



## Application Guide

# MARBALEASE® Polymer Concrete Release

MARBALEASE® Polymer Concrete Release is a fast-drying liquid mold release agent blended from a combination of microcrystalline and hydrocarbon waxes. It is especially designed as a release agent for polymer concrete applications on polyester or metal molds, including heated molds. Suited to spray or brush application without polishing to shine for non-cosmetic finishes.

MARBALEASE® Polymer Concrete Release can also be used as a general purpose release agent in applications where a smooth post-production finish is not required with thermoset resins and on forms for concrete (Portland cement or polycrrete). Can be used on most mold substrates for Glass Reinforced Concrete (GRC) and Glass Reinforced Gypsum (GRG). Also useful brushed or sprayed on gimbaled mold stands and frames and other areas to aid in removal of gel coat or matrix overspray and to lubricate and protect metal mold fittings and moving parts.

### PREPARING THE MOLD SURFACE

Molding surface must be thoroughly dry and free of other parting agents and contaminants such as silicone, dust, and compressor oil prior to application of MARBALEASE® Polymer Concrete Release. Porous molds (i.e., plaster or wood) must be sealed; composites grade sealers such as FORMULA FIVE® Mold Sealer are recommended but fairing compounds, automobile type primer-sealers, and lacquers may be sufficient. Rough wood molds or plugs used to create non-cosmetic parts may be adequately sealed with a number of coats of PARTALL® Paste #2. Best practice is to allow residual solvents to out-gas from sealers and waxes for at least one hour after application.

### DIRECTIONS FOR USE

Use in a well-ventilated area with appropriate personal protection. Mix well before use as solid components within the mixture have a natural tendency to crystallize or clump together. Use of a T-swing mixer mounted on an air drive and inserted through the container pour spout is an effective method for mixing the contents of the pail.

Fresh liquid material may be applied with a compression sprayer or disposable cup gun. Otherwise use a brush or clean dry cloth to apply MARBALEASE® Polymer Concrete Release to the surface of the mold or form. Leave wax mold release as-is or wipe away excess with a cloth, as application requires. There is no need to buff. MARBALEASE® Polymer Concrete Release will attain a hazy appearance when dry that can be seen on the mold surface.

The best procedure for separating parts from a mold depends on the size and shape of the part. In most cases a part can be lifted from the mold after loosening around the edges. On large curved parts it may be necessary to first tap over the surface with a rubber mallet. Injecting compressed air between the part and mold at the edge is sometimes useful in freeing very rigid parts that cannot be flexed.

*MARBALEASE® Polymer Concrete Release is packaged in 5 gallon (18.9 liter) pails.*