



## PRODUCT DATA SHEET

# PARTALL® OCF-55

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### General Product Information

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Partall® OCF-55 PVA Parting Film, also known as dome end PVA, is designed for use in the manufacture of non-cosmetic thermoset composite parts. The dry film is solvent-resistant yet water-soluble. Partall® OCF-55 PVA Parting Film contains a higher alcohol content than traditional PVA barrier solutions giving a faster drying time. Formulated with a special combination of polymers, Partall® OCF-55 PVA Parting Film has improved performance on vertical surfaces. It is recommended as a parting agent for polyester, vinylester or epoxy resin parts made on most mold or plug surfaces. It is not recommended for use with resins containing water or giving off water during cure (e.g., phenolics), or for mold substrates that contain or give off water as the dry film is water-soluble.

De-molding of the part after the resin has cured is facilitated by the Partall® OCF-55 releasing from the mold. It is then readily peeled off or dissolved from the molded part with warm water or in some cases left on the part. Partall® OCF-55 is typically used over a mold release wax such as Partall® Paste #2 although in some applications it is used as a stand-alone mold release agent. In most processes Partall® OCF-55 will need to be renewed on the mold for each part.

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### Preparing Mold Surface

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Porous molds (i.e., plaster or wood) must first be sealed. Best results are obtained with coatings formulated specifically as sealers or fairing compounds for the fiberglass reinforced molding industry such as Formula Five® Mold Sealer or Formula Five® Mold Sealer-S (Super). Plaster molds or plugs must first be thoroughly dry. Molding surfaces should be free of other parting agents and contaminants such as silicone, dust, or compressor oil.

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### Directions for Use

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Apply on a clean mold surface that has been prepared with mold release wax such as Partall® Paste #2 according to instructions. Partall® OCF-55 is ready to use as received and should not be diluted. Partall® OCF-55 is designed to be applied by brush, roller or sponge. A self-feeding paint roller attached to a compressed air pressure pot is an efficient set-up for applying to large surfaces. Clean dry air is recommended.

Apply an even coat of wet Partall® OCF-55 to mold surface ensuring 100% coverage without voids or gaps. Best results are achieved with multiple layers of Partall® OCF-55 applied in different directions, allowing each coat to completely dry between coats and before making the fiberglass composite part. Recommended dry film thickness is 2 - 4 mils (50 – 100 µm) on new, recently repaired or reconditioned molds and 1 - 2 mils (25 - 50 µm) on seasoned molds. One gallon (3.79 L) will cover about 400 feet<sup>2</sup> (40 m<sup>2</sup>).

Drying time is normally 15 to 45 minutes depending on wet PVA coat thickness, ambient temperature and humidity. The film should be very smooth and glossy when dry without voids, porosity, runs or sags. A dull film may result from insufficient application of material and may contain pinholes. Too little or a porous coating of PVA film should be avoided as it will allow the aggressive solvents in the resin system to penetrate the PVA film and cook against the mold surface during part exotherm causing damage to the part or the mold surface.

Partall® OCF-55 PVA Parting Film will stay on the part when de-molded. It can be peeled or washed off with water. For stubborn films use warm water and a Scotch-Brite® pad or bristle brush. Application equipment should be cleaned with water before Partall® OCF-55 dries. If PVA has dried soak equipment in warm water until PVA softens. Do not leave Partall® OCF-55 PVA Parting Film in spray equipment as metal parts may be damaged.