

PROCEDURE FOR RESIN TRANSFER MOLDS (RTM) USED WITH DENSIFIED MARBLE & DENSIFIED GRANITE

The following procedures and products are recommended to assure you of proper mold preparation to get clean multiple releases when making densified products using the RTM system.

1. Cleaner—#135-80: Polymer Mold Cleaner and Wax Remover
2. Porosity Sealant—#86: Seal Kote
3. Mold Release Agent—#135T: Polymer Release Agent.

NOTE: THIS PROCESS USED ONLY ONCE ON THE NEW MOLD WILL BE SUFFICIENT TO BREAK IT IN. ON REPAIRED SURFACES PLEASE FOLLOW THE PROCEDURE LISTED BELOW:

CLEANING:

STEP 1: Saturate the cotton cloth with FK'S #135-80 and apply it quite wet and agitate thoroughly. Work a small convenient area at a time, wipe while wet. Continue to clean the entire mold in this manner.

STEP 2: Reapply #135-80 in a light even film while working the product well over all surfaces until a light, waxy film appears. Allow it to dry, wipe with a clean cloth. #135-80 acts as a cleaning and stripping agent.

SEALING POROSITY:

STEP 3: Apply #86 over the entire mold by working down to a light, even and transparent film. Allow it to dry and set for 30 minutes. **DO NOT WIPE.**

STEP 4: Apply a 2nd coat of #86 in the same manner; once again allow it to dry. **DO NOT WIPE.**

STEP 5: Now apply a 3rd coat of #86 in the same manner, but, after letting it dry, wipe lightly to get an even film.

APPLYING MOLD RELEASE AGENT:

STEP 6: Apply #135T in a light, even film over #86. Allow it to dry for 30 minutes and wipe lightly to get a nice gloss.

STEP 7: Apply one more coat of #135T to assure that all the areas, such as radiuses, corners, and wells are completely covered. The little extra here and there will provide extra insurance for easy de-molding. Let this last coat of #135T dry for at least one hour, wipe it lightly with a clean soft cotton cloth to a nice glossy finish. Let it set for additional 15 minutes and place the mold into production. This will effectively start the multiple release cycle.

When parts show surface tension upon demolding and the release is getting harder, reapply a coat of #135T in the same manner.



CAUTION:

1. This entire procedure needs only to be repeated from step 1 if damaged or affected area(s) are repaired by sanding, compounding & polishing. The repair process will strip the mold of all waxes, sealant and mold release agents.
2. Periodically the sealant and the mold release agent film will degrade through the sealer base depending on the amount of granite used and vibrations in the mold. This will show up when you see spot sticking and some areas are getting harder to release. When you observe this, repeat the entire mold prep procedure from the beginning to assure proper mold preparation and easy demolding.
3. An extra coat of #86 on areas showing abrasion will assure additional demolding cycles.



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