

# FORMULA FIVE

## MOLD RELEASE WAX

### GENERAL INFORMATION

Formula Five® Mold Release Wax is a general purpose release wax that blends carnauba - nature's most durable protection - with modern polymers and hydrocarbon waxes. Silicone is added to provide easy application and positive multiple releases in even the most demanding situations. Recommended for use in conjunction with Formula Five® Clean 'N Glaze to ease the release of parts from gel-coated mold surfaces.

It is recommended that a Polyvinyl Alcohol (PVA) solution such as Partall® Coverall Film or Partall® Film #10 be used in conjunction with Formula Five® Mold Release Wax on molds that are new or reconditioned or that are particularly intricate or too expensive to risk demolding problems.

### PREPARATION OF MOLD SURFACE

Porous molds (i.e., plaster or wood) must first be sealed with lacquer or similar coating. A good surface on plaster may be obtained with automobile type primer-sealers and lacquers. Mold should be thoroughly dry and free of other parting agents prior to application of Formula Five® Mold

### APPLICATION OF FORMULA FIVE® MOLD RELEASE WAX

#### **New / Reconditioned Molds**

Apply Formula Five® Clean 'N Glaze according to instructions prior to use. Using a clean dry rag, apply a thin even coat of Formula Five® Mold Release Wax to mold surface. Excess should be wiped away, also using a clean dry rag. Hand-buff waxed surface using clean Turkish toweling when moderately dry (approximately 10-12 minutes after application). If wax wipes away easily or "balls up" when buffing, Formula Five® Mold Release Wax has not been allowed to dry long enough. Buff until high gloss appears - mold surface should be smooth and free of streaks or smudges.

In order to insure complete coverage, apply 2-3 coats during initial usage. Use alternating rubbing motions during application of each coat (i.e., up-down, left-right, circular). Apply one coat of Formula Five® Mold Release Wax following each cycle thereafter until mold is broken in. Wait at least one hour after application of final coat before proceeding with molding.

#### **Seasoned Molds**

Using the same process described for new molds, apply one coat of Formula Five® Mold Release Wax to mold surface and buff. Re-wax mold as necessary.

### 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. A jet of air between the part and mold at the edge is sometimes useful. On large curved parts it may be necessary to first tap over the surface with a rubber mallet. A very strong blast of air, or a few squirts with a CO<sub>2</sub> extinguisher, can aid in freeing very rigid parts that cannot be flexed.



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