



PRODUCT DATA SHEET

PARTALL® Hi-Temp Wax

General Product Information

PARTALL® Hi-Temp Wax is a premium multiple-release mold release formulated from a blend of hydrocarbon and microcrystalline waxes and fortified with PTFE polymer. It is particularly recommended for use with epoxies or phenolics or processes that cure and/or catalyze at higher temperatures, 150 - 350 °F (65 - 177 °C) when casting composites parts or molds from plugs. It may be used with most thermoset resins at ambient or elevated temperature cure. PARTALL® Hi-Temp Wax is especially useful in applications where standard silicone waxes hinder post-finishing operations. PARTALL® Hi-Temp Wax has a creamy texture that makes for ease of application.

It is recommended that a PVA solution such as PARTALL® Coverall Film or PARTALL® Film #10 be used in conjunction with PARTALL® Hi-Temp Wax on molds that are particularly intricate or too expensive to risk demolding problems or when initializing new or reconditioned polyester or vinylester molds. PVA is commonly used over this wax when making epoxy parts.

Preparing Mold Surface

Before application of PARTALL® Hi-Temp Wax porous molds (i.e., plaster or wood) should first be cleaned and sealed. Composites grade sealers such as Formula Five® Mold Sealer or Formula Five® Mold Sealer-S (Super) are recommended.

Directions for Use

Using a clean dry cloth, apply a small amount of Partall® Hi-Temp Wax to mold surface in a thin even coat. 0.5 - 1.0 gm is enough for about 1-square yard (1-m²). Turn over cloth and begin buffing immediately by hand (within one minute after application). On larger molds or plugs work on smaller sections at a time or have second operator follow to polish. Power buffer equipped with a terry cloth or lamb's wool pad will reduce labor time on larger molds. Surface should be buffed to a glossy finish.

Complete surface coverage is more important than a thick film of wax. In order to insure complete coverage, repeat application and polishing process three (3) times for initializing new or reconditioned molds or plugs. Alternate direction of application of each coat (i.e., zero degrees, 90-degrees, circular). Polish each coat before applying the next. Allow at least one hour for wax solvents to out gas before applying PVA or casting parts.

Apply one coat of Partall® Hi-Temp Wax polishing to a shine following each cycle thereafter until mold is broken in. Re-wax mold as necessary throughout production.

Removing Part from Mold

The best procedure for separating parts from a mold depends on the size and shape of the part. In most cases a part can be lifted from the mold after loosening around the edges. On large curved parts it may be necessary to first tap gently over the surface with a rubber mallet. A strong blast of compressed air, or a few squirts with a CO₂ extinguisher, can aid in freeing very rigid parts that cannot be flexed.