

# TECHNICAL DATA SHEET

## MARBOCOTE W810AR

**MARBOCOTE**  
RELEASE TECHNOLOGY

**Product Description:** Marbocote W810AR is an environmentally safe water based semi-permanent release agent that produces a durable film capable of giving many releases before re-application is necessary and will not contaminate the released surface. W810AR has an anti-rust formulation and will inhibit rusting of moulds.

**Recommended Uses:** W810AR is specifically developed for tyre applications and will release all types of natural and synthetic rubber.

Product Benefits:
Environmentally safe – water based system
Fast curing – minimum down time
Quick and easy to apply
Minimal mould build-up
Non-contaminating
Will not rust mild steel moulds
Durable; provides multiple releases per application
Versatile; releases a wide range of rubber types

Product Characteristics:	
Appearance	White liquid
Composition	Water based formulation
Specific Gravity	1.000 g/cc
Mould Temperature	Ideal temperature >60°C
Thermal stability of cured film	>250°C
Coverage	60-80m <sup>2</sup> / L per coat
Application Type	Spray
Shelf Life	12 months

**Note:** The polymeric resin used in W810AR reacts when heated. Please store in a cool location below 35°C (i.e. not next to heated moulds). W810AR is supplied ready to use, no shaking or mixing is required. Mould cleaning and release agent application should be performed in a well-ventilated area.

Marbocote W810AR is not designed for the release of silicone elastomers. For this application, please use Marbocote W2130.

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

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.

If a semi-permanent release agent has been used on the mould then W810AR can be applied over existing semi-permanent release agent. The best performance is obtained by removing all traces of prior products.

**Application Type:** W810AR is applied by a spray technique. It can be applied using any spray equipment capable of producing fine atomisation (such as the SCHUTZE SPRITZTECHNIK® fine spray gun W3/FZ-Duo kit).

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## Spray Application Technique:

Spray Gun Parameters	
Air Cap	90°
Fluid nozzle size	0.5mm
Distance from mould	10-20cm

- 1) Test the gun settings and spray technique on the mould flange/edge to give required coverage.
- 2) Spray the product directly onto the preheated mould surface from a distance of 10–20cm. The product does not spread, angle the fluid nozzle to directly coat each and every surface.
- 3) Systematically coat the entire surface of the mould. Care must be taken to overlap sprayed areas.
- 4) Immediately after applying the first coat, apply the second at 90° to the first. No waiting is required between coats.
- 5) For difficult to reach areas, use a spray gun extension or lance.
- 6) Best results will be obtained by using the following parameters:

Mould Temp (°C)	Gun Output (ml/min)	Air Pressure (bar)	Number of coats	Cure Time* (mins)
180	200	4-5	4	1
150	160	3-4	4	2.5
120	130	3	5	5
90	100	2.5	6	10
60	80	2	8	20

\* Cure time is to be calculated after applying the last coat.

- 7) Do not over-apply, the product should not appear wet on the mould. For new moulds, 2 additional coats are recommended.
- 8) Allow product to cure for the minimum time given above.

**Reapplication:** When release becomes hesitant, reapply one coat of W810AR in the same manner as described above.

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**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.