



## Product Bulletin PARTALL® One-Coat

### General Product Information

PARTALL® One-Coat is a water-based Polyvinyl Alcohol (PVA) coating comprised of water-soluble, film forming materials. It is particularly recommended as a parting agent for separation between polyester or epoxy resins and various mold surfaces. PARTALL® One-Coat is not recommended for use with resins containing water or giving off water during cure (i.e., phenolics).

PARTALL® One-Coat will not shrink or pull away from corners or curved surfaces. Film parts easily from mold surface and is readily dissolved from molded parts and application equipment with water.

### Preparing Mold Surface

Porous molds (i.e., plaster or wood) must first be sealed with lacquer or similar coating. A good surface on plaster may be obtained with automobile type primer-sealers and lacquers. Mold should be thoroughly dry and free of contaminants.

### Directions for Use

PARTALL® One-Coat is ready to use as received but may be diluted with clean water to suit application method. Apply one coat to mold surface with a brush, sponge, or roller and allow to dry completely before proceeding. If size and shape of mold allow, application may be made by flooding the mold surface and tipping to drain off excess. If sprayed onto mold, PARTALL® One-Coat will attain a white foamy appearance but will dry to a clear coat. A dull film may result from insufficient spray and may contain pinholes.

Do not begin molding until surface is completely dry. Drying time is approximately 120 minutes assuming 70 °F (21 °C) at 50% relative humidity.

Dry film thickness should be at least 2-4 mils (about the thickness of an industrial-type trash bag) on new or reconditioned molds and at least 2 mils on seasoned molds. A wet film thickness of 6 mil should yield a dry film thickness of approximately 2 mil. PARTALL® One-Coat will attain a white foamy appearance when sprayed but will dry to a clear coat. Film should not sag or contain runs when applied; drying time will be increased in areas where PARTALL® One-Coat is allowed to pool or sag.

Factors such as humidity and ambient air temperature may cause drying time to vary. Make certain that PARTALL® One-Coat is completely dry before proceeding with molding process. Film should be relatively smooth and glossy when dry although some air bubbles may remain. Normally applied over mold release wax such as PARTALL® Paste #2 or FORMULA FIVE® Mold Release Wax.

*55 GALLON (208.2 LITER) DRUM AND 5 GALLON (18.9 LITER) PAIL  
AVAILABLE IN CLEAR OR TINTED*

DISCLAIMER: The information and recommendations contained herein are, to the best of our knowledge, accurate and reliable. No guarantee of their accuracy is made, however, and the products discussed are sold without warranty, express or implied, and upon condition that purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses. Revised June 1, 2008.

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