



## Application Guide

# FORMULA FIVE® Mold Stripper

FORMULA FIVE® Mold Stripper is a heavy duty cleaner used to clean most mold surfaces including those composed of metal or thermoset composites (fiberglass). Formulated to dwell on mold surface and leach out and react with contaminants, FORMULA FIVE® Mold Stripper dissolves resin deposits and styrene buildup. Can also be used to aid in removal of semi-permanent release agents. Allows contaminants to be wiped or washed off the mold surface. Effectively combats resin and styrene build up on mold surfaces and mold scumming.

FORMULA FIVE® Mold Stripper is especially recommended for closed molding operations and is also effective for deep cleaning of highly detailed mold surfaces, engineered surfaces and non-skid. FORMULA FIVE® Mold Stripper is a more aggressive cleaner than FORMULA FIVE® Wax Stripper and may be used to remove most thermoset resin residues including polyester, vinylester, epoxy, phenolics, and polyurethane. FORMULA FIVE® Mold Stripper also aids in the removal of cured semi-permanent mold releases. Best used on warm molds up to 130 °F (54 °C).

### PREPARING THE MOLD SURFACE

FORMULA FIVE® Mold Stripper is ready to use as received. Do not dilute or mix with other products or solvents. Before use, determine first that mold surface will not clean with less aggressive cleaners such as FORMULA FIVE® Mold Cleaner or FORMULA FIVE® Wax Stripper.

Prior to use on rubber molds, thoroughly test for compatibility on a non-cosmetic portion of the mold. FORMULA FIVE® Mold Stripper is not intended for use on new or recently reconditioned or repaired composite molds. Do not reuse contaminated cloths to apply. Do not return contaminated product to original container.

### DIRECTIONS FOR USE

FORMULA FIVE® Mold Stripper should always be used in a well-ventilated area with appropriate personal protection equipment, including solvent resistant gloves and eye protection.

Dispense a quantity of FORMULA FIVE® Mold Stripper into a metal, HDPE plastic, or other solvent resistant container. Apply liberally to mold surface with a natural bristle or nylon brush. Move FORMULA FIVE® Mold Stripper around mold surface, replenishing with additional quantity as necessary to keep mold surface wet; do not allow mold surface to dry. Continue replenishing as needed and allow to penetrate contaminants for up to twenty minutes. Wipe off dissolved residue/stripper with water/detergent moistened cloths or wash mold surface with warm water and a tiny amount of dishwashing detergent and dry. Wipe mold surface with a clean cloth to dry. Apply FORMULA FIVE® Mold Cleaner according to instructions prior to application of mold sealer or semi-permanent top coat. Prior to applying mold release perform tape test in several locations to verify entire surface is clean (if tape adheres very well, mold is clean).

**LARGER SURFACES / HEAVY DEPOSITS:** Work on manageable sections no larger than 5 ft<sup>2</sup> (0.5 m<sup>2</sup>) at a time. For removal of heavy deposits scrub mold surface with bristle brush and FORMULA FIVE® Mold Stripper. For extremely heavy deposits or difficult to clean surfaces, liberally apply to mold surface and place cloth over FORMULA FIVE® Mold Stripper to slow evaporation, allowing to soak for up to thirty minutes. Be alert to any softening of composite tooling surfaces or excess abrasion to tool surface while cleaning. Do not return contaminated product to original container.

*FORMULA FIVE® Mold Stripper is packaged in 1 gallon (3.79 liter) jerricans.*