

# TECHNICAL DATASHEET

## Marbocote® W1141 Release Agent

### Product Description:

Marbocote® W1141 is a water based release agent for the release of natural and synthetic rubber. The application of Marbocote® W1141 is quick and easy, and produces an extremely durable film on the mould surface capable of providing many releases before reapplication is necessary. Marbocote® W1141 will not contaminate the released surface and is therefore ideal for the release of rubber to metal bonded components and 'O' rings.

### Product Benefits:

- Easy application
- Fast curing – minimum down time
- Non contaminating
- Safe water based formulation
- Low/no odour
- High gloss
- Minimal mould build-up
- Reduces need for mould cleaning
- Extremely durable; provides multiple releases per application
- Versatile; releases a wide range of rubber types and formulations

### Physical Properties:

Appearance : White liquid  
 Odour : Slight / odourless  
 Specific Gravity : 1.000 g/cc  
 Flash Point : None  
 Solvents : Water  
 pH : 5 to 7  
 Coverage : 15 - 20m<sup>2</sup> / L  
 Shelf life : 12 months  
 Storage : Store below 35°C  
 Application : Spray  
 Temperature : >60°C

Mould

**Note:** The polymeric resin used in Marbocote® W1141 reacts when heated; please store at <35°C. Marbocote® W1141 is supplied ready to use, no shaking or mixing is required. Please store in original container. Avoid prolonged contact with or storage in mild steel or aluminium equipment.

Marbocote® W1141 is not designed for the release of silicone elastomers. For this application, please use Marbocote® W313 or W2110.

### Application:

Please read safety data sheet before use.

The mould should be clean and dry before use. If necessary, clean the mould using an abrasive (for example, sand, metal or dry-ice shot-blasting). When possible, this should be followed by wiping the mould with a solvent based cleaner, such as Marbocote® Mould Cleaner. Although Marbocote® W1141 can be applied over existing semi-permanent release agents, best performance is obtained by removing all traces of prior products. Mould cleaning and release agent application should be performed in a well-ventilated area.

Marbocote® W1141 can be applied using any spray equipment capable of producing fine atomisation. Typically, a 0.5mm nozzle size is recommended but a 0.8mm may give better results when applying to moulds with deep cavities or at temperatures >170°C. Please contact Marbocote® at the telephone number overleaf for more specific equipment recommendations.

Best results will be obtained by using the following parameters:

Mould temp (deg C)	Gun Output (ml/min)	Air Pressure (bar)	Number of coats	Cure time* (min)
180	100 - 150	4-5	4	3
150	80 - 100	3-4	4	5
120	70	3	5	8
90	60	2.5	6	15
60	40	2	8	30

- Spray the product directly onto the preheated mould surface from a distance of 100 - 200mm.
- For difficult to reach areas, use a spray gun extension or lance.
- No waiting is required between coats (\* the cure time is only required after the final coat has been applied)
- Apply each coat at 90 degrees to the last.
- For new moulds, 2 additional coats are recommended.
- Do not over-apply.

**Note:** The user will determine the suitability for use of this product. The recommendations / data given above are based on information we believe to be accurate. They are intended to be used only as a guide for selection for end-use evaluation and do not constitute a product specification. Marbocote cannot assume responsibility for results obtained by use of this product as we have no control over end-use applications or handling. Marbocote therefore specifically disclaims any damage or loss of any kind in relation to the use of this product.