

PREVENTATIVE MOLD MAINTENANCE

Annually, a great deal of production time is lost due to wax buildup, surface tension and dullness in particularly tight areas over the mold. Subsequently, crazing occurs and eventually parts are lost and there is a need for mold repair and rejuvenation.

FK recommends using:

1. #69: Mold Cleaner & Stripper or #80: Liquid Mold Cleaner or #135-80: Polymer Mold Cleaner and Wax Remover
2. #1000P: Hi-Low Paste Wax and
3. #1000L: Hi-Low Liquid Wax

Processes given below prevent these problems and assist you in keeping your mold in production longer to get better productivity. This translates into reduced costs, better bottom line and increased profit.

ONCE MOLD IS PROPERLY PREPARED ACCORDING TO PROCEDURES OUTLINED EARLIER (NEW MOLD PREPARATION OR REJUVENATION OF OLD MOLDS) AND MULTIPLE RELEASES CYCLE IS WORKING, PLEASE FOLLOW ONE OF THE APPROPRIATE PROCESS OUTLINED BELOW:

PROCESS 1: Apply #1000L: Hi-Low Liquid Wax to the mold over the paste wax when the part gets a little hard to pull between multiple releases. Use of #1000L will liquefy old wax and will reactivate it to make it a part of the mold release agent, thereby avoiding the wax buildup. Thus, the application of #1000L will reduce surface tension, keep the proper amount of Hi-Low Wax on the mold and will achieve problem free and easy releases.

PROCESS 2: FK recommends reapplication of a Paste Wax or mold release agent, over the entire mold along with the application of Liquid Wax after 6-8 releases. Then revert back to use of only #1000L: Hi-Low Liquid Wax. Therefore, use of #1000L on a regular basis will deter wax buildup and most importantly surface tension by keeping a fresh coat of release agent on the surface for better & easy releases.

PROCESS 3: The inevitable thing is that wax will build up no matter what care or precautions you take. So, when wax build-up does take place, areas of dullness will appear and surface tensions will develop around deep corners, contours and radiuses and parts will become a little harder to pull. At this time redo the complete cleanup procedure to prepare the mold. Use either #69 or #135-80 to clean the mold thoroughly by agitating and wiping while wet. Two or three coats may be necessary. This will remove the wax build-up and reduce the surface tension. Then, apply 2 coats of #86 and 3 to 4 coats of Mold Release agent (either #1000P or any other paste wax or #135T) and put mold into production. Following these processes will assure prolonged mold use and will give trouble free and easy releases. Thus, the total work will be reduced and you will achieve more production with better profitability.



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