

TECHNICAL DATA SHEET

MARBOCOTE PK4

MARBOCOTE
RELEASE TECHNOLOGY

Product Description: Marbocote PK4 is ideally suited for applications where high slip is required such as releasing abrasive, complex or deep draft components. The product is easy and quick to apply and produces a durable film capable of giving many releases before re-application is necessary and will not contaminate the released surface. Marbocote PK4 is an advanced polymeric resin in a non-chlorinated organic solvent blend.

Recommended Uses: Marbocote PK4 can be applied on all non porous mould surfaces such as GRP, epoxy or metal moulds and will release glass reinforced polyester (GRP), vinyl ester or epoxy parts.

Product Benefits:
Quick and easy application
Non-contaminating
Non-chlorinated solvents
Low odour
High slip, easy release
Minimal mould build-up
Durable, provides multiple releases per application

Product Characteristics:	
Appearance	Clear colourless liquid
Composition	Aliphatic hydrocarbon
Flash Point	<10°C
Thermal stability of cured film	250°C
Coverage	80 - 100 m ² / L per coat
Application Type	Wipe and spread
Shelf Life	12 months

Important: The polymeric resin used in Marbocote PK4 reacts with moisture. Please ensure can is resealed after use.

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 PK4. 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 PK4 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 PK4 is applied by a wipe and spread technique.

The choice of cloth is important; as the Marbocote PK4 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) Apply Marbocote PK4 to a clean, dry cotton cloth.
- 2) Gently wipe over mould surface covering an area of approximately 0.5 - 1m². Vigorous rubbing or polishing is not required.
- 3) Wait for 5-10 seconds then, with a second dry cotton cloth, gently wipe over the wet coating until the film starts to dry. Vigorous rubbing or polishing is not required.
- 4) Repeat steps 1 to 3 on the adjacent area. Ensure a good overlap with the previous area to provide complete coverage.
- 5) Repeat until mould is completely coated.
- 6) When dry, allow a further 10 minutes between coats for the film to partially cure.
- 7) Repeat Steps 1-6 above for a further 3 coats (4 in total).
- 8) When dry, the final film needs to be cured before moulding. See table below.

Temp (°C)	Cure Time
Room temp (20°C)	30 minutes
60°C*	15 minutes

Note: Use the tape-test before and after application. This will initially ensure the mould is clean and latterly, to 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 PK4 in the same manner as described above.

Issue 4

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.