

# MOLD PREPARATION USING #1000P: HI-LOW PASTE WAX

Finish Kare (FK) recommends the following procedures for new molds. The same procedure is also used in its entirety when old molds are sanded, compounded and polished to remove scratches and blemishes after molds are damaged due to their use.

## CLEANING:

**STEP 1:** Clean the new mold by applying one (1) coat of #135-80\*: Polymer Mold Cleaner and Wax Remover. Agitate and wipe while wet. This will help remove the contaminants and debris that have been dissolved, dislodged and have become loose from the mold.

**STEP 2:** Then clean the mold by applying one more coat of #135-80 as done in Step 1. Let it dry thoroughly and wipe. In some cases a 3rd application may be required. Just make sure it looks and feels clean by running your finger over the **edges** of the mold. (Please note: **Never** touch the inside of the mold surface with your fingers because it will leave oils from your finger tips on the mold surface and may hinder sealant bonding.)

## SEALING POROSITY:

**STEP 3:** Now apply a coat of #86: Seal Kote. Allow it to dry thoroughly for about 30-40 minutes, and lightly wipe. (Please note: Drying time may depend on weather conditions.)

**STEP 4:** Reapply another coat of #86 and allow it to dry, wipe lightly and let it set for an about 60 minutes. This will allow the polymer to set and bond to the mold surface and will leave a nice intact, uniform film. Wipe the mold dry with a soft, clean cloth. It is best to use terry cloth or cotton towels.

## APPLYING MOLD RELEASE AGENT:

**STEP 5:** Apply #1000P: Hi-Low Paste Wax in five (5) separate applications. Make sure that each coat is dry prior to wiping. Please crisscross each application to assure complete coverage. Apply wax in a circular motion to work the wax in.

**STEP 6:** Allow 30 minutes to set after the final wipe then re-wipe. Pour the first part and release it.

**STEP 7:** After releasing the part, gently wipe the mold, then apply one more coat of wax and release one more part.

*At this point, Mold is cured to the point that Multiple Releases Are Possible.*

**STEP 8:** When a part gets a little hard to pull, apply one coat of #1000L: Hi-Low Liquid Wax, let it dry and wipe lightly. Run more parts and apply #1000L as needed. Use of #1000L helps in preventing wax buildup and thus helps in multiple releases.

**NOTE:** While tooling Gel Coat or Green molds, use at least 4 applications of #86 per the instructions to the left. Please allow ample time for each coat to dry prior to wiping it and reapplying.

## PRECAUTIONS:

1. Make sure each coat of wax is dry prior to wiping it.
2. Allow a minimum of 30 minutes to dry each coat of wax. In extreme cold temperatures and high humidity or inclement weather, please allow additional time (45-60 minutes) prior to wiping. Before wiping make sure wax coating is dry.
3. For best results, use Turkish-type cotton towel to wipe off.
4. In the event mold has become scarred or shows any visible blemishes or scratches, re-work this area (or preferably the entire mold) before pouring any new part.

**NOTE:** Some mold manufactures recommend the spraying of one coat of PVA over wax for several releases when breaking in a new mold. We recommend use of FK's #PV-6: Spray or Brush Release Agent mainly for tooling application. #PV-6 is a solvent based film former, it dries quickly and may be used over plaster, etc... where moisture may be present. Once the mold is cured, this procedure may be eliminated and multiple releases wax system may be put into practice.

\* #135-80 is one of our newer cleaners. In the past we used to recommend use of #69, which is still available. #135-80 is little expensive compared to #69; however, it is a much better cleaner and will accomplish your cleaning much more quickly and efficiently; thus resulting in overall cost savings. #135-80 contains toluene as one of the cleaning component so it may not be suitable in certain cleaning conditions. Under these circumstances #80 will do a good job for you.



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