

## 1016 Partall Paste Wax



**Overview:** #1016 Partall Paste Wax is a non-silicone green wax specially formulated to produce a tough, durable, high gloss surface. Excellent release characteristics are achieved when used with # 13 PVA. We recommend that new molds are coated with four layers before use. Apply two coats of wax, buff off the excess, and allow standing for an hour before applying the last two coats. The wait is to give solvents extra time to evaporate so a tougher wax barrier develops.

Available in 24 oz and 7 lb containers.

### Features and Benefits:

- **Simple and Reliable**
- **General purpose polishing compound**
- **Made from a blend of hydrocarbon and microcrystalline waxes**
- **Recommended for use on molds where standard silicone waxes hinder post-finishing operations**
- **Use as a primer coat to create a smooth mold surface prior to application of # 13 PVA Release Film**
- **Employed as an inexpensive edge wax on larger molds.**

**Directions:** Using a clean dry rag, apply a thin even coat of #1016 Partall Paste Wax to mold surface, covering 3-4 square foot sections at a time. Excess should be wiped away, also using a clean dry rag. Begin buffing immediately (approximately one minute after application) either by hand or with a power buffer equipped with a terry cloth or lamb's wool pad. Keep power buffer moving constantly so as not to allow a build-up of friction that could burn through the wax coating. Surface should be buffed to a glossy finish.

In order to insure complete coverage, repeat entire process 3-4 times for initial molding cycle. Alternate rubbing motions during application of each coat (i.e. up-down, left-right, circular). Apply one coat of Partall Paste Wax following each cycle thereafter until mold is broken in. Wait at least one hour after application of final coat before proceeding with molding.

For Seasonal Molds, Using the same process described above, apply one coat of Partall Paste Wax to mold surface and buff. Re wax mold as necessary.

The best procedure for separating parts from a mold depends on the size and shape of the part. In most cases a part can be lifted from the mold after loosening around the edges. A jet of air between the part and mold at the edge is sometimes useful. On large curved parts it may be necessary to first tap over the surface with a rubber mallet. A very strong blast of air, or a few squirts with a CO2 extinguisher, can aid in freeing very rigid parts that cannot be flexed.

**Storage:** Keep out of Reach of Children. All containers should be properly labeled to prevent accidental ingestion or improper disposal. Individuals should reseal any partly used material back in the container. Store under cool, dry conditions away from open flames and high temperatures. For more detailed instructions on storage, please see the MSDS Sheet.

**Safety and Handling:** #1016 Partall Paste Wax contains ingredients that could be harmful if mishandled. Contact with skin and eyes should be avoided and necessary protective equipment and clothing should be worn. Individuals should wash with soap and water before eating, drinking, or using toilet facilities. Individuals should observe conditions of good industrial hygiene and safe working practices. For more detailed instructions on handling please refer to the MSDS Sheet.