



PRODUCT DATA SHEET

PARTALL® Film #10

General Product Information

PARTALL® Film #10 is a water and alcohol-based polyvinyl alcohol (PVA) coating comprised of water-soluble, film forming materials. The dry PVA film is resistant to the solvents in the resin system used to make composites parts but is soluble in water. It is particularly recommended as a parting agent for separation between polyester or epoxy resins and various mold surfaces but may be used with most thermoset resins. PARTALL® Film #10 is not recommended for use with resin or substrates containing water or giving off water during cure.

PARTALL® Film #10 parts easily from mold surface and is readily dissolved from molded parts and spray equipment with water. For most composite casting processes PARTALL® Film #10 is used over wax or other mold release agents.

Preparing Mold Surface

Before application of PARTALL® Film #10 porous molds (i.e., plaster or wood) should first be sealed with lacquer or similar coating and waxed. Composites grade sealers and fairing compounds are recommended but a good surface on plaster or wood may be obtained with automobile type primer-sealers and lacquers. Rough wood molds or plugs may be adequately sealed with a number of coats of PARTALL® Paste #2. Apply mold release wax to mold or plug surfaces according to instructions and polish each coat to a shine. Choose PARTALL® Paste #2, FORMULA FIVE® Mold Release Wax, or PARTALL® Hi-Temp Wax according to process requirements.

Directions for Use

PARTALL® Film #10 is ready to use as received and should not be diluted. Preferred application is with a spraygun. Good results may be obtained with a sponge applicator or paint brush or by dipping substrate and draining excess PVA. Recommended air pressure with HVLP spraygun is 22 - 24 PSI (1.5 - 1.7 BAR) at the gun. When using a traditional spraygun adjust air pressure to 60 - 90 PSI (4 - 6 BAR). Normal gun to substrate spraying distance is 12 -18 inches (30 - 45 cm).

On new or unseasoned polyester or vinylester molds, apply multiple coats of PARTALL® Film #10 to surface and allow each coat to dry completely before proceeding. On seasoned mold, apply one or two coats of PARTALL® Film #10. Do not begin molding until PVA on surface is completely dry. Drying time is approximately 15 - 30 minutes per coat depending on ambient temperature and humidity. On new or reconditioned molds dry film thickness should be at least 2 - 4 mils (50 - 100 micrometers), about the thickness of an industrial type trash bag. 1 - 2 mils (25 - 50 micrometers) is recommended on seasoned molds. PARTALL® Film #10 will exhibit a white foamy appearance when sprayed but will dry to a clear coat. Film should not sag or contain runs when applied. If application flaws appear in PVA film wash off with water and begin again. Make certain that PARTALL® Film #10 is completely dry before proceeding with molding process. Film should be very smooth and glossy when dry. A dull, hazy or grainy film may result from too thin a PVA film from insufficient spray - spray PVA to wet look. If spray air bubbles are trapped in PVA film try higher air pressure. One gallon (3.79 liters) covers about 400 feet² (40 m²).

Removing Part from Mold

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. Injecting compressed air between the part and mold at the edge is sometimes useful. On difficult or large parts it may be helpful to introduce water between mold and part to dissolve the PVA parting film helping to float the part free. PVA parting film generally comes off with the part and will need to be renewed on the mold for each part.

55 GALLON (208.2 LITER) DRUM, 5 GALLON (18.9 LITER) PAIL, AND 1 GALLON (3.79 LITER) BOTTLE

AVAILABLE IN GREEN OR CLEAR

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