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Meguiar's International Headquarters:  
Suite 6-7, 20/F Marina House, 68 Hing Man Street, Shaukeiwan, Hong Kong  
Phone: 852-2967-0202 Fax: 852-2967-6968



# Application Guide



MV-81



MV-82



MV-83



MV-85



## THE HISTORY

In the 1950's Meguiar's invented the worlds first mold release paste wax for the FRP industry. Today Meguiar's mold release products have become an industry standard and can be found in quality fiberglass factories all around the world.



Not only does Meguiar's offer great mold release wax, it also offers mold compound, mold polish and all the tools necessary to maintain a fiberglass mold, such as: sandpaper, sanding backing pad, wool pad, foam pad, pad washer, applicator pad and even towels!



Although the traditional Meguiar's mold release system consisting of *M-01*, *M-03* and *M-08* are still the most popular products used in fiberglass factories around the world, Meguiar's is now proud to present the most advanced mold release system to the fiberglass industry - *Velocity*. *Velocity* is Meguiar's latest- liquid mold release system that can save time and cost, while producing incredibly high gloss parts that need no buffing or painting after being released! Please read the rest of the book to find out how to start using these amazing products today!



## STEPS TO COMPLETE THE VELOCITY SYSTEM

1. Clean & Inspect the Mold Surface with *M34 Final Inspection®* then inspect the mold surface.
2. Use *Unigrit®* sandpaper to remove defects.
3. Compound with *MV81 Velocity™ 81 Mold Compound* to remove sanding marks.
4. Polish with *MV82 Velocity™ 82 High Gloss Polish* to restore gloss.
5. Apply *MV83 Velocity™ 83 Liquid Mold Sealer* (optional).
6. Apply *MV85 Velocity™ 85 L.E. Low Emission Mold Seal & Release Agent*.

## STEP 1: CLEAN THE MOLD

Clean and Inspect the mold with *Final Inspection®* (M34) and an *Ultimate Wipe®* (M9910) microfiber towel to remove dust and other loose contaminants from the surface. These contaminants can result in deep scratches during sanding and buffing.

Remember: a clean mold produces high quality parts!



M9910



M3401

M3416



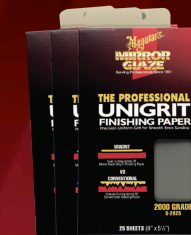
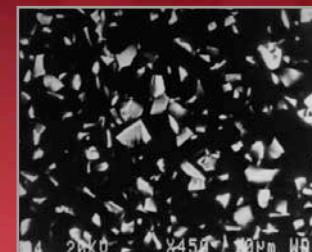
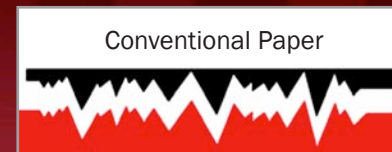
## STEP 2: SANDING



1. Soak the *Unigrit™* sand paper in water for at least 15 minutes before use.
2. Always try to use the least aggressive sand paper first.
3. Keep the surface very wet during sanding.
4. Use the Meguiar's *E7200 Backing Pad* to ensure even sanding marks and uniform sanding.
5. After 10 passes, wipe off the water and inspect the surface.

## STEP 2 - APPLICATION TIP:

Why Meguiar's *Unigrit™* papers are better.



S1025 = 1000 grit  
S1225 = 1200 grit  
S1525 = 1500 grit  
S2025 = 2000 grit  
S2525 = 2500 grit



E7200

Meguiar's *Unigrit™* sand paper and *E7200 Backing Pad* ensure even sanding marks that will save buffing time and remove less gel coat from the mold. *Unigrit™* papers are extremely uniform eliminating the deep scratches that result from ordinary papers. Deep scratches mean more sanding and more polishing.

## STEP 3: COMPOUND TO REMOVE SANDING MARKS



1. Thoroughly clean the wool pad using the 90-2000P Pad Washer.



2. Apply MV81 compound directly to the mold.



3. Keep the W4000 wool pad flat on the surface while buffing.



4. See the amazing shine!

### Key Products for Step 3:

Velocity MV8101 Mold Compound removes sanding marks quickly & leaves an amazing swirl-free finish!



Meguiar's Dispenser Bottle - M9912



Meguiar's Cut 'N Shine Wool Pad - W4000 is a high quality single-sided wool pad with Velcro backing.



Meguiar's Double-Sided Wool Cutting Pad - W5000 is the new double-sided wool pad with woven fibers that cut faster than ever!

