

# TECHNICAL DATASHEET

## Marbocote® W636 Release Agent

### Product Description:

Marbocote® W636 is a water based release agent for the release of natural and synthetic rubber. The application of Marbocote W636 is quick and easy, and produces a durable film on the mould surface capable of providing many releases before reapplication is necessary. Marbocote W636 will not contaminate the released surface.

### Product Benefits:

- Easy application
- Fast curing – minimum down time
- Non contaminating
- Safe water based formulation
- Low odour
- Minimal mould build-up
- Reduces need for mould cleaning
- Durable; provides multiple releases per application
- Versatile; releases a wide range of rubber types and formulations

### Physical Properties:

Appearance	:	White liquid
Odour	:	Slight
Specific Gravity	:	1.000 g/cc
Flash Point	:	None
Solvents	:	Water
Coverage	:	15 - 20m <sup>2</sup> / L
Shelf life	:	6 months
Storage	:	Store below 35oC
Application	:	Spray
Mould Temperature	:	>60oC

### Note:

The polymeric resin used in Marbocote W636 reacts when heated. Marbocote W636 is supplied ready to use, no shaking or mixing is required. Please store in original container.

Marbocote W636 is not designed for the release of silicone elastomers. For this application, please use Marbocote W313.

### 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 W636 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 W636 can be applied using any spray equipment capable of producing fine atomisation. Best results will be obtained by using the following parameters that are dependent on mould temperature.

Mould temp (deg C)	Gun Output (ml/min)	Air Pressure (bar)	Number of coats	Cure time* (min)
180	100	5	4	2
150	80	4	4	4
120	70	3	5	7
90	60	2.5	6	12
60	40	2	8	20

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. 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. For new moulds, 2 additional coats are recommended. Do not over-apply. Avoid running or accumulation of product, especially when applying to a mould surface preheated to <100°C.

Please contact Marbocote at the telephone number below for more specific equipment recommendations.

### Reapplication:

When release becomes hesitant, reapply one coat of Marbocote W636 in the same manner as described above.

**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.