

MOLD PREPARATION USING #135T: SEMI-PERMANENT POLYMER RELEASE AGENT

This procedure may be used on New Molds, Reconditioned molds, tooling plugs or Release System Change Over. Some of these molds may have been sanded, compounded or polished.

CLEANING:

STEP 1: Pre-clean the mold with #135-80: Polymer Mold Cleaner & Wax Remover. Soak cloth with the product, apply it to surface, agitate and wipe while wet. Clean small areas at a time and continue in this manner and treat the entire mold.

STEP 2: Apply a 2nd thin and even coat of #135-80. Allow to dry and wipe gently. If there is a heavy wax build up, repeat the cleaning with #135-80 until you are fully-satisfied and the mold is clean.

SEALING POROSITY:

STEP 3: For sealing porosity and to assure a better release, apply 4 coats of #86: Seal Kote. Please allow each coat to dry thoroughly before applying the next coat. Wipe lightly between each coat so that you are leveling the material and not removing it.

APPLYING THE MOLD RELEASE AGENT:

STEP 4: Apply 4 consecutive coats of #135T: Polymer Release Agent and allow each coat to dry a minimum of 10 minutes. **DO NOT WIPE.**

#135T may be sprayed. If sprayed, wipe it lightly over the sprayed film to get uniform coverage.

For Best Results: Use Turkish cotton or terry cloth towels when applying #135T. Apply it in a circular motion overlapping previous areas. Work product thoroughly over the mold creating a thin even coat. Check for uniform coverage.

STEP 5: Apply an extra coat of #135T on all radiuses, corners and wells. Allow it to dry for 15 minutes and then wipe lightly to get an even coat.

STEP 6: Laminate or cast your first part.

STEP 7: Release the part. After this first release, reapply one more coat of #135T. Continue with multiple releases and reapply #135T, as needed when the pull becomes a little hard.



NOTE: We cannot stress enough the importance of the mold being clean prior to applying the release coat. In addition, make sure each coat, including the final coat, is dry and cured prior to casting or wiping. We recommend that each coat of wax or #135T be thin so it will dry better.



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