## STEP 3 - APPLICATION TIP:

### Why Meguiar's Compound is Better.

Meguiar's Velocity MV-81 Mold Compound is unlike any other compound. It uses the latest *Diminishing Abrasive™* technology. MV-81 has the ability to break down during buffing removing the sanding marks quickly but leaving a very fine finish. Even using the quickest and most aggressive W5000 Wool Pad, this compound leaves a glossy finish that requires very little polishing in the next step!



MV8101



## STEP 4: POLISH - RESTORING HIGH GLOSS



1. Clean the foam pad using the 90-2000P Pad Washer.



2. Apply MV82 polish directly to the mold.



3. Keep the foam pad flat on the surface while buffing.



4. Super High Gloss Finish!

### Key Products for Step 4:

Velocity MV8201 High Gloss Polish provides ultra high gloss finish to mold surface which results in finished parts that exceed Class "A" standards.



Meguiar's  
Dispenser Bottle  
- M9912



Meguiar's Softbuff™  
Polishing Pad  
- W8000 / W8006



Rotary Backing  
Plate - W65

## STEP 4 - APPLICATION TIP:

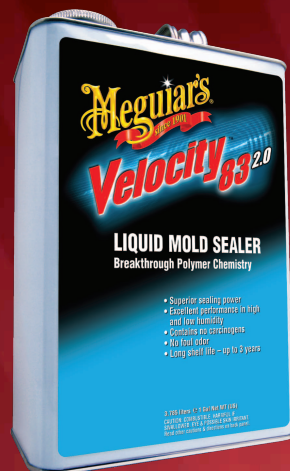
### Why Meguiar's MV-82 High Gloss Polish is Better.



Meguiar's *Velocity MV-82 High Gloss Polish* is the new & improved *M-03 Machine Glaze*. MV-82 is water based which makes it safer to use before a liquid release agent. This polish gives an amazing gloss, & now it comes in a stronger 1-gallon bottle!



M9912 is the Meguiar's plastic dispenser bottle. Save time & effort by first pouring the product from a 1-gallon bottle into this convenient dispenser is perfect for MV-81, MV-82, MV-83 & MV-85!



**MV-83 Liquid Mold Sealer**  
**MV8301**

## STEP 5: VELOCITY MOLD SEALANT (OPTIONAL)

1. Apply 1 thin coat of *MV-83 Liquid Mold Sealer* to the newly polished mold. For detailed application instructions, please refer to page 14.
2. Wait 15 minutes for the MV-83 to cure.
3. Apply a second thin coat of MV-83 to the mold.
4. Wait 15 minutes for the second coat to cure.
5. The mold is ready for Step 6.

### APPLICATION TIP

Meguiar's *Velocity MV-83 Liquid Mold Sealer* is a highly advanced liquid mold sealant that was created through breakthrough polymer chemistry. When applied to a mold before the release agent, it can result in up to a 20% increase in the number of releases.



**MV-85 Mold Seal & Release**  
**MV8501**

## STEP 6: VELOCITY LIQUID SEALANT / RELEASE

1. Apply 1 thin coat of *MV-85 Mold Seal & Release* to the mold. For detailed application instructions, please refer to page 14.
2. Wait 15 minutes for the MV-85 to cure.
3. For new or newly polished molds, repeat this process 6 times.
4. For molds that have already been sealed with *MV-83 Liquid Mold Sealer*, repeat this process only 4 times.
5. After the last coat of MV-85, wait 30 minutes before laying down the gel coat.

### APPLICATION TIP

Meguiar's *Velocity MV-85 Mold Seal & Release* is a high performance formula derived from a totally new chemistry that was created for high production factories who require more releases, & desire the highest gloss parts. MV-85 not only delivers amazing releases, it also has no foul smell & is a low emission product.

## APPLICATION METHOD FOR MEGUIAR'S VELOCITY MV-83 & MV-85



1. Cut a 100% cotton towel into 10x10 cm squares.



2. Apply product to the center of the towel.



3. Apply a thin layer of product to the mold.



4. Wipe up the excess immediately with a paper towel.

Do not let the product sit for more than 10 seconds before wiping.



5. Wipe it again with a 100% cotton towel to leave a perfectly even coat of product.

## MEGUIAR'S VELOCITY APPLICATION METHOD FOR LARGE MOLDS

When working on a large mold, we recommend working with two people. The first person applies the product as instructed on page 14. The second person follows the first person - wiping first with a paper towel in the left hand and then wiping again with a 100% cotton towel in the right hand.

Do not let the product stay on the surface for more than 10 seconds before wiping.



Person 1:  
Apply the product with a 100% cotton towel.



Person 2:  
1. Wipe with a paper towel.  
2. Wipe again with a 100% cotton towel.





