

SILPAK, Inc

470 E. BONITA AVE. POMONA, CA 91767
PH (909) 625-0056 WWW.SILPAK.COM FX (909) 625-0082

PARTALL FILM #10

Product Data Sheet

PARTALL FILM #10 (PVA) water/alcohol solution of water-soluble, film-forming materials. This parting film is particularly recommended as a parting agent for separation between polyester or epoxy resins and various mold surfaces. It is not recommended for use with resins containing water or giving off water during cure (i.e. phenolics) or with automotive finishes, as damage may occur. Partall Film #10 will not shrink and pull away from corners or curved surfaces. After resin has dried, the film parts easily from the mold and is readily dissolved from the molded parts with water.

Available Sizes: Pint, Quart, Gallon

PREPARATION OF MOLD SURFACE:

Porous Molds (i.e. plaster or wood) must first be sealed with lacquer, Krylon Crystal Clear, or similar coating. Automotive primers and sealers work well on plaster molds. Plaster molds must first be thoroughly dried. *****Mold surfaces should be free of other parting agents, especially those containing silicone.***

APPLYING RELEASE:

PARTALL #10 is supplied ready to use and should not be diluted. It is recommended that a spray gun at 80-90 PSI be used to apply release, but brushing, rolling or sponging will work in less critical applications.

Best results are achieved with as fine a spray as possible. To achieve this result, use a small orifice in the gun, close the needle about halfway, and adjust the air pressure to 80-100psi at the gun (setting may vary depending on the equipment used). Normal spraying is from 12-18 inches from surface.

1. Apply a thin mist coat first and allow to dry completely (approximately 10-15 minutes). Follow with two heavier flow coats allowing each coat to dry completely before proceeding (approximately 30-45 minutes). A spray density that just allows the liquid to flow together and form a continuous film is ideal.
2. Dry film thickness must be at least 2-4 mils on new or reconditioned molds and 1-2 mils on seasoned molds (Industrial Trash Bag is 2 mils thick). **COVERAGE GALLON: 400 ft²**
3. Drying time per coat is approximately 15-45 minutes (depending on thickness) with normal application. External ambient factors such as humidity, heat, proximity to sunlight, and the use of fans or heaters can cause drying time to vary. Film must be completely dry before proceeding with molding. Applying additional coats before a previous coat has dried thoroughly can compromise the effectiveness of release. **Film should be smooth and glossy when dry**—a dull film may result from insufficient spray and may contain pinholes.

CHARACTERISTICS

APPEARANCE:	Low Viscosity, Green Liquid
NON-VOLATILE:	9.5%
WEIGHT PER GALLON:	8 lbs./gallon
FLAMMABILITY:	FLAMMABLE
SOLVENT CARRIER:	Isopropyl Alcohol/Water
COVERAGE:	400 ft ² @ 2 mil thick

THE INFORMATION AND DATA CONTAINED HEREIN ARE BASED ON INFORMATION WE BELIEVE RELIABLE. EACH USER OF THE MATERIAL SHOULD THOROUGHLY TEST ANY APPLICATION, AND INDEPENDENTLY CONCLUDE SATISFACTORY PERFORMANCE BEFORE COMMERCIALIZING. SUGGESTIONS OF USES SHOULD NOT BE TAKEN AS INDUCEMENTS TO INFRINGE ON ANY PARTICULAR PATENT.