



PRODUCT DATA SHEET

FORMULA FIVE® Mold Cleaner

General Product Information

FORMULA FIVE® Mold Cleaner is a general purpose mold cleaner for routine mold maintenance. Use prior to application of FORMULA FIVE® Mold Sealer and FORMULA FIVE® Matte Top Coat semi-permanent release. Suitable for use on most mold substrates including those composed of fiberglass, aluminum, steel and thermoset resins. Cleans without abrasives and can be used between molding cycles to remove uncured resin or overspray and other contaminants without stripping off underlying coat of semi-permanent mold release. Dissolves build up on mold surfaces caused by wax, silicone, and other contaminants such as grease and dirt, allowing them to be wiped off without softening or dulling the surface. Can be used to remove excess semi-permanent mold releases before they fully cure, and can be used to reduce surface tension of semi-permanent mold releases in areas of the mold that exhibit gelcoat pre-release. Use to clean areas of mold before touch up with semi-permanent mold release during production. Useful to remove residues from other cleaners/strippers or spots from water washing. May be used on warm molds. Not designed to remove fully cured semi-permanent mold releases.

Preparing Mold Surface

FORMULA FIVE® Mold Cleaner is ready to use as received. Do not dilute or mix with other products or solvents. Prior to use on rubber molds, thoroughly test for compatibility on a non-cosmetic portion of the mold. Do not reuse contaminated cloths to apply. Do not return contaminated product to original container.

Directions for Use

Consult Material Safety Data Sheet (MSDS) prior to use. FORMULA FIVE® Mold Cleaner should always be used in a well-ventilated area with appropriate personal protection equipment, including solvent resistant gloves.

Apply FORMULA FIVE® Mold Cleaner with a damp cotton cloth to mold surface prior to touch up with semi-permanent mold release during production, to remove light resin scumming or excess uncured semi-permanent mold release, or to reduce the surface tension of molds prepared with semi-permanent mold releases. Using a fresh clean cloth, gently wipe away dissolved residue before cleaner dries. Prior to applying mold release perform tape test in several locations to verify entire surface is clean (if tape adheres very well, your mold is clean).

LARGER SURFACES / HEAVY DEPOSITS: On larger surfaces work on manageable sections no larger than 5 ft² (0.5 m²) at a time. Repeat on neighboring areas, overlapping to ensure complete coverage of mold surface. For removal of heavier wax or contaminant deposits apply FORMULA FIVE® Mold Cleaner with a wet cotton cloth or stiff solvent resistant bristle brush. Work cleaner over mold surface with brush. Wipe away dissolved residue before cleaner dries with clean cotton cloths. Several applications may be necessary to remove stubborn deposits. For removal of extremely heavy build up use FORMULA FIVE® Wax Stripper or compound mold before cleaning.

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

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