

FINISH KARE

PRODUCT DATA 333MR BLUE MOLD RELEASE PASTE WAX

PRODUCT DESCRIPTION

A true hard gloss paste wax reformulated to incorporate Hi Temp Multiple Release factors. #333MR - Blue Paste Release Wax contains carnauba, synthetic waxes and hi-heat resins for the effective release of most plastic parts through numerous cycles with a buttery texture for those who prefer an easier on/off application.

APPLICATION

NOTE: BEFORE USING YOUR NEW MOLD, WE RECOMMEND THE FOLLOWING PROCEDURES.

STEP I- Wash entire mold with soap and water (use our Product #118SC Shampoo Concentrate). Rinse clean and wipe dry.

STEP II- Apply one coat of Product #69, agitate and wipe dry.

STEP III- Reapply Product #69, allow to thoroughly dry, wipe off film. Surface should be friction free, bright and shiny.

STEP IV- Apply one coat of #86 Seal Kote, allow to dry 30-45 minutes, wipe dry.

STEP V- Reapply another coat of #86 Seal Kote, allow to dry, wipe until you have a uniform waxy looking film over all, let set for a minimum of one hour (60 minutes) allowing polymer to set and bond to the mold. Wipe dry with a soft clean cloth.

NOTE: ON TOOLING GEL COAT OR GREEN MOLDS, USE 4 APPLICATIONS OF PRODUCT #86 SEAL KOTE AS PER INSTRUCTIONS. GIVE AMPLE TIME FOR EACH COAT TO DRY PRIOR TO WIPE AND REAPPLICATION.

STEP VI- Apply 333MR Blue Mold Release Paste Wax in (5) five separate applications, crisscrossing each application for assurance of complete coverage.

NOTE: To make sure each coat of wax is dry prior to wipe off, allow a minimum of 30 minutes. In extreme cold or inclement weather allow 60 minutes prior to wipe off. Allow to set 30 minutes, re-wipe, lay up and release one (1) part. After final coat wipe off, reapply one coat of 333MR as directed, release part. At this point mold should be cured to the point that extended releases are possible before re-waxing. Knowledgeable personnel should determine the need for re-waxing, and extended releases before re-waxing thereof. For best results, use Turkish type toweling for wipe off. See Mold Maintenance.

NOTE: Some mold manufacturers recommend the spraying of (1) one coat of PVA over wax for several releases when breaking in a new mold. We recommend our PV-6 Mold Release Film, more so for tooling. PV-6 is solvent based, dries faster and can be used over plaster etc., where moisture is present. Again, knowledgeable personnel should determine this requirement before proceeding. Once mold is cured, this procedure can be eliminated, and multiple releases wax system put into practice.

CAUTION: In the event mold has become scarred or shows any visible imperfection (scratches, etc.) After removal of part, this area or preferably entire mold should be reworked prior to additional lay up. See below.

NOTE: If necessary to effect repair, use caution, and perform the following steps. (See system 300 Mold Repair).

TYPICAL PHYSICAL CHARACTERISTICS

Weight per can:	412 Grams
Flash Point:	N/A
Shelf life:	1 year from date of shipment
Color:	Blue
V.O.C.	356.06 Grams per liter