PRODUCT DATA SHEET

PARTALL® Film #10

General Product Information

PARTALL® Film #10 is a water/alcohol-based Polyvinyl Alcohol (PVA) solution of water-soluble, film forming materials. It is particularly recommended as a parting agent for separation between polyester or epoxy resins and various mold surfaces. PARTALL® Film #10 is not recommended for use with resins containing water or giving off water during cure (i.e., phenolics). or with automotive finishes as damage may occur.

PARTALL® Film #10 will not shrink or pull away from corners or curved surfaces. Film parts easily from mold surface and is readily dissolved from molded parts and spray equipment with water. An occasional coating of PARTALL® Paste #2 is suggested for most mold surfaces prior to application of PARTALL® Film #10.

Preparing 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. Cleaning with fine steel wool or sandpaper will not affect the high gloss obtained with PARTALL® Film #10 although deep scratches or pits will fill with solution and increase drying time.

Directions for Use

Apply PARTALL® Paste #2 according to instructions prior to use. PARTALL® Film #10 is ready to use as received and should not be diluted. Apply with a spraygun, adjusting air pressure to approximately 90 psi at the gun. Normal spraying distance is 12 to 18 inches.

Apply a mist coat of PARTALL® Film #10 to mold surface followed by at least two flow coats. Allow each coat to dry completely before proceeding (drying time is approximately 10-15 minutes for mist coats and 30-45 minutes for flow coats). A spray density that just allows the liquid to flow together and form a continuous film is ideal. Dry film thickness should be at least 2-4 mils (about the thickness of an industrial-type trash bag) on new or reconditioned molds (1-2 mils on seasoned molds). One gallon will cover about 400 square feet.

Factors such as humidity and proximity to direct sunlight may cause drying time to vary. Make certain that PARTALL® Film #10 is completely dry before proceeding with molding process. Film should be very smooth and glossy when dry. A dull film may result from insufficient spray and may contain pinholes.

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_2 extinguisher, can aid in freeing very rigid parts that cannot be flexed.

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.

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