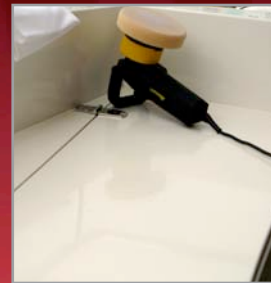
## PROTECTING THE FINISHED PART WITH MEGUIAR'S CLEANER WAX



1. Apply M-50 Marine One Step Cleaner Wax to the W8006 foam pad.



2. Put the G220EU flat on the surface & then turn it on. Move it over the whole surface evenly.



3. Let the wax dry for 1-2 minutes then wipe off with a clean towel & see the amazing shine & deep protection!

### Key Products for Step 4:

Marine One Step  
Cleaner Wax  
M5001 (1 gallon)  
M5016 (16 oz)



Dual Action Polisher  
G220EU

Meguiar's Softbuff™  
Polishing Pad  
W8006



Softbuff™ Terry Towels  
X2050

## APPLICATION TIP

Using the Meguiar's G220EU Dual Action Polisher and M-50 Marine One Step Cleaner Wax is the very best way to protect your finished part & ensure that it arrives to the customer in the best possible condition. Especially for boat yards who need to apply a protectant wax before shipping the finished boat, the G220EU offers a super fast way to apply a protectant wax to a large boat. It also comes with a carrying case and all the necessary tools.



Marine One Step Cleaner Wax  
M5001 (1 gallon)  
M5016 (16 oz)



Dual Action Polisher  
G220EU

Meguiar's Softbuff™  
Polishing Pad  
W8006



## MEGUIAR'S MOLD RELEASE PRODUCTS

### Velocity 81 Mold Compound - MV8101

- For molds & finished parts
- Diminishing Abrasives cut fast & save time
- Removes sanding marks
- Excellent for removing sealer, release, & styrene build-up
- Water-based, low V.O.C.'s

#### Usages Tips:

- Use with a wool pad like the W4000 or W5000
- Follow the application directions on page 8



### Velocity 82 High Gloss Polish - MV8201

- For molds & finished parts
- Prepares mold for sealing
- Creates a smooth, high gloss finish
- Removes fine scratches & minor defects
- Restores high gloss after compounding
- Water-based, low V.O.C.'s
- Pleasant scent

#### Usages Tips:

- Use with W8000 Softbuff™ Foam pad
- Follow the application directions on page 10



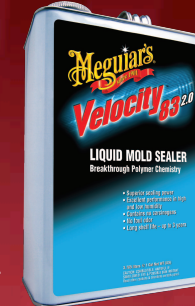
## MEGUIAR'S MOLD RELEASE PRODUCTS

### Velocity 83 Liquid Mold Sealer - MV8301

- Superior sealing power
- Excellent performance in high & low humidity
- Contains no carcinogens
- No foul odor
- Long shelf life - up to 3 years

#### Usage Tips:

- Apply using the directions on page 14
- When used before the release agent MV83 can improve the number of releases by 20%.



### Velocity 85 Mold Seal & Release - MV8501

- Seal & release in only one step.
- Consistent, fast, easy release
- Produces ultra high gloss results
- Reduces finished part buffing
- Excellent performance in high & low humidity
- Contains no carcinogens
- No foul odor
- Long shelf life - up to 3 years

#### Usage Tips:

- Apply using the directions on page 14



## MEGUIAR'S MOLD RELEASE PRODUCTS

### Double-Sided Wool Cutting Pad - W5000

- Aggressive cutting-action without leaving difficult to remove swirl marks
- Removes serious surface imperfections
- Fastest cutting Meguiar's wool pad



#### Usage Tips:

- Use only one product per individual pad
- Recommended buffing speed for a rotary buffer is 1500 to 2000 RPM
- Clean the pad using the 90-2000P pad washer or by running a wool pad cleaning spur over the pad surface with a rotary buffer turned on

### Cut N Shine Wool Pad - W4000

- Aggressive cutting-action without leaving difficult to remove swirl marks
- Removes serious surface imperfections
- Quick change Velcro backing system fits perfectly with the W65 backing plate for fast & convenient pad changing



#### Usage Tips:

- Use only one product per individual pad
- Recommended buffing speed for a rotary buffer is 1500 to 2000 RPM
- Clean the pad using the 90-2000P pad washer or by running a wool pad cleaning spur over the pad surface with a rotary buffer turned on

## MEGUIAR'S MOLD RELEASE PRODUCTS

### Softbuff™ Foam Polishing Pad - W8000/W8006

- Active polishing action removes minor surface imperfections
- Restores high gloss
- Exclusive foam cell structure improves air flow
- Quick change Velcro backing system



