



PRODUCT DATA SHEET

PARTALL® Coverall Film

General Product Information

PARTALL® Coverall Film 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® Coverall Film 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® Coverall Film 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 spray equipment with water. An occasional coating of PARTALL® Paste #2 is suggested for most mold surfaces prior to application of PARTALL® Coverall Film.

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 other parting agents. Cleaning with fine steel wool or sandpaper will not affect the high gloss obtained with PARTALL® Coverall Film although deep scratches or pits will fill with solution and increase drying time.

Directions for Use

Apply PARTALL® Paste #2 according to instructions prior to use. PARTALL® Coverall Film is ready to use as received and should not be diluted. Apply with a spraygun or brush: when using spraygun adjust air pressure to approximately 60-90 psi at the gun. Normal spraying distance is 12-18 inches.

On new or unseasoned molds, apply two coats of PARTALL® Coverall Film to surface and allow each coat to dry completely before proceeding. On seasoned mold, apply one coat of PARTALL® Coverall Film. Do not begin molding until surface is completely dry. Drying time is approximately 30-60 minutes per coat with normal application. Dry film thickness should be at least 2-4 mils (about the thickness of an industrial-type trash bag) on new or reconditioned molds (1-2 mils on seasoned molds). PARTALL® Coverall Film will attain a white foamy appearance when sprayed but will dry to a clear coat. Film should not sag or contain runs when applied. One gallon covers about 500 square feet.

Factors such as humidity and proximity to direct sunlight may cause drying time to vary. Make certain that PARTALL® Coverall Film is completely dry before proceeding with molding process. Film should be very smooth and glossy when dry. A dull film may result from insufficient spray and may contain pinholes.

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. A jet of air between the part and mold at the edge is sometimes useful. On large curved parts it may be necessary to first tap over the surface with a rubber mallet. A very strong blast of air, or a few squirts with a CO₂ extinguisher, can aid in freeing very rigid parts that cannot be flexed.

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