



## PRODUCT DATA SHEET

# PARTALL® Paste #2

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### General Product Information

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PARTALL® Paste #2, “The Original Green Wax”, is a general purpose polishing compound and mold release made from a blend of hydrocarbon and microcrystalline waxes. For use with thermoset molding resins at ambient temperature cure when making fiberglass, cast polymer or composites parts. It is particularly recommended for use on molds where standard silicone waxes hinder post-finishing operations or as a primer coat to create a smooth mold surface prior to application of PARTALL® Film #10 or PARTALL® Coverall Film. PARTALL® Paste #2 may also be employed as an economical edge wax on larger molds, and is used to seal rough wood molds or plugs for casting composites, cements and grouts. Unregulated for shipping.

Use with PARTALL® Film #10 or PARTALL® Coverall Film PVA parting films for initializing new or reconditioned polyester and vinylester molds.

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### Preparing Mold Surface

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Before application of PARTALL® Paste #2 porous molds (i.e., plaster or wood) should first be cleaned and sealed. 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. For non-cosmetic parts with rough wood molds or plugs a number of coats of PARTALL® Paste #2 should adequately seal the surface.

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### Directions for Use

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Using a clean dry cloth, apply a small amount of Partall® Paste #2 to mold surface in a thin even coat. 0.5 - 1.0 gm is enough for about one square yard (1-meter<sup>2</sup>). Turn over cloth and begin buffing immediately by hand (within one minute after application). On larger molds or plugs work on smaller sections at a time or have second operator follow to polish. Power buffer equipped with a terry cloth or lamb’s wool pad will reduce labor time on larger molds. Surface should be buffed to a glossy finish.

Complete surface coverage is more important than a thick film of wax. In order to insure complete coverage, repeat application and polishing process 3 times for initializing new or reconditioned molds or plugs. Alternate direction of application of each coat (i.e., zero degrees, 90-degrees, circular, etc.) Polish each coat before applying the next.

Apply one coat of Partall® Paste #2 polishing to a shine following each cycle thereafter until mold is broken in. Re-wax mold as necessary throughout production.

Partall® Paste #2 may be used as an effective edge, hat or slurry wax applied in a thicker coats without polishing to a shine.

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### Removing Part from Mold

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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. On large curved parts it may be necessary to first tap over the surface with a rubber mallet. A strong blast of compressed air, or a few squirts with a CO<sub>2</sub> extinguisher can aid in freeing very rigid parts that cannot be flexed.

*200 POUND (90.7 KILOGRAM) DRUM, 25 POUND (11.3 KILOGRAM) PAIL, 7 POUND (3.18 KILOGRAM) PAIL, 1.5 POUND (680 GRAM) TIN*  
*AVAILABLE IN GREEN OR CLEAR*

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