#### Usage Tips:

- Use only one product per individual pad
- Recommended buffing speed for a rotary buffer is 1500 to 2000 RPM
- Keep the pad flat against the surface to prevent swirls
- Clean the pad with a soft brush while the buffer is turned on

### Rotary Buffer Backing Plate - W65

- Fits perfectly with the new W4000 & W8000 pads
- Quick & easy change from wool to foam pad
- Center button helps easily center the pad on the backing plate



#### Usage Tips:

- Center the W4000 or W8000 on the backing plate using the middle hole



## MEGUIAR'S MOLD RELEASE PRODUCTS

### Medium-Cut Cleaner - M0164

- Machine applied abrasive cleaner for buffing out blemishes, light abrasions & sanding marks
- Diminishing Abrasives™ cut quickly then reduce to a polishing rouge
- Excellent for buffing off wax buildup when used on a regular maintenance schedule

#### Usage Tips:

- Apply with a rotary buffer and *Meguiar's Cut 'N Shine W4000 wool pad*
- Follow with *Machine Glaze (M-03)* & the *Softbuff™ W8000 polishing pad*



### Machine Glaze - M0364

- Creates spectacular, deep clear gloss
- Specially formulated polish to remove any imperfections left after cleaning the mold with *Medium-Cut Cleaner (M-01)*
- Buffing residue wipes off easily
- Chemically balanced with *Medium-Cut Cleaner* to ensure complete compatibility with all *Meguiar's Mold Release Waxes*

#### Usage Tips:

- Apply with a rotary buffer and *Meguiar's Softbuff™ W8000 polishing pad*



## MEGUIAR'S MOLD RELEASE PRODUCTS

### Maximum Mold Release Wax - M0811

- Provides the maximum number of releases per wax application
- Costly blend of imported waxes
- The industry's first & still most widely used mold release wax

#### Usage Tips:

- Apply evenly to surface by hand
- Allow sufficient time for wax to set up on mold surface (approximately 5 to 10 minutes depending on climatic conditions)
- When wiping off, first use one side of the towel to remove excess wax, then use the other side to buff remaining residue to a high gloss finish



### Universal Mold Release Wax - M8811

- Easy to use, high performance product with complete versatility
- Ideal for use on plugs, new molds, production molds & even as a storage wax
- Exceptionally easy to apply & wipe off

#### Usage Tips:

- Apply evenly to surface by hand
- Allow sufficient time for wax to set up on mold surface (approximately 5 to 10 minutes depending on climatic conditions)
- When wiping off, first use one side of the towel to remove excess wax, then use the other side to buff remaining residue to a high gloss finish



## MEGUIAR'S MOLD RELEASE PRODUCTS

### High Temp Mold Release Wax - M8711

- Provides consistent performance when above-normal molding temperatures are used
- Unique blend of exceptionally hard waxes & thermoresins continue to provide excellent mold release capabilities when conventional mold releases fail to deliver



#### Usage Tips:

- Apply evenly to surface by hand
- Allow sufficient time for wax to set up on mold surface (approximately 5 to 10 minutes depending on climatic conditions)
- When wiping off, first use one side of the towel to remove excess wax, then use the other side to buff remaining residue to a high gloss finish

### Marine One Step Cleaner Wax - M5001 & M5016

- Use on finished product for protection during transport & storage
- Provides long-lasting protection against salt air, corrosion & the sun's ultraviolet rays
- A non-abrasive formula that cleans, polishes, & protects all fiberglass surfaces in one easy step



#### Usage Tips:

- Apply to all fiberglass surfaces by hand or *Dual Action Polisher (G220EU)*, allow to cure, & wipe away residue with a clean towel

## MEGUIAR'S MOLD RELEASE PRODUCTS

### Unigrit™ Finishing Papers

- Uniform grit particles leave a smooth, even sanding pattern that buffs out in seconds
- Eliminates the risk of deep sanding scratches that take longer to remove
- More economical to use - cuts faster, lasts longer

S1025 = 1000 grit    S1225 = 1200 grit  
S1525 = 1500 grit    S2025 = 2000 grit  
S2525 = 2500 grit



### Meguiar's Dispenser Bottle - M9912

- Convenient & quick application of product
- Perfect for MV-81, MV-82, MV-83, & MV-85



### Foam Backing Pad - E7200

- Fits perfectly with Meguiar's *Unigrit™ Finishing Papers*
- Flexible so it can also be used on curved surfaces
- Evenly distributes hand pressure across face of finishing paper
- Closed-cell construction makes it durable yet flexible
- Excellent as a squeegee to dry and inspect surface



### Pad Washer - 90-2000P

- The very best method to clean wool & foam pads
- Extremely fast & convenient
- Makes pads look like new again
- Only requires water, no solvent necessary

