



Application Guide

MARBALEASE® Slurry Wax

MARBALEASE® Slurry Wax is a water-white semi-paste mold release agent blended from a combination of microcrystalline and hydrocarbon waxes. It is especially designed for use as a flange or edge wax on larger molds or as a hat wax when casting sanitary ware or for the undersides of cultured marble vanities. The mold surface can be prepped in advance for use the following day as MARBALEASE® Slurry Wax will remain “wet” up to twelve hours after application. Formulated for use when casting non-cosmetic composite parts using thermoset resins such as polyester and vinyl ester. Apply with a cloth or brush with no need to buff to a shine.

MARBALEASE® Slurry Wax can also be used as a general purpose release agent with thermoset resins in applications where a smooth post-production finish is not required. A clean alternative to traditional form oil when casting concrete based on Portland cement or polyester resin (polycrcrete). Can be used on most mold substrates for glass reinforced concrete (GRC) and glass reinforced gypsum (GRG). Also useful brushed on gimbaled mold stand 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. The soft yogurt like consistency of MARBALEASE® Slurry Wax makes for ease of application.

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® Slurry Wax. 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. Apply to mold surface with a brush or clean dry cloth. Leave as is or wipe away excess to create thin even layer as application requires. MARBALEASE® Slurry Wax is not designed to be buffed to a shine. Use caution not to deposit excess wax on mold flanges for cosmetic parts as heat of exothermic reaction may melt flange wax allowing it to run into cosmetic part of mold.

MARBALEASE® Slurry Wax contains nondrying oils and will remain “wet” up to twelve hours following application, allowing for advance preparation of mold surface if desired. When dry, MARBALEASE® Slurry Wax will attain a hazy appearance 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® Slurry Wax is packaged in 5 gallon (18.9 liter) pails and 1 gallon (3.79 liter) pails.