

## AN Series

### *Non-skid and Textured Patterns for Plugs and Molds*

**Quick and  
Easy Apply Sheets**

**Adhesive Pre-Applied**

**Friendly to Environment**

**Available in sizes 1' x 1'  
up to 4' x 12' depending  
upon pattern and builders  
requirements.**



### **General Information**

Plug surface can have 220 grit scratch to a polished wax free surface for good adhesion. Bare wood must be sealed.

A water based release agent has been applied to the FLEX-MOLD. Its purpose is to provide some lubrication to aid smoothing down during application and offer added release protection. We recommend that you apply your own release over the entire surface.

Some vinyl ester gelcoats are affected by chemicals in our FLEX-MOLDS. With the application of a silicon free wax and a PVA release system will solve this problem.

We recommend that you pre-test your brand of gelcoat and release system.

One pull is all that can generally be expected. Some have reported more. We believe because of the softness of the rubber and the fact that gelcoat shrinks down tightly, it will form thousands of little suction cups. If the FLEX-MOLD comes out with mold, it is easily peeled out. If mold seems more difficult than usual to separate from plug, use steady pressure and give the adhesive time to release.

### **Important Information**

Bottom edge of FLEX-MOLD should be radiused into plug surface with any fillet material of your choice or you can sand a radius once the female mold is made.

**WARNING!!!** *It is important to smooth edges or the result will be poor appearance of the part and chipping out of the mold.*

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## Application Procedures



**1** For a good degree of accuracy, cut FLEX-MOLD pattern from a plywood template.



**2** After FLEX-MOLD pattern is cut, place on top of template or other appropriate fixture. Using no coarser than 220 grit sand paper, block sand a taper or radius edge on FLEX-MOLD or use Gibco FLEX-MOLD edge tool. If you cut to much, fiber of the reinforcing material will show.



**3** After sanding edge, clean sanding debris from FLEX-MOLD. Dampen cloth with acetone and wipe edge to help smooth rubber.



**4** Turn FLEX-MOLD over and clean back side. Make sure gap between tape stripes are not contaminated with sawdust or other debris. Use no solvent.



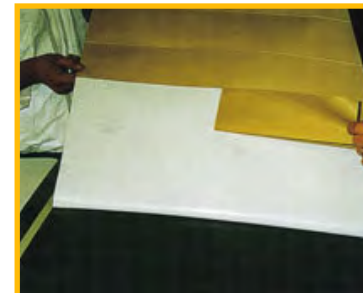
**5** On a clean and wax free plug surface, apply adhesive promoter as directed. Let flash off. (Promoter provided Continental U.S. only)



**6** Place FLEX-MOLD into position and secure in place with tape. Lift one end and remove one or two strips of the release paper.



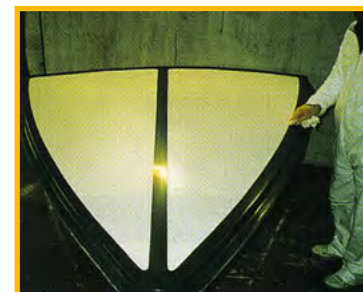
**7** Smooth down FLEX-MOLD from inside toward outer edge in a manner as to not trap air.



**8** Lift other end of FLEX-MOLD. Continue to peel off paper strips two or three at a time.



**9** Smooth down FLEX-MOLD as you proceed. DO NOT PULL OR STRETCH FLEX-MOLD. This will hamper spot repair procedures of part or mold, should it ever be necessary.



**10** Once FLEX-MOLD is in place, clean plug surface around edge with acetone to remove excess adhesive promoter.