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PRODUCT DATA SHEET FOR # PW1000: PLASTILEASE PASTE WAX RELEASE 1000 HI/LO TEMP

PRODUCT DESCRIPTION

PW1000 Series Mold Release Waxes are formulated with the help of today's modern chemistry. Thus, they work in extreme conditions of accelerated exothermic (HIGH), high temperature conditions and low to ambient (LOW) temperature conditions.

HI-TEMP and HI-LOW 1000 Waxes contain a blend of synthetic waxes which reduce the quality fluctuations that are found in natural organic waxes, such as carnauba. Synthetic waxes that FK uses in its mold release waxes have high melt points and proper hardness to get the desired properties of film developed on the molds. The resulting film has high gloss and intensive wear resistance under the high or low temperature molding conditions. This assures the easy release.

PLEASE NOTE: DIFFERENT 1000 SERIES WAXES CONTAIN DIFFERENT BLENDS OF SYNTHETIC WAXES AND SOLVENT MIXTURES TO GET THE DESIRED AND UNIQUE PROPERTIES.

APPLICATION

MOLD PREPARATION USING # PW1000 PLASTILEASE PASTE WAX RELEASE 1000 HI/LO TEMP:

Lilly-Ram Chemical Company recommends the following procedures for new molds. The same procedure is also used in its entirety when old molds are sanded, compounded and polished to remove scratches and blemishes after molds are damaged due to their use.

CLEANING:

STEP 1: Clean the new mold by applying one (1) coat of Mold Cleaner & Wax Remover. Agitate and wipe while wet. This will help remove the contaminants and debris which have been dislodged and have become loose from the mold.

STEP 2: Then clean the mold by applying one more coat of Mold Cleaner & Wax Remover as done in Step 1. Let it dry thoroughly and wipe. In some cases a 3rd application may be required. Just make sure it looks and feels clean by running your finger over the edges of the mold. (Please note: never to touch the inside of the mold surface with your fingers because it will leave oils from your fingers tips on the mold surface and it may hinder in sealant bonding.)

SEALING POROSITY:

STEP 3: Now apply a coat of Seal Coat. Allow it to dry thoroughly for about 30-40 minutes, and lightly wipe. (Please note, drying time may depend on weather conditions.)

STEP 4: Reapply another coat and allow it to dry, wipe lightly and let it set for an about 60 minutes. This will allow the polymer to set and bond to the mold surface and will leave a nice intact and uniform film. Wipe the mold dry with a soft clean cloth. It is best to use terry cloth or cotton towels.

APPLYING MOLD RELEASE AGENT:

STEP 5: Apply #PW1000 in Five (5) separate applications. Make sure that each coat is dry prior to wiping. Please criss-cross each application for assuring the complete coverage. Apply wax in a circular motion to work the wax in.

STEP 6: Allow 30 minutes to set after the final wipe. Then re-wipe, pour the first part and release it.

STEP 7: After releasing the part gently wipe the mold, then apply one more coat of wax and release one more part.

AT THIS POINT, MOLD IS CURED TO THE POINT THAT MULTIPLE RELEASES ARE POSSIBLE.

STEP 8: When a part gets a little hard to pull, apply one coat of # PW1000, let it dry and wipe lightly. Run more parts and apply # PW1000 as needed. Use of # PW1000 helps in preventing wax buildup and thus helps in multiple releases

NOTE: While tooling Gel Coat or Green molds, use at least 4 applications of a Seal Coat per the above instructions. Please allow ample time for each coat to dry prior to wiping it and reapplication.

PRECAUTIONS:

1-MAKE SURE EACH COAT OF WAX IS DRY PRIOR TO WIPING IT.

2-ALLOW A MINIMUM OF 30 MINUTES TO DRY EACH COAT OF WAX. IN EXTREME COLD TEMPERATURES AND HIGH HUMIDITY OR INCLEMENT WEATHER, PLEASE ALLOW ADDITIONAL TIME, SAY 45-60 MINUTES, PRIOR TO WIPING. BEFORE WIPING MAKE SURE WAX COATING IS DRY. 3-FOR BEST RESULTS, USE TURKISH TYPE COTTON TOWELING FOR WIPEOFF.

4-IN THE EVENT MOLD HAS BECOME SCARRED OR SHOWS ANY VISIBLE BLEMISHES OR SCRATCHES, RE-WORK THIS AREA OR PREFERABLY THE ENTIRE MOLD BEFORE POURING ANY NEW PART.

NOTE: SOME MOLD MANUFACTURES RECOMMEND THE SPRAYING OF ONE COAT OF PVA OVER WAX FOR SEVERAL RELEASES WHEN BREAKING IN A NEW MOLD. WE RECOMMEND USE OF LR'S MOLD RELEASE FILM MAINLY FOR TOOLING APPLICATION. IT IS A SOLVENT BASED FILM FORMER, IT DRIES QUICKLY AND CAN BE USED OVER PLASTER, ETC. WHERE MOISTURE MAY BE PRESENT. ONCE THE MOLD IS CURED, THIS PROCEDURE CAN BE ELIMINATED AND MULTIPLE RELEASES WAX SYSTEM CAN BE PUT INTO PRACTICE.

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| TYPICAL PHYSICAL CHARACTERISTICS |
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| Weight: | 412 Grams per can |
| Flash Point: | 98 °F |
| Shelf Life: | 1 year from date of shipment |
| Color: | Yellow Paste Wax |
| V.O.C.: | 356.06 Grams per liter |

LILLY-RAMS LIMITATIONS OF LIABILITY

To the best of our knowledge, the data presented here is true and accurate, but is subject to change without prior notice. User is kindly requested to contact Lilly-Ram Chemical Company to verify the correctness before specifying or ordering. Since we don't know how the product will be used we cannot assume any responsibility for its use, performance, or any injuries resulting from its use. Liability, if any, is limited to replacement of defective product. **NO WARRANTY OR GUARANTEE OF ANY KIND IS EXPRESSED OR IMPLIED BY LILLY-RAM CHEMICAL COMPANY.**