

PARTALL® PASTE #2

GENERAL INFORMATION

Partall® Paste #2 is a general purpose polishing compound made from a blend of hydrocarbon and microcrystalline waxes. It is particularly recommended for use on molds where standard silicone waxes hinder post-finishing operations or as a primer coat to create a smooth mold surface prior to application of Partall® Film #10. Partall® Paste #2 may also be employed as an inexpensive edge wax on larger molds.

It is recommended that a Polyvinyl Alcohol (PVA) solution such as Partall® Coverall Film or Partall® Film #10 be used in conjunction with Partall® Paste #2 on molds 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, especially those containing silicone, prior to application of Partall® Paste #2.

APPLICATION OF PARTALL® PASTE #2

New / Reconditioned Molds

Using a clean dry rag, apply a thin even coat of Partall® Paste #2 to mold surface, covering 3-4 square foot sections at a time. Excess should be wiped away, also using a clean dry rag. Begin buffing immediately (approximately one minute after application) either by hand or with a power buffer equipped with a terry cloth or lamb's wool pad. Keep power buffer moving constantly so as not to allow a build-up of friction that could burn through the wax coating. Surface should be buffed to a glossy finish.

In order to insure complete coverage, repeat entire process 3-4 times for initial molding cycle. Alternate rubbing motions during application of each coat (i.e., up-down, left-right, circular). Apply one coat of Partall® Paste #2 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 Partall® Paste #2 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 CO₂ extinguisher, can aid in freeing very rigid parts that cannot be flexed.



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