



## PRODUCT DATA SHEET

# PARTALL® Coverall Film

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### General Product Information

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PARTALL® Coverall Film is a nonflammable water-based, polyvinyl alcohol (PVA) coating comprised of non-hazardous, film forming materials. The dry PVA film is resistant to the solvents in the resin system used for composites parts manufacture but is soluble in water. It is particularly recommended as a parting agent for separation between polyester or epoxy resins and various mold surfaces but may be used with most thermoset resins. PARTALL® Coverall Film is not recommended for use with resins containing water or giving off water during cure (i.e., phenolics).

After part casting PARTALL® Coverall Film parts easily from the mold surface and is readily dissolved from molded parts and spray equipment with water. For most composite casting processes PARTALL® Coverall Film is used over wax or other mold release agents and renewed for each part casting.

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### Preparing Mold Surface

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Porous molds (i.e., plaster or wood) should first be sealed with lacquer or similar coating. Composites grade sealers and fairing compounds are recommended. Apply mold release wax to mold or plug surfaces according to instructions and polish each coat to a shine. Choose PARTALL® Paste #2, FORMULA FIVE® Mold Release Wax, or PARTALL® Hi-Temp Wax according to process requirements.

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### Directions for Use

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PARTALL® Coverall Film is ready to use as received and should not be diluted. Preferred application is with a spraygun but good results may be obtained with a sponge applicator or paint brush or by dipping substrate and draining excess PVA. Recommended air pressure with HVLP spraygun is 22 - 24 PSI (1.5 - 1.7 BAR). When using a traditional spraygun adjust air pressure to approximately 60-90 PSI (4 - 6 BAR) at the gun. Normal gun to substrate spraying distance is 12 - 18 inches (30 - 45 cm).

On new (unseasoned) polyester or vinylester molds, apply multiple coats of PARTALL® Coverall Film to surface and allow each coat to dry completely before proceeding. On seasoned molds, apply one or two coats of PARTALL® Coverall Film. Do not begin molding until PVA on surface is completely dry. Drying time is approximately 15 - 60 minutes per coat depending on ambient temperature and humidity. On new or reconditioned molds dry film thickness should be 2 - 4 mils (50 - 100 micrometers), about the thickness of an industrial-type trash bag. 1 - 2 mils (25 - 50 micrometers) is recommended on seasoned molds. PARTALL® Coverall Film will exhibit a white foamy appearance when freshly sprayed but will dry to a clear coat. Film should not sag or contain runs when applied. If application flaws appear in PVA film wash off with water and begin again. Make certain that PARTALL® Coverall Film is completely dry before proceeding with molding process. Film should be very smooth and glossy when dry. A dull, hazy or grainy film may result from too thin a PVA film from insufficient spray - spray PVA to wet look. If spray air bubbles are trapped in PVA film try higher air pressure. One gallon (3.79 liters) covers about 400 square feet (40 m<sup>2</sup>).

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### Properties

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- Non-Flammable
- Primary Application: Release agent for use with unsaturated polyester, vinyl ester and epoxy resins.
- Gas Density: High barrier characteristic against nearly all common gases makes PVA an ideal surface cure agent for air-inhibited resins such as polyester gel coats and cast methyl methacrylate acrylics.
- Solvent stability against nearly all organic solvents, oils and fats. Solvent resistant yet water soluble.
- Dry film temperature resistance up to 300 °F (149 °C).
- Application temperature preferred 70 – 80 °F (21 – 27 °C) @ 50% relative humidity. Ambient or substrate temperatures above 100 °F (38 °C) may cause wet film separation or cob-web defects.

55 GALLON (208.2 LITER) DRUM, 5 GALLON (18.9 LITER) PAIL, 1 GALLON (3.79 LITER) BOTTLE, 1 QUART (0.95 LITER) BOTTLE

AVAILABLE IN PURPLE OR CLEAR

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