

TECHNICAL DATA SHEET

MARBOCOTE SPRAYCOTE FD



Product Description: Marbocote Spraycote FD is ideally suited for high gloss applications. The product is easy and quick to apply by spray application and produces a high gloss durable finish capable of giving many releases before re-application is necessary. It will not contaminate the released surface. Marbocote Spraycote FD is an advanced polymeric resin in a non-chlorinated organic solvent blend.

Recommended Uses: Marbocote Spraycote FD can be applied on all types of gel coated/non porous moulds and will release glass reinforced polyester (GRP) or vinyl ester parts.

Product Benefits:
Quick and easy spray application
Reproduces finish on mould, i.e. high gloss on high gloss moulds, matte finish on matte moulds
Ideal for large, non-skid or textured moulds
Fast Dry; no waiting between coats
Minimal mould build-up
Versatile, can be used on all mould surfaces
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	75 - 100 m ² / L per coat
Application Type	Spray
Shelf Life	12 months

Important: The polymeric resin used in Marbocote Spraycote FD 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.

Ensure supplied air is dry and free of oil lubrication. If possible, use a desiccator dryer. If airline is not dry (i.e. there is water in the airline) this can cause pre-release, hazy and fish eyes.

For new, porous or damaged moulds, **Marbocote Mould Sealer** should be used prior to applying Marbocote Spraycote FD. 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 or if there is dirt or dust on the mould, thoroughly clean the mould using a solvent based cleaner such as Marbocote Mould Cleaner. Marbocote Spraycote FD 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 Spraycote FD is applied by spray technique.

When spraying, the use of a High Volume Low Pressure (HVLP) spray gun is strongly recommended. This type of spray gun will give the best drying pattern and highest gloss finish while providing optimum transfer efficiency.

Spray Gun Parameters	
Air pressure	2-2.5 bar (30-35 psi)
Fluid needle size	<1.4mm

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Distance from mould	Approx. 20cm
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- 1) Holding the nozzle of the gun approximately 20-30cm from the mould surface, adjust the output so that the film dries in approximately 2-3 seconds when using a normal spray technique. If the film stays wet for >5 seconds, too much product is being applied.
- 2) Systematically coat the entire surface of the mould. As the film dries clear, care must be taken to over-lap sprayed areas.
- 3) Immediately after applying the first coat, apply the second at 90° to the first. No waiting is required between coats.
- 4) For old moulds (moulds having been previously coated with release agent), clean the mould as described above and apply 3 coats.
- 5) Allow a minimum of 30 minutes after the final coat for the film to cure before moulding.

Tips:

As this is a moisture sensitive product, please re-seal can after each and every use.

DO NOT:

- leave product in the spray pot when not in use.
- return unused product back into the can. Only dispense enough for immediate use.
- dispense from a pressure pot using compressed air.

DO:

- Test the gun settings and spray technique on the mould flange/edge to give ideal coverage.
- Correct application of the product produces a light mist on the surface of the mould that dries in a few seconds.
- If any product drips from the spray gun, wipe dry immediately and continue spraying.
- Clean spray nozzle after each use to ensure product does not dry and cure at nozzle tip.
- If the product is over applied (i.e. hazes), rub the area with a clean dry cloth and reapply as described above.
- If any product drips from the spray gun, wipe dry immediately and continue spraying.

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

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 highly the risk of problems occurring. Please observe the recommendations of the gel coat and/or resin manufacture(s) with respect to the use of their products at these temperatures.

Although the recommended application temperature for Marbocote Spraycote FD 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 Marbocote Spraycote FD is advised, i.e. 4 coats for old moulds, 6 coats for new moulds.
- The spray gun should be adjusted to allow for the slower drying time of Spraycote. For example, at 10°C, instead of the usual ideal 2-3 second dry time, the product should dry in an ideal 4-6 seconds.
- Greater care is required not to over apply, i.e. the dry time should be on longer than 10 seconds.
- Ensure the temperature of the Marbocote Spraycote FD 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 for the final cure; for examples, at 10°C, allow a minimum of 60 minutes before starting production. An over-night coat is recommended.

Above 35°C:

- Above 35°C, as the product will dry very quickly, there is a greater tendency to over apply. Ensure that a wet film is visible for ideally 1-2 seconds. A longer dry time may result in a hazy (white) film. If this occurs, clean mould with Marbocote Cleaner (see Cleaner Tech Data sheet for details) and re-apply 1 coat of Spraycote.
- Apply one less coat than standard application, i.e. a total of 2 coats for old moulds and 4 for new moulds and repaired areas.

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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.

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