

## Technical data sheet

# Marbocote® 220

## Semi-permanent mould separating agent

### Product description

**Marbocote® 220** is determined for release of gel coated FRP or vinylester parts. **Marbocote® 220** is ideal for high glossy surfaces of the moulded blank. It is a polymer resin in a mixture with not chlorinated solvents. It is applied by simple wiping with a fabric. Rubbing or polishing is not necessary. **Marbocote® 220** is steady and suitable allow many mould releases per application. It will not be transferred to the released surface.

### Product advantages:

- ▶ easy application
- ▶ not transferential / polluting
- ▶ not chlorinated, only environment friendly solvents
- ▶ low smell
- ▶ minimum mould set up
- ▶ high gloss of the moulded part
- ▶ steady, allows many mould releases per application

### Physical characteristics:

<b>Appearance</b>	- clear liquid
<b>Smell</b>	- weak
<b>Density</b>	- 0.740 g/cc
<b>Separating agent</b>	- aliphatical carbon hydride
<b>Burning point</b>	- < 20 °C
<b>Shelf life</b>	- 12 months
<b>Storage</b>	- flameproof warehouse

### Note:

The polymer resin in **Marbocote® 220** reacts with air moisture. Please close the container after use. **Marbocote® 220** is delivered ready for use, no shaking or mixing necessary. For new or damaged moulds use before **Marbocote® 220** our mould sealer RS 415 (for aluminum) or GRP sealer (for plastic moulds) – see the referring data sheets.

## Use instructions :

Please read the safety data sheet before use. If necessary polish the mould till the requested gloss grade. If one used before a waxy or silicone containing separating agent, please remove the traces of this separating agent with the help of a solvent based cleaner.

**Marbocote® 220** can be applied over other semi-permanent separating agents without removing them before. In spite of this the mould should be clean and dry before application.

### Working steps:

1. Apply **Marbocote® 220** with a clean, dry cotton fabric.
2. Wipe the wet fabric over the mould surface, about a space of 1 - 2 m<sup>2</sup>. Intensive rubbing or polishing is not necessary.
3. Wait 10 – 15 seconds, then wipe with a second dry fabric **softly** over the moist surface to leave a thin moist film. Don't dry completely. Intensive rubbing or polishing is not necessary.
4. Repeat the steps 1 to 3 at bordering spaces whilst wetting the fabric very often with separating agent. Please take care that the worked spaces overlap very well to exclude defects.
5. Repeat these steps till the complete mould is coated entirely.
6. After drying wait further 10 minutes so that the film can harden (by air moisture)
7. Repeat these steps (1 - 6) for further 3 coatings (totally 4).
8. After drying wait at least 30 minutes at room temperature before moulding. Warming (e.g. to 60 °C) would improve the film hardness.

## Finishing coating:

If mould release becomes heavier, apply a layer **Marbocote® 220** as described above.

## Packaging:

5 and 25 Liter cans

All information contained in this data sheet are based on our technical and scientific knowledge, but buyer and user should make their, own trials with our products under their own use conditions.

## Technical data sheet

# Marbocote® 227 CEE Semi-permanent separating agent

## Product description:

**Marbocote® 227 CEE** is determined for release of gel coated FRP or vinylester parts. **Marbocote® 227 CEE** is a polymer resin in a mixture with not chlorinated solvents. It is applied by simple wiping with a fabric. Rubbing or polishing is not necessary. **Marbocote® 227 CEE** is steady and suitable allow many mould releases per application. It will not be transferred to the released surface.

## Product advantages:

- ▶ easy application
- ▶ not transferential / polluting
- ▶ not chlorinated, only environment friendly solvents
- ▶ low smell
- ▶ minimum mould set up
- ▶ high gloss of the moulded part
- ▶ steady, allows many mould releases per application

## Physical characteristics:

Appearance	- clear liquid
Smell	- weak
Density	- 0.735 g/cc
Separating agent	- aliphatical carbon hydride
Covering	- 20 – 25 m <sup>2</sup> /L
Burning point	- < 21 °C
Shelf life	- 12 months
Storage	- flameproof warehouse

## Note:

The polymer resin in **Marbocote® 227 CEE** reacts with air moisture. Please close the container after use. **Marbocote® 227 CEE** is delivered ready for use, no shaking or mixing necessary.

