



## PRODUCT DATA SHEET

# PARTALL® HT-PT Liquid Mold Release

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### General Product Information

PARTALL® HT-PT Liquid Mold Release is a liquid polymeric mold release (solvent-based fluoropolymer) that dries at room temperature. A silicone-free external mold release agent that gives a matte or glossy finish to parts depending on method of application. Use in most composite processes including spray up, RTM, compression, casting, vacuum bagging or with prepregs.

Offers multiple part releases and will not interfere with post-finishing or bonding operations. For use with most thermoset resins including polyester, vinyl ester, epoxy and phenolics. Suitable for use on most mold substrates including FRP/GRP composite, glass, aluminum and steel. Easy to use and handle with wipe on application and easy wet polishing.

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### Preparing Mold Surface

Mix before use. PARTALL® HT-PT Liquid Mold Release is ready to use as received and is not to be mixed with other chemicals or diluted. Clean mold with FORMULA FIVE® Mold Cleaner according to directions. FORMULA FIVE® Mold Sealer-S recommended before use on aluminum and other porous mold surfaces.

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### Directions for Use

Consult Material Safety Data Sheet (MSDS) prior to use. PARTALL® HT-PT Liquid Mold Release should always be used in a well-ventilated area with appropriate personal protection equipment, including double solvent resistant gloves and eye protection. May be applied to molds up to temperatures of 120 °F (50 °C).

For Glossy Finish: Using a clean dry lint free and solvent resistant cloth or high quality paper towel, wipe an even coat of PARTALL® HT-PT Liquid Mold Release on the mold. Do not polish at this time. Allow first coat to dry to a haze. Apply a second coat of PARTALL® HT-PT Liquid Mold Release and for a gloss surface use a fresh clean solvent resistant cloth to wet polish the mold. Apply a third coat of PARTALL® HT-PT Liquid Mold Release and wet polish to a shine. When final coat is dry, allow film to cure for at least 30 minutes at room temperature before proceeding with molding. Repeat wet polish application after each of the first few parts cast. Gradually increase the number of parts made before additional wet polish applications of PARTALL® HT-PT Liquid Mold Release.

For matte finish do not polish to a shine after application.

*1 GALLON (3.79 LITER) JERRICAN*

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