



CUSTOMER SERVICES BULLETIN

WAXING A FIBERGLASS PLUG & MOLD

Prior to waxing a fiberglass plug or mold, it must be let to cure for at least seven days. If the plug or mold is oxidized it must be wet-sanded with 600 grit wet/dry sandpaper and followed with 1200 grit wet/dry sandpaper.

Aqua-Buff 1000 Fast Cut Compound is applied next. This is a medium abrasive cut polish compound which effectively reduces the marks left by the 1200 grit wet-sanding. See the "How to Cut Polish Gelcoat" bulletin for info on applying the Aqua-Buff 1000.

Next, an application of Aqua-Buff 2000 Compound and Polish is applied. This is a fine glaze which will provide a mirror finish to the surface of the plug or mold. See the "How to Cut Polish Gelcoat" bulletin for info on applying the Aqua-Buff 2000.

The application of a mold release wax is an important step in the performance and life expectancy of the plug and mold. Five relatively thin coats of mold release wax, such as Oscar's OP 600, is recommended. This wax is in a paste form and contains high carnauba content, and is similar in looks and application to car wax. Using a clean, lint-free cloth, apply the first coat by hand using an overlapping, circular motion paying close attention to make sure that wax is rubbed into all radius areas, nooks and crannies. Allow to dry to a complete haze (approximately 20 – 30 minutes) and polish up by hand using a clean, dry, lint-free cloth. Allow two hours between coats of wax to permit solvent to flash off before applying the second coat. Repeat waiting period between subsequent coats.

After the final coat of wax, allow the mold to sit at room temperature overnight. This will set and harden the carnauba wax. After this point, the surface may be buffed to a high gloss, mirror finish.

Once the wax has been applied, cured and buffed, P.V.A. (Poly Vinyl Alcohol) can be applied to the surface by spraying or using a soft, lint-free cloth, sponge or brush. Allow the P.V.A. to dry for 30-60 minutes before applying gelcoat.

For new molds, it is advisable to re-buff the surface and apply 1-2 additional coats of wax and re-apply the P.V.A. For molds already in use, buff the surface to a gloss. Re-waxing is not always necessary for molds in constant production.

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