



## PRODUCT DATA SHEET

# PARTALL® Hi-Temp Wax

### General Product Information

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PARTALL® Hi-Temp Wax is a multiple-release wax polishing compound formulated from a blend of teflon and hydrocarbon and microcrystalline waxes. It is recommended for use with epoxies or other resins that cure and/or catalyze at higher temperatures (150° - 350° F). PARTALL® Hi-Temp Wax is especially useful in applications where standard silicone waxes hinder post-finishing operations.

It is recommended that a Polyvinyl Alcohol (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.

#### Preparing Mold Surface

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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® Hi-Temp Wax.

#### Directions for Use

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##### New / Reconditioned Molds

Using a clean dry rag, apply a thin even coat of PARTALL® Hi-Temp Wax 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® Hi-Temp 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 PARTALL® Hi-Temp Wax to mold surface and buff. Re-wax mold as necessary.

#### Removing Part from Mold

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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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