

TECHNICAL DATA SHEET

220 MOULD RELEASE AGENT

Product Description:

Marbocote[®] 220 is designed to release gel coated glass reinforced polyester (GRP) or vinyl ester parts from gel coated moulds. Marbocote 220 is an advanced polymeric resin in a non-chlorinated organic solvent blend. Marbocote 220 is ideally suited for high gloss applications. The product is easy and quick to apply and produces a high gloss durable finish capable of giving many releases before re-application is necessary.

Product Benefits:

- Easy application
- Non contaminating
- Non-chlorinated solvents
- Low odour
- Minimal mould build-up
- Superior gloss retention
- Durable; provides multiple releases per application

Physical Properties:

Appearance	- Clear, colourless liquid
Odour	- Hydrocarbon
Specific Gravity	- 0.740 g/cc
Flash Point	- <20°C
Solvents	- Aliphatic hydrocarbon
Coverage	- 20 - 25m ² / L
Shelf life	- One year
Storage	- Flammable store (see Safety Data Sheet for further details).

Note:

The polymeric resin used in Marbocote 220 reacts with moisture. Please ensure can is resealed after use. Marbocote 220 is supplied ready to use, no shaking or mixing is required. Do not mix with other products or solvents.

For new, porous or damaged moulds, Marbocote Mould Sealer should be used prior to applying the Marbocote 220. See Marbocote Mould Sealer technical data sheet for application details.

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 220 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 be performed in a well-ventilated area.

1. Apply Marbocote 220 to clean, dry cotton cloth (certain synthetic cloths are also suitable; please contact Marbocote Ltd for more details).
2. Gently wipe over mould surface covering an area of approximately 1-2 m². Vigorous rubbing or polishing is not required.
3. Wait for 10-15 seconds then, with a second dry cotton cloth, gently wipe over the wet coating to leave a thin wet film. **Do not wipe 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 cure.
7. Repeat Steps 1-6 above for a further 3 coats (4 in total).
8. When dry, allow final film to cure for at least 30 minutes at room temperature before moulding. Allowing a longer cure or heat curing (e.g. 15 min at 60°C) will improve film durability.

Reapplication: When release becomes hesitant, reapply one coat of Marbocote 220 in the same manner as described above.

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