## Use instructions :

Please read the safety data sheet before use. If necessary polish the mould till the requested gloss grade. If one used before a waxy or silicone containing separating agent, please remove the traces of this separating agent with the help of a solvent based cleaner.

**Marbocote® 227 CEE** can be applied over other semi-permanent separating agents without removing them before. In spite of this the mould should be clean and dry before application to achieve the very best results.

### Working steps:

1. Apply **Marbocote® 227 CEE** with a clean, dry cotton fabric.
2. Wipe the wet fabric over the mould surface, about a space of 1 - 2 m<sup>2</sup>. Intensive rubbing or polishing is not necessary.
3. Repeat the steps 1 and 2 at bordering spaces whilst wetting the fabric very often with separating agent. Please take care that the worked spaces overlap very well to exclude defects.
4. Repeat these steps till the complete mould is coated entirely.
5. Wait till the solvent is evaporated completely und so the surface is dry. After that wait further 15 minutes till the surface hardened completely under the influence of air moisture.
6. Repeat these steps (1-5) for further 2 coatings (totally 3)
7. At new moulds or damaged places please apply 1 to 2 additional layers as described.
8. After drying wait at least 30 minutes at room temperature before moulding. Warming (e.g.to 60°C) would improve the film hardness.
9. Check the reliable coating with **Marbocote® 227 CEE** with the help of a glue foil, which can be removed very easily from a coated surface.

## Finishing coating:

If mould release becomes heavier, apply a layer **Marbocote® 227 CEE** as described above.

## Packaging:

5 and 25 Liter cans

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## Technical data sheet

# Marbocote® Fastcote LP

## Semi-permanent mould separating agent

### Product description:

**Marbocote® Fastcote LP** is determined for release of gel coated FRP or vinylester parts.

**Marbocote® Fastcote LP** a polymer resin in a mixture with not chlorinated solvents. It is most suitable for the production of high gloss surfaces only by simple wiping with a fabric. Rubbing or polishing is not necessary. The application is simple and fast und creates a steady high gloss surface, which allows many mould releases before a new application becomes necessary.

### Product advantages:

- ▶ easy application
- ▶ not transferential / polluting
- ▶ not chlorinated, only environment friendly solvents
- ▶ low smell
- ▶ minimum mould set up
- ▶ high gloss of the moulded part
- ▶ steady, allows many mould releases per application

### Physical characteristics:

Appearance	- clear liquid
Smell	- weak
Density	- 0.76 g/cc
Separating agent	- aliphatical carbon hydride
Covering	- 20 – 25 m2/L
Burning point	- > 24 °C
Shelf life	- 12 months
Storage	- flameproof warehouse

### Note:

The polymer resin in **Marbocote® Fastcote LP** reacts with air moisture. Please close the container after use. **Marbocote® Fastcote LP** is delivered ready for use, no shaking or mixing necessary. Don't mix it with other products or solvents. The use of a sealer before the application of **Marbocote® Fastcote LP** isn't absolutely necessary.

## Use instructions:

Please read the safety data sheet before use. If necessary polish the mould till the requested gloss grade. If one used before a waxy or silicone containing separating agent, please remove the traces of this separating agent with the help of a solvent based cleaner like e.g. Marbocote®.mould cleaner.

**Marbocote® Fastcote LP** can be applied over other semi-permanent separating agents without removing them before. In spite of this the mould should be clean and dry before application.

