



PRODUCT DATA SHEET

FORMULA FIVE® Glossy Top Coat Semi-Permanent Mold Release

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General Product Information

FORMULA FIVE® Glossy Top Coat semi-permanent mold release is a proprietary blend of cross-linking polymers in a solvent carrier that bond to the mold surface to protect the mold and preserve fine detail. A high gloss external mold release that produces very little mold build up. Yields multiple releases per application, has excellent chemical resistance and withstands extreme processing temperatures. Ideal for applications where transfer of release agent to finished part must be avoided. Designed to release gelcoated polyester, vinyl ester or epoxy parts from most substrates, including metal or gelcoated mold surfaces. Can be used with most molding processes and ideal for high production open molding operations. Simple wipe-on leave-on application.

NOTE: The cross-linking resins used in FORMULA FIVE® Glossy Top Coat cure by hydrolysis (interaction with moisture in the atmosphere) and temperature. Recommended storage is in original containers tightly sealed avoiding extreme temperatures. Decant the amount of material expected to be used into HDPE containers with a positive closure just before use. Do not return air exposed release back into original container.

Preparing Mold Surface

FORMULA FIVE® Glossy Top Coat is ready to use as received with no mixing or agitation necessary. Do not mix with other chemicals or dilute. Only use FORMULA FIVE® Glossy Top Coat after mold surface has been thoroughly cleaned and prepared with FORMULA FIVE® Mold Sealer or FORMULA FIVE® Mold Sealer-S according to instructions.

Directions for Use

Consult Material Safety Data Sheet (MSDS) prior to use. FORMULA FIVE® Glossy Top Coat should always be used in a well-ventilated area with appropriate personal protection equipment, including solvent resistant gloves.

FORMULA FIVE® Glossy Top Coat performs very well at application temperatures of 70 °F (21 °C) and above, but curing at higher temperatures above process or part resin exotherm temperature makes a more durable release coating. Multiple coats and longer curing times between mold release coats before first part being made will also make a more durable coating. May be applied to surface temperatures of 70 - 350 °F (21 - 177 °C). Rapid evaporation of carrier solvents will require spray application for mold surfaces above 130 °F (55 °C).

Using a clean dry lint-free cloth or high quality paper towel, wet but not dripping with FORMULA FIVE® Glossy Top Coat, gently wipe mold surface covering up to 5 square feet (0.5 meter²) at a time. Never pour mold release directly on mold. Wipe away any pooling, do not over wipe or apply excess material. The goal is to apply a thin even coat without pooling. Reapply FORMULA FIVE® Glossy Top Coat to cloth frequently during application. Repeat on neighboring areas, overlapping to ensure complete coverage, until mold surface is completely covered. No buffing or polishing is necessary.

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Allow 15 minutes after first coat has dried for the resulting film to cure. Then, using a fresh clean cloth or paper towel, repeat previous steps 3 more times for a total of 4 protective coats. When final coat is dry, allow film to cure for at least 30 minutes at room temperature before proceeding with molding. Durability of mold release will be improved by allowing films to cure longer or by heat curing, e.g. at 140 °F (60 °C) for 15 minutes or by heat curing at temperatures above process or part resin exotherm temperature.

For best results, reapply one coat of FORMULA FIVE® Glossy Top Coat as described above after first, third and fifth part have been de-molded and when molded parts begin to hesitate or stick upon release. Best practice for new or reconditioned molds or repaired areas of previously seasoned molds is to first apply FORMULA FIVE® Mold Sealer or FORMULA FIVE® Mold Sealer-S according to instructions, followed by six coats of FORMULA FIVE® Glossy Top Coat, allowing 30 minutes cure time for each coat and allowing the final coat to cure overnight.

A soft solvent resistant brush or foam applicator pad is helpful to apply to difficult to reach or highly textured areas.

Hand wiping is the best application method for FORMULA FIVE® Glossy Top Coat, but the use of a spray mister bottle to apply to difficult to reach, highly textured areas or very large molds is useful. After spray application of FORMULA FIVE® Glossy Top Coat, gently wipe over wet coating using a clean dry cotton cloth so that a thin wet film remains - *do not wipe dry*. This will help eliminate hazing caused by spraying that appears upon cure or streaking caused by release pooling on mold.

If streaking is observed after applying a coat of mold release, polish off with a clean cloth after cure. Streaking can be caused by applying too heavy of a coat of mold release or by applying with a cloth containing partially or fully cured release or other contaminants.

Use a clean cloth dampened with FORMULA FIVE® Glossy Top Coat to clean scuff marks and light styrene build up from mold surfaces and to touch up wear areas on mold between production cycles.

If resin scum is observed after demolding a part, clean area using FORMULA FIVE® Glossy Top Coat and wipe away residue. If scumming persists while molding parts, lightly clean area(s) with FORMULA FIVE® Mold Cleaner and a Scotch-Bright® type pad, wiping away residue and reapplying one or two coats of mold release as described above. Continue molding parts. If scumming is chronic, clean mold with FORMULA FIVE® Wax Stripper according to instructions and then buff the mold. Proceed by reconditioning mold with FORMULA FIVE® Mold Sealer or FORMULA FIVE® Mold Sealer-S and FORMULA FIVE® Glossy Top Coat according to instructions.

1 GALLON (3.79 LITER) JERRICAN AND 55 GALLON (208.2 LITER) DRUM

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