

## **RF-5215 (PVA)**

### **WATER SOLUBLE PARTING FILM**

### **NON-FLAMMABLE FORMULA**

RF-5215 is a water-soluble parting film (PVA) recommended for separation between polyester, epoxy and polyurethane resins from various mold surfaces. It is typically applied by a siphon cup spray gun. After the part has been separated from the mold surface, release film RF-5215, can be easily stripped and washed from the mold or model with water. RF-5215 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.

| PHYSICAL PROPERTIES  | RESULTS                                       |
|----------------------|---|
| Color                | Purple  |
| Flash Point (TAG CC) | >200°F (93.3°C)                               |
| Water Soluble        | Flows easily. Material should not be diluted. |

#### **DIRECTIONS:**

Best release results will occur if a coating of Partall Past Wax, or equivalent, is applied on the surface to be released before application of RF-5215. Porous molds such as a plaster or wood must be sealed with lacquer or a similar coating prior to using a paste wax.

RF-5215 can be applied by spray or brush method with spraying being preferred. Use care to insure complete coverage of all areas to be released. Spray application is recommended using an air pressure of 60-90 psi, depending on the equipment being used. Normal spraying distance is from 12-18 inches and light uniform coats are applied to avoid runs or drips.

New molds will require two coats of RF-5215. The initial coat must dry before application of the second coat and the second coat must also dry completely. Drying time per coat is approximately 30-60 minutes, but may vary due to external factors such as humidity.

Seasoned molds will generally require only one coat of RF-5215. Dry film thickness must be at least 2-4 mils on new or reconditioned molds and 1-2 mils on seasoned molds.

#### **STORAGE:**

Store at ambient temperatures, 65-80°F (18-27°C). Unopened containers will have a shelf life of 12 months from date of shipment when properly stored at recommended temperatures. Purge opened containers with dry nitrogen before re-sealing.

#### **IF CONTACT OCCURS:**

**Skin:** Immediately wash with soap and water. Remove contaminated clothing and launder before reuse. Seek qualified medical attention if allergic reactions occur.

**Eyes:** Immediately flush with water for at least 15 minutes. Call a physician.

**Ingestion:** If swallowed, call a physician immediately. Remove stomach contents by gastric suction or induce vomiting only as directed by medical personnel. Never give anything by mouth to an unconscious person.

**Refer to the Material Safety Data Sheet before using this product.**