



PRODUCT DATA SHEET

PARTALL® One-Coat

General Product Information

PARTALL® One-Coat is a water-based Polyvinyl Alcohol (PVA) coating comprised of water-soluble, film forming materials. Commonly used as parting film between polyester, vinylester or epoxy resins and various mold surfaces or as a release barrier when making rigid support shells for elastomeric rubber molds. Also specified as an anti-mutilation coating for aircraft windshields. PARTALL® One-Coat contains 2 – 3 times the solids content of standard PVA giving it a thick viscosity that builds quickly. The solvent-resistant dry film releases easily from mold or part surface or application equipment. Removal is by peeling off in a continuous skin or by dissolving with water and scrubbing with a soft bristle brush or sponge. Warm water aids removal.

NON-HAZARDOUS, NON-FLAMMABLE

Preparing Mold Surface

Porous surfaces (e.g. - plaster or wood) should be dry and first sealed with lacquer or similar coating followed with one or more coats of a durable mold release wax such as PARTALL® Paste #2 buffed to a high gloss. Waxes containing high levels of silicone such as automotive wax should be avoided as they can create separation or pin holes in the PVA film. Best practice is to allow residual solvents to out-gas from mold release wax for one hour prior to application of PVA.

Directions for Use

PARTALL® One-Coat is ready to use as received for most purposes but may be diluted with clean water up to a ratio of 1:1 to suit application method. Normally applied over mold release wax such as PARTALL® Paste #2 or FORMULA FIVE® Mold Release Wax although may be used as a stand alone mold release. Safe for all non-porous, non-absorbent substrates.

Apply PARTALL® One-Coat to mold surface in an even continuous coat with a brush, sponge, or roller and allow complete drying before molding parts. If size and shape of mold allows, application may be made by flooding the mold surface with PVA and tipping to drain off excess. Test for dry state by gently pressing finger into film, if PVA comes off of mold onto finger or if finger impression is left in PVA the film is not completely dry.

The goal is complete coverage with a smooth and glossy film without voids, separation or pin holes. Dry PVA film thickness should be 1 - 4 mils (25 – 100 µm), to protect mold surface from solvents found in thermoset casting or fabrication resins, paints and adhesives. A wet film thickness of 20 mil (500 µm) should yield a dry film thickness of approximately 4 mil (100 µm).

Do not begin molding until surface is completely dry. Drying time is approximately 120 minutes at 70 °F (21 °C) with 50% relative humidity. Factors such as humidity and ambient air temperature and coating thickness will cause drying time to vary. Mechanically moving air over wet PVA surface or heating mold surface will accelerate drying time.

*55 GALLON (208.2 LITER) DRUM, 5 GALLON (18.9 LITER) PAIL, AND 1 GALLON (3.79 LITER) BOTTLE
AVAILABLE IN CLEAR (WATER-WHITE) OR TINTED*

REXCO • P.O. Box 80996 • Conyers, GA 30013 • U.S.A.
Telephone (770) 483-7610 • Fax (770) 483-8550 • Toll Free (800) 888-1060 (U.S.A. & Canada)
E-mail: info@rexco-usa.com • Website: www.rexco-usa.com