Castro Street | 650 962-8430 |
| <input type="checkbox"/> Pleasant Hill CA | 1478 Contra Costa Blvd | 925 798-0420 |
| <input type="checkbox"/> Pleasanton CA | 6010-C Johnson Drive | 925 460-8214 |
| <input type="checkbox"/> Portland OR | 2842 NE Sandy Blvd | 503 230-0770 |
| <input type="checkbox"/> Sacramento CA | 4538 Auburn Blvd | 916 481-7584 |
| <input type="checkbox"/> Sacramento CA | 4506 Florin Road | 916 429-9551 |
| <input type="checkbox"/> San Francisco CA | 154 S. Van Ness Ave | 415 864-7360 |
| <input type="checkbox"/> San Jose CA | 1212 The Alameda | 408 292-8685 |
| <input type="checkbox"/> San Leandro CA | 3011 Alvarado Street | 510 357-3755 |
| <input type="checkbox"/> San Mateo CA | 606 South B Street | 650 344-7127 |
| <input type="checkbox"/> San Rafael CA | 900 Andersen Drive | 415 454-6393 |
| <input type="checkbox"/> Santa Rosa CA | 2770 B Santa Rosa Ave | 707 544-5772 |
| <input type="checkbox"/> Seattle WA | 710 9th Avenue North | 206 389-5900 |
| <input type="checkbox"/> Stockton CA | 1859 Pacific Avenue | 209 937-9300 |
| <input type="checkbox"/> Tigard OR | 15957 SW 72nd Avenue | 503 620-4960 |

