

# PROCEDURE FOR GLASS & STAINLESS STEEL MOLDS

ALL GLASS MOLDS SHOULD BE MADE UP OF TEMPERED MATERIAL.

## CLEANING:

**STEP 1:** Wash mold with soap & water. Then, apply one coat of #135-80: Polymer Mold Cleaner and Wax Remover. Spread, agitate and wipe wet. Make sure that mold is clean. Wiping wet allows one to pick-up loose debris and contaminants.

**STEP 2:** Apply one more coat of #135-80, agitate and wipe wet. Reapply #135-80 and allow it to dry thoroughly, wipe off film. At this point the surface should be friction free, bright and shiny.

## SEALING POROSITY:

**STEP 3:** Apply 4 consecutive coats of #68: Edge Wax. Spread the wax evenly over the surface of the mold. Allow each coat to haze before buffing it into the mold using a 100% wool cutting pad until the wax disappears and creates a high gloss surface.

## APPLYING MOLD RELEASE AGENT:

**STEP 4:** Apply 5 consecutive coats of #1000P: Hi-Low Paste Wax. Allow each coat to dry thoroughly before wiping it gently.

**STEP 5:** Pour part, inspect mold and apply one more coat of #1000P and proceed with multiple releases..

# PROCEDURE FOR URETHANE & ELASTOMER RESINS MOLDS

## CLEANING:

**STEP 1:** Wash the mold with #80: Liquid Mold Cleaner, agitate and wipe wet. Apply a 2nd coat, let it dry. DO NOT WIPE.

## APPLYING MOLD RELEASE AGENT:

**STEP 2:** Apply 2 consecutive coats of #135ER : Urethane Release Agent and allow each to dry for about 20 minutes. DO NOT WIPE.

**STEP 3:** Now apply 4 consecutive coats of #135ER and let them dry for about 20 minutes between each coat. Do not wipe other coats, but wipe only the last coat.

**STEP 4:** Allow the last coat to cure for about 45 minutes before pouring matrix. Release the part and apply one more coat of #135ER. Now the mold is ready for multiple releases.

**STEP 5:** Reapply #135ER as needed when the part becomes a little hard to pull.



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