

TECHNICAL BULLETIN:
PAN-L-CURE™
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Pan-L-Cure® Factory Preseasoning First-Use Instructions

Raw aluminum in contact with typical concrete “wall mix” results in a chemical reaction. That reaction will cause an unattractive concrete wall appearance. In addition a residue concrete (build-up) on the form surface can be expected. This build-up can range from moderate to severe. A procedure of cleaning and oiling is required for the first 10 – 12 pours until the forms become “oxidized” by repeated contact with the concrete. This process continues during what is called the “break-in period.” There are many variables that can affect the severity of the sticking and the number of pours required to develop a sufficient oxidization that will serve as an effective barrier. The extent of the reaction is related to the alkalinity of the concrete. Higher alkaline concrete will result in a greater degree of reaction. Western Forms Pan-L-Cure preseasoning is a chemical treatment for raw aluminum that reduces and in some cases eliminates the break-in period. The effectiveness of the preseasoning is reduced when a very high alkaline content concrete is poured on the new forms. In any case Pan-L-Cure preseasoning is superior to all other currently available preseasoning methods.

This preseasoning process is performed in the factory and is available on new equipment. Benefits of the factory pre-seasoning option include:

- Superior wall finish
 - **Reduces or substantially eliminates** typical break-in period of 10-12 pours
 - More effective than other seasoning methods
 - Eliminates health and environmental liability risks associated with other seasoning methods
 - No wasted down time and lost profit in preseasoning forms on job site (estimated 60 man hours required for 200 LF. 8'-0" tall form set form face only)
 - Factory preseasoning protects all form surfaces (front, back, sides, top, bottom)
 - Protected factory preseasoned surfaces **reduce** cleaning time and concrete sticking on all surfaces
 - **IMPORTANT NOTE:** Factory preseasoning does not eliminate the need for a good quality reactive form release agent
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Instructions for Use of Factory Preseasoned Forms

All surfaces of factory preseasoned forms from Western Forms are treated. The form "face" and siderails are factory oiled and ready to assemble. Do not apply any additional form oil, release agents or seasoning products to the 'FORM FACE" prior to the first use. This may reduce the effectiveness of the factory preseasoning and form release. For the best results, follow the instructions below for the first pour.

FIRST USE INSTRUCTIONS

STEP - 1

After the forms are erected, a Western Forms Form Release should be applied to the **backside** of the forms to prevent sticking of concrete spillage occurring during concrete placement. The form release can be applied with a 2" thick sponge, sponge mop or can be more easily applied with a pressurized sprayer. Release agent should be applied to the form backs at a coverage rate of about 2,500 square feet per gallon (1 gallon per 100 36"x96" forms). Blue Ribbon, Kleenstrip 2000, and Kleenstrip are reactive type oils that work best when applied sparingly. If oil pools on the footing or slab after being applied, you have applied too much. When Western Forms release agents are applied according to recommended coverage rates, they are lower cost per square foot than other form release products. Do not underestimate the value of this first application of form release in cleaning concrete buildup off the form backsides in subsequent uses. Take particular care to assure the form release is applied in corner areas of the forms where concrete can be more difficult to clean.

STEP - 2

Pour concrete in forms taking care to use appropriate splash boards, funnels and chutes to prevent abrasive action of flowing concrete on form face. The abrasive action of pouring concrete against the form face effectively "sandblasts" or otherwise removes the protective coating that has developed on the form. Try to direct concrete to fall without abrading the form any more than necessary.

STEP - 3

If the forms have been oiled properly on the back sides prior to the first pour, spilled concrete will be easily removed during the stripping process. Stubborn spots will normally be removed with only light tapping or scraping of form with the side of a hammer or form scraping tool. In the event that concrete is not removed easily, you will know that forms were not completely oiled and cleaning will require more effort.

STEP - 4

Immediately after the form is removed from the wall, the form face should be examined for evidence of sticking concrete. If sticking concrete is found, it should be scraped clean with an 8" flexible form scraper (common drywall taping knife) before the concrete completely hardens on the form surface. Exposing the dirty form face to the sun on a hot day, for only a few minutes, will cause the sticking concrete to harden and become more difficult to clean. Scrape to remove only the concrete. Excessive scraping can remove the forms protective coating, exposing the bare aluminum. This may defeat the effectiveness of the seasoning. Form side rails should also be cleaned at this time, prior to loading forms on a truck or into baskets.



POURS 2-6

STEP - 1

Before erecting forms for the second pour, apply a Western Forms reactive form release agent to face and side rails. Use the recommended coverage of 1,200 – 1,800 square feet per gallon (see coverage rates for the product you will be using).

