

# PROCEDURES FOR BUFFING & POLISHING OF MOLD

**STEP 1:** After sanding, buff the entire mold with FK's #923: Micro Polishing Compound or #440-5: Polishing Compound. Use of a wool cutting pad is recommended. FK's #440-5 is more aggressive than #923. If the mold is not really bad, FK's #923 may be used for finer scratches and blemishes and #440-5 may be used for deeper scratches without sanding. (Selection of either heavy duty compound, mild compound and or polishing compound will depend on what kind of shape the mold is and how much work it requires. Additionally, the selection of product will depend on hardness of the mold surface; harder the surface more aggressive compound you will need. In some cases you might need 3 steps, aggressive compound, mild compound and then polishing compound.)

**STEP 2:** Finish buffing entire mold with FK's #330: Mini Buff. FK recommends use of a 100% soft, lamb's wool finishing pad.

## CLEANING:

**STEP 3:** Apply FK's #135-80: Polymer Mold Cleaner and Wax Remover. Spread, agitate and wipe while wet. For excessive wax buildup or residue, reapply #135-80, allow it to dwell for penetration, then agitate and wipe. Sometimes, 3 applications of #135-80 may be necessary.

## SEALING POROSITY:

**STEP 4:** Apply one coat of #86: Seal Kote. Allow it to dry 30-45 minutes and wipe lightly.

**STEP 5:** Reapply another coat of #86, allow it to dry thoroughly and wipe gently. Let it sit for about 60 minutes. This will allow the polymers to set and bond to the entire mold. Then, wipe it lightly with a clean soft cloth.

## APPLYING MOLD RELEASE AGENT:

**STEP 6:** Apply one of FK's Mold Release Waxes (#1000P: Hi-Low Paste Wax, #1165: Hi-Temp Extra Hard Premium Wax or #333MR: Blue Wax) in 5 separate applications. Wipe lightly after each coat and wait at least 30 minutes between each coat.

**STEP 7:** After applying the final coat of wax, wipe, allow 30 minutes to set, and re-wipe. Pour the first part and release it.

**STEP 8:** Reapply one more coat of wax, pour part and release it. Now the mold is ready for multiple releases, so proceed as in multiple cycles.



**NOTE:** On tooling Gel Coat or Green Molds, FK recommends the use of at least 4 coats of #86 while following the above instructions. Give ample time for each coat to dry prior to wiping and reapplying.



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