

TECHNICAL DATA SHEET

FASTCOTE RELEASE AGENT

Product Description:

As the name implies Marbocote® Fastcote makes release agent application fast and easy. Marbocote Fastcote is designed to release glass reinforced polyester (GRP), vinyl ester, phenolic or epoxy components from composite or metal moulds and is ideally suited for high gloss applications. Marbocote Fastcote is an advanced polymeric resin in a non-chlorinated organic solvent blend. Marbocote Fastcote gives an instant high gloss surface by simple wipe application; there is no need for rubbing or polishing. The Marbocote Fastcote is extremely durable and capable of giving many releases per application. It will not contaminate the released surface.

Product Benefits:

- Fast, easy wipe application
- Non contaminating
- Non-chlorinated solvents
- Low odour
- Minimal mould build-up
- Durable; provides multiple releases per application
- Flammable store (see Safety Data Sheet for further details).

Physical Properties:

Appearance	- Clear, colourless liquid
Odour	- Slight, hydrocarbon
Specific Gravity	- 0.729 g/cc
Flash Point	- <10°C
Solvents	- Aliphatic hydrocarbon
Coverage	- 100 -125m ² / L per coat
Shelf life	- One year
Storage	- Flammable store (see Safety Data Sheet for further details).

Note:

The polymeric resin used in Marbocote Fastcote reacts with moisture. Please ensure can is resealed after each and every use. Marbocote Fastcote is supplied ready to use, no shaking or mixing is required. Do not mix with other products or solvents. Store in original container in approved flammable store.

Application:

Please read Safety Data Sheet before use. If necessary, polish mould to desired level of gloss. 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 Fastcote can be applied over existing semi-permanent release agents without a further cleaning step. However, the mould should be clean and dry before use. Mould

cleaning and release agent application should always be performed in a well ventilated area.

Choice of cloth is important; as the Fastcote 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. Fold the cloth so that a smooth, flat surface is presented to the mould surface.

1. Apply Marbocote Fastcote to clean, dry cloth. Do not over-apply; the cloth must not be soaked or dripping.
2. Wipe a **thin** film of Fastcote over mould surface covering an area of approximately 1m². Vigorous rubbing or polishing is not required. The film should stay wet for up to 2 minutes (see over-leaf for further details).
3. Repeat steps 1 and 2 until the mould is completely coated. Ensure a good overlap of the coated areas to provide complete coverage.
4. When dry, allow a further 5-10 minutes between coats for the film to partially cure.
5. Repeat Steps 1-4 above for a further 2 coats (3 in total).

NOTE: for new or porous moulds, or repaired areas on old moulds, apply a further 2 coats (5 in total). A separate mould sealer is not necessary.

6. When dry, allow final film to cure for at least 15 minutes at room temperature before moulding. Allowing a longer cure or heat curing (e.g. 5 min at 60°C) will improve film durability.

Please see over for further application details.

Reapplication:

When release becomes hesitant, reapply one coat of Marbocote Fastcote in the same manner as described above. Again allow a minimum of 15 minutes before commencing production. Often, reapplication is only required in high abrasion areas such as external corners and vertical surfaces.

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

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NOTE (continued): If the film appears hazy, it is likely that too much has been applied. Do NOT polish out the haze with a dry cloth. To remove the haze, re-apply a further thin coat of Fastcote. Check product coverage and dry time. Frequently replace the cloth (this avoids product drying on the cloth after excessive use)

Please dispose of used cloths in the appropriate manner. Remember, wet cloths still contain highly flammable solvents.

Troubleshooting:

<u>Problem</u>	<u>Cause</u>	<u>Solution</u>
Streaking	Cloth has picked-up dirt from the mould – poor cleaning prior to application.	Discard old cloth and replace with new. If necessary, repeat mould cleaning process using Marbocote Mould Cleaner prior to applying Marbocote Fastcote. Pay particular attention to cleaning mould flanges (edges).
	Fastcote has dried on the cloth	Discard old cloth and replace with new. Reapply Fastcote and continue as normal.
Hazing	Over application	Squeeze out cloth prior to use (over absorbent material). If product drips from cloth then too much has been applied to cloth. Discard old cloth and replace with new. Ensure dry time is < 2 minutes
	Configuration of mould – poor air circulation in mould well prevents the quick dry of Fastcote (important to generate a high gloss finish). Solvent vapours are heavier than air and will stay in mould well or cavity until removed. This is observed by a drastic increase in dry time (e.g. >>2 minutes) which, in turn, causes hazing of the film.	Ensure good air circulation over mould. Angle the mould to allow solvent vapour to drain out of the mould well. Alternatively, use a fan to increase air flow over the mould (placed in an appropriate position to blow across the mould). When using a fan, it is important that dust is not blown onto the mould.
Poor durability (few releases per Application)	The Fastcote container has been left open for an extended period	Ensure can is resealed after each and every use. Replace with fresh product.
Poor/tight release	Highly porous moulds	Fastcote is designed to be applied to high gloss gel coated moulds. The surface porosity of these moulds will be relatively low. For matte finish or highly porous moulds, an alternative product may be more appropriate. Please consult a Marbocote Technical Representative
Mould hazes after first release manufacturer	Green mould. The mould has not been allowed to cure for the period specified by the gel coat/resin	Allow mould to cure for gel coat/resin manufacturer's recommended cure time (typically 2-3 weeks) before using. If any colour is removed during the cleaning process, i.e. discolours the cloth, this is a good indication of a soft or green mould.

GRP moulding outside the usual 15 – 35°C range.

GRP moulding outside the usual 15 – 35°C range has many other detrimental effects, not just on the release agent. For example, gel coat application below 15°C may result in permanent under cure. The further from this ideal temperature range that moulding is performed, the higher the risk of problems occurring. Please observe the recommendations of the gel coat and/or resin manufacturer(s) with respect to the use of their products at these temperatures.

Although the recommended application temperature for Fastcote is also between 15 and 35°C, the product may be used outside this range providing the following precautions are observed:

Below 15°C:

- An extra coat of Fastcote is advised, i.e. 4 coats for old moulds, 6 coats for new moulds.
- Ensure the temperature of the Fastcote is the same as that of the mould (to avoid condensation), i.e. store the can and the mould inside.
- Extra time should be allowed between coats; for example, at 10°C, allows a minimum of 30 minutes before the next coat is applied.
- Extra time should be allowed for the final cure; for example, at 10°C, allows a minimum of 60 minutes before starting production. An over-night cure is recommended.
- The slower drying time of Fastcote means that greater care is required not to over apply.

Above 35°C:

- Greater care is required to ensure the cloth does not dry-out; i.e. reapply the product frequently
- One less coat is recommended, i.e. 2 for old moulds and 4 for new moulds and repaired areas
- Ensure the use of the recommended cloths, i.e. Kimberly-Clark Wipe All X60
- Frequently replace the cloth (this avoids product drying on the cloth after excessive use)

If in any doubt, please contact a Marbocote Technician at the number below

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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.

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