



Application Guide

FORMULA FIVE® Mold Cleaner

FORMULA FIVE® Mold Cleaner is a general purpose mold cleaner for routine mold maintenance. Use prior to application of FORMULA FIVE® Mold Sealers and when using FORMULA FIVE® Matte Top Coat semi-permanent release as a one-step system. Suitable for use on most mold substrates including those composed of fiberglass, aluminum, steel, and thermoset resins.

FORMULA FIVE® Mold Cleaner cleans without abrasives and can be used between molding cycles to remove uncured resin or overspray and other contaminants without stripping off underlying coat of semi-permanent mold release. Dissolves build up on mold surfaces caused by wax, silicone, and other contaminants such as grease and dirt, allowing them to be wiped off without softening or dulling the mold surface. FORMULA FIVE® Mold Cleaner can be used to remove excess semi-permanent mold releases before they fully cure and can be used to reduce surface tension of semi-permanent mold releases in areas of the mold that exhibit gel coat pre-release.

Use FORMULA FIVE® Mold Cleaner to clean areas of mold before touch up with semi-permanent mold release during production. Useful for removing residues from other cleaners/strippers or spots from water washing. FORMULA FIVE® Mold Cleaner may be used on warm molds. Not designed to remove fully cured semi-permanent mold releases.

PREPARING THE MOLD SURFACE

FORMULA FIVE® Mold Cleaner is ready to use as received. Do not dilute or mix with other products or solvents. Prior to use on rubber molds, thoroughly test for compatibility on a non-cosmetic portion of the mold. Do not reuse contaminated cloths to apply. Do not return contaminated product to original container.

DIRECTIONS FOR USE

FORMULA FIVE® Mold Cleaner should always be used in a well-ventilated area with appropriate personal protection equipment, including solvent resistant gloves and eye protection. Dampen a cotton cloth with FORMULA FIVE® Mold Cleaner and apply to mold surface prior to touch up with semi-permanent mold release during production, to remove light resin scumming or excess uncured semi-permanent mold release, or to reduce the surface tension of molds prepared with semi-permanent mold releases. Using a fresh clean cloth, gently wipe away dissolved residue before cleaner dries. Prior to applying mold release perform tape test in several locations to verify entire surface is clean (if tape adheres very well, the mold is clean).

LARGER SURFACES / HEAVY DEPOSITS: On larger surfaces work on manageable sections no larger than 5 ft² (0.5 m²) at a time. Repeat on neighboring areas, overlapping to ensure complete coverage of mold surface. For removal of heavier wax or contaminant deposits apply FORMULA FIVE® Mold Cleaner with a wet cotton cloth or stiff solvent resistant bristle brush. Work cleaner over mold surface with brush. Wipe away dissolved residue before cleaner dries with clean cotton cloths. Several applications may be necessary to remove stubborn deposits. For removal of extremely heavy build up use FORMULA FIVE® Wax Stripper or compound mold before cleaning.

FORMULA FIVE® Mold Cleaner is packaged in 55 gallon (208.2 liter) drums, 5 gallon (18.9 liter) pails, and 1 gallon (3.79 liter) jerricans.

DISCLAIMER: The information and recommendations contained herein 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 condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses. Consult Material Safety Data Sheet (MSDS) prior to use.