

TECHNICAL DATASHEET

Marbocote[®] WC36 Release Agent

Product Description:

Marbocote[®] WC36 is a water based release agent concentrate for the release of natural and synthetic rubber. Marbocote WC36 can be diluted up to 5 parts water to 1 part product. The application of diluted product is quick and easy, and produces a durable film on the mould surface capable of providing many releases before reapplication is necessary.

Product Benefits:

- Dilutable concentrate (upto 5 parts water to 1 part product)
- Diluted product is stable for up to 10 days
- Fast curing – minimum down time
- Safe water based formulation
- Minimal mould build-up
- High slip
- 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 ² / L (diluted)
Shelf life	: 6 months
Storage	: Store below 35°C
Application	: Spray
Mould Temperature	: >60°C

Note:

The polymeric resin used in Marbocote WC36 reacts when heated; store in cool location. Please store in original container. Shaking is not required. Dilute Marbocote WC36 prior to use. Marbocote WC36 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.

Marbocote WC36 should be diluted before use. Soft, de-ionised or distilled water is recommended. WC36 can be diluted upto 5 parts water to 1 part product. Diluted product is stable for up to 10 days if stored at below 35C. Although Marbocote WC36 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 WC36 can be applied using any spray equipment capable of producing fine atomisation. 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	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 diluted product 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.