



Product Bulletin

PARTALL[®] POWER Liquid Mold Release

General Product Information

PARTALL[®] POWER Liquid Mold Release is a non-hazardous water-based polymeric external mold release that gives a matte finish (non-cosmetic finish) to parts. It is designed for use on most mold substrates including FRP/GRP composite (fiber glass), glass, aluminum and steel. This product provides multiple releases, ease of application, and minimal fouling of tooling during processing. PARTALL[®] POWER Liquid Mold Release is ideal for spraying on hot molds, for use in compression molding, resin transfer molding and filament winding operations. PARTALL[®] POWER Liquid Mold Release is recommended for use with most thermoset composites including polyester, vinylester and epoxy and molding processes including contact molding and closed molding. Suitable for application to high temperature surfaces or for high molding process temperatures.

- Wipe-on or spray-on application
- Non-hazardous and non-flammable
- Renders an even matte finish to molded part when properly applied
- Shake well before use as PARTALL[®] POWER Liquid Mold Release may separate in storage container
- May be applied to hot molds ~600°F (~316°C)
- Contains no silicones, waxes or stearates

Preparing Mold Surface

Before applying PARTALL[®] POWER Liquid Mold Release compound mold if necessary and then clean mold with FORMULA FIVE[®] Mold Cleaner according to instructions.

Directions for Use

Consult Material Safety Data Sheet (MSDS) prior to use. PARTALL[®] POWER Liquid Mold Release should always be used in a well-ventilated area with appropriate personal protection equipment, including resistant gloves and eye protection.

Wipe-On: Apply using a clean lint-free cotton cloth or high quality paper towel. Wet the applicator with PARTALL[®] POWER Liquid Mold Release. Wipe release on mold using a circular motion in multiple directions leaving an even wet coat. Reapply mold release to applicator as needed. Allow first coat to air dry for 5 minutes or accelerate drying by moving warm air over surface. Apply second coat in the same fashion allowing a final 30 – 45 minute drying time. It is normal that the coats do not appear to be completely dry; do not attempt to polish to a shine.

Spray-On: Spray on leave on application is recommended for crating a consistent matte finish part. Apply the first coat by spray then use a clean cotton cloth to wipe to an even film. Do not wipe dry. Allow 5 minutes drying time. Apply second spray coat and do not wipe. Allow a final drying time of 30 – 45 minutes for best results.

Re-apply PARTALL[®] POWER Liquid Mold Release as needed to maintain ease of part de-molding or when mold is cleaned again with FORMULA FIVE[®] Mold Cleaner. For maximum performance use full strength. PARTALL[®] POWER Liquid Mold Release may be diluted with water up to 50:50. Spray application recommended for hot molds. If post finishing processes such as bonding or painting are impeded clean parts first with FORMULA FIVE[®] Mold Cleaner.

4 X 1 GALLON (3.79 LITER) BOTTLE PER CASE

DISCLAIMER: The information and recommendations contained herein are, to the best of our knowledge, accurate and reliable. No guarantee of their accuracy is made, however, and the products discussed are sold without warranty, express or implied, and upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses. Revised June 1, 2008.