

# TECHNICAL DATA SHEET

## MARBOCOTE 625X

MARBOCOTE

RELEASE TECHNOLOGY

**Product Description:** Marbocote 625X is applied in a similar manner to a liquid wax combining ease of application and multiple release capability. Marbocote 625X produces an easily visible film on the mould surface that assures the user of complete, uniform coverage. The film is easy to polish, producing a high gloss durable finish capable of giving many releases before re-application is necessary. Marbocote 625X is a blend of a microcrystalline wax and a polymeric resin.

**Recommended Uses:** Marbocote 625X can be applied on all types of non porous gel coated moulds and will release gel coated glass reinforced polyester (GRP) or vinyl ester resins.

Product Benefits:
Quick and easy application
High gloss (enhanced)
Easy polish
Visible film
Low odour
Minimal mould build-up
Multiple releases per application

Product Characteristics:	
Appearance	Milky liquid
Composition	Aliphatic hydrocarbon
Flash Point	>23°C
Thermal stability of cured film	250°C
Coverage	60 - 80 m <sup>2</sup> / L per coat
Application Type	Wipe and leave
Shelf Life	12 months

**Important:** The polymeric resin used in Marbocote 625X reacts with moisture. Please ensure can is resealed after use. Shake well before and during use of product.

Please read Safety Data Sheet before use. Do not mix with other products or solvents. Application should be conducted in a well-ventilated area. Solvent resistant gloves and eye protection must be worn during this process.

For new, porous or damaged moulds, **Marbocote Mould Sealer** should be used prior to applying Marbocote 625X. See Marbocote Mould Sealer technical data sheet for application details.

### Mould Cleaning: This needs to be performed prior to product application

If a wax or silicone based release agent has been used previously, remove all traces of previous product using a solvent based cleaner such as Marbocote Mould Cleaner. Marbocote 625X can be applied over existing semi-permanent release agents without a further cleaning step. The mould must be clean and dry before use.

### Application Type: Marbocote 625X is applied by a wipe and leave technique.

The choice of cloth is important; as the Marbocote 625X resin reacts with water, the cloth must be dry. A smooth, soft cloth with a high synthetic content, such as Kimberley-Clark Wypall X60 is ideal.

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### Wipe Application Technique:

- 1) Shake can before use.
- 2) Generously apply Marbocote 625X to clean, dry cotton cloth.
- 3) Wipe over mould surface, frequently reapplying Marbocote 625X to cloth.
- 4) Allow film to haze (as with a wax)
- 5) Check film for areas that may have been missed. Reapply as necessary.
- 6) Allow 15-20 minutes (typically) for Marbocote 625X to dry.
- 7) Using a fresh cotton cloth, polish film to a high gloss. No hard rubbing is required. Frequently turn / replace cloth to provide easy removal of wax from the surface. Mechanical polishers are not recommended as they tend to produce "dry spots".
- 8) Repeat Steps 1-7 above for a further 3 coats (4 in total).
- 9) When dry, the final film needs to be cured before moulding. See table below.

Temp (°C)	Cure Time
Room temp (20°C)	20 minutes

**Note:** Use the tape-test before and after application. This will initially ensure the mould is clean and latterly, ensure correct coverage and cure times have been observed and that the coating is ready for production. If the tape release is hesitant after application, simply apply another coat in the same manner as described above.

**Reapplication:** When release becomes hesitant, reapply one coat of Marbocote 625X in the same manner as described above.

### Issue 8

**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.