STEP - 2

Release agent should be applied conservatively with a two inch thick sponge or sponge mop. NOTE: SPONGE OR MOP SHOULD BE RUNG OUT TO THE POINT THAT NO OIL IS DRIPPING. A pressure sprayer is also a very efficient method of applying form release. If using Blue Ribbon with a pressurized sprayer, the Blue Ribbon Spray Tip is recommended.

STEP - 3

Make sure the form face is completely covered with a thin film of form release agent. Do not over apply. Excessive form release agent on the surface of the form can act as a surface retarder, causing the concrete to “pull off” when the forms are stripped from the wall. WARNING: Do not attempt to apply the release agent to the form face after forms are erected as it is not possible to apply evenly and completely.

STEP - 4

After the form face and side rails have been oiled, erect the forms and oil backs of forms to prevent spilled concrete and concrete leaking through vacant tie notches from sticking to hats, corner gussets, etc. NOTE: FOR BEST RESULTS USE A PRESSURIZED SPRAYER TO APPLY FORM RELEASE ON BACKS.

STEP - 5

When stripping forms, immediately clean concrete from backs of forms and side rails by lightly scraping with a form tie, 8” flexible scraper (common dry-wall joint taping knife) or the side of a hammer. Scrape off as necessary any concrete buildup on face of forms using an 8” flexible form scraping tool. Scrape to remove only the concrete. Excessive scraping can remove the forms protective coating, exposing the bare aluminum. This may defeat the effectiveness of the seasoning.

AFTER THE FIRST 6 POURS, FOLLOW THESE INSTRUCTIONS:

STEP - 1

Before erecting forms, apply release agent to form face. Use the recommended coverage rate. Form release agent can be applied by spray method. Make sure both form face and side rails are completely covered with a thin film. NOTE: DO NOT OVER APPLY. WIPE IMMEDIATELY ANY EXCESS OIL COATING BEFORE IT DRIES, LEAVING ONLY A THIN FILM). During extreme high temperatures Western Forms release agents may dry, leaving a clear coat that continues to be an effective form release.

STEP - 2

Erect forms and oil backs of forms, especially at form joints. This will prevent concrete that leaks from unused form tie notches from sticking to back side of the form panel.

STEP - 3

Concrete is best removed from backs of form, side rails and form face immediately after forms are stripped.



RECOMMENDED PROCEDURE IN THE EVENT OF EXCESSIVE CONCRETE BUILD-UP ON ALUMINUM FORMS

Contractors differ on how much concrete build-up would be considered "excessive." The following procedure has proven very effective in reducing or eliminating concrete build-up on aluminum forms preseasoned with Pan-L-Cure.

STEP – 1

After stripping forms from wall immediately apply a medium coat of Western Forms Blue Ribbon form release agent to the face and siderails of the forms. A medium coat is full coverage of the surface up to the point where the agent begins to run, trying to avoid allowing the agent to run. Load the forms as usual and allow Blue Ribbon to penetrate as long as possible (2 - 5 days). The cleaning agent in the Blue Ribbon will penetrate the concrete and begin to break the bond between the form face and the aluminum. Blue Ribbon does not dissolve old concrete. *Ambient temperatures at the time of application will have an impact on the effectiveness of this process. The warmer the better.*

STEP – 2

Before erecting the forms for the next pour, scrape the face and siderails of the form well, avoiding excessive scraping which might expose bare aluminum. It is not advisable to try to remove 100% of the concrete in one cycle. Re-apply Blue Ribbon to the face and siderails of the forms and allow to penetrate for 24 – 48 hours.

STEP – 3

Erect forms. DO NOT REAPPLY FORM RELEASE AGENT. The form release applied in STEP – 2 will begin to break the bond between the concrete and the aluminum. The objective is for the concrete on the forms to be pulled off and stick to the wall as the forms are stripped, remaining with the concrete wall because the bond between the build-up concrete and the wall is stronger than the bond between the form and the build-up. If release agent is applied before the pour the hardened concrete on the form surface will not "pull off." Pour using pour shields to avoid pour burns.

STEP – 4

REPEAT STEPS 1 – 3 FOR 3 CYCLES OR AS NECESSARY.

WARNING: WESTERN FORMS DOES NOT RECOMMEND THE USE OF SANDBLASTERS, ACIDS, OR ABRASIVE CLEANSERS TO REMOVE CONCRETE FROM ALUMINUM FORMS.

For additional information on this topic, or other Western Forms applications, uses, or products, please contact a Western Forms Technical Service representative.

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