## Working steps:

1. Saturate **Marbocote® Fastcote LP** with a clean, cry cotton fabric.
2. Wipe the wet fabric over the mould surface, about a space of 0,5 m<sup>2</sup>. Intensive rubbing or polishing is not necessary.
3. Repeat the steps 1 and 2 at bordering spaces whilst wetting the fabric very often with separating agent. Please take care that the worked spaces overlap very well to exclude defects.
4. Repeat these steps till the complete mould is coated entirely
5. After drying wait further 15 minutes so that the film can harden (by air moisture)
6. Repeat the steps (1-5) for further 3 coatings (totally 4 layers)
7. After drying wait at least 30 minutes are room temperature before moulding. Warming (e.g. 15 minutes up to 60°C) would improve the film hardness.

## Finishing coating:

If mould release becomes heavier, apply a layer **Marbocote® Fastcote LP** described above.

## Packaging:

- 5 liter cans
- 25 liter cans

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## Technical data sheet

# Marbocote® 625 X ECO

## Semi-permanent, waxen mould separating agent

### Product description:

**Marbocote® 625 X ECO** is determined for release of gel coated FRP or vinylester parts. **Marbocote® 625 X ECO** is ideal for production of high gloss surfaces. **Marbocote® 625 X ECO** is a mixture of micro crystalline wax and a polymer resin. It is easy to apply and moreover it allows multiple releases. **Marbocote® 625 X ECO** is applied similar as liquid wax. **Marbocote® 625 X ECO** creates a good visible layer on the mould surface, which makes it sure for the user that he hasn't overseen any spaces of the mould surface. The visible wax layer can be polished easily and creates a high glossy surface, which allows many mould releases, before a new application becomes necessary.

### Product advantages:

- ▶ easy application
- ▶ visible layer
- ▶ easy polishing
- ▶ high glossy
- ▶ not chlorinated, only environment friendly solvents
- ▶ low smell
- ▶ minimum mould set up steady, allows many mould releases per application
- ▶ up steady, allows many mould releases per application

### Physical characteristics:

<b>Appearance</b>	- milky liquid
<b>Smell</b>	- weak
<b>Density</b>	- 0.76e g/cc
<b>Separating agent</b>	- aliphatical carbon hydrides
<b>Burning point</b>	- 28 °C
<b>Shelf life</b>	- 12 months
<b>Covering</b>	- 15 to 20 m <sup>2</sup> / liter
<b>Storage</b>	- flameproof warehouse

### Note:

The polymer resin in **Marbocote® 625 X ECO** reacts with air moisture. Please close the container after use. Please shake very well before and whilst use. At new, porous and damaged moulds use our "GRP mould sealer" before **Marbocote® 625 X ECO** – see the referring data sheet.

## Use instructions:

Please read the safety data sheet before use. If necessary, polish the mould till the requested gloss grade. If one used before a waxy or silicone containing separating agent, please remove the traces of this separating agent with the help of a solvent based cleaner like e.g. Marbocote®.mould cleaner.

**Marbocote® 625 X ECO** can be applied over other semi-permanent separating agents without removing them before. In spite of this the mould should be clean and dry before application.

## Working steps:

1. Shake the container very well before use.
2. Apply **Marbocote® 625 X ECO** rich with a clean, dry cotton fabric.
3. Wipe the wet fabric over the mould surface and thereby saturate the fabric again and again with **Marbocote® 625 X ECO**.
4. Wait till the surface becomes cloudy – like wax
5. Check the surface for not covered spaces, if these should become visible, repair as described under 2-4.
6. Wait about 15 – 20 minutes till **Marbocote® 625 X ECO** becomes dry on the surface.
7. With a new, clean cotton fabric now the surface is polished glossy. This happens without any effort, very soft. Please turn the fabric several times and replace it often by a fresh, unused fabric to guarantee a good surface. Mechanical polishing tools are harmful since these can create „dry spaces“.
8. Repeat these steps (1- 6) for further 3 coatings (totally 4).
9. After drying wait at least 20 minutes at room temperature before moulding.
10. Start with production

## Finishing coating:

If mould release becomes heavier, apply a layer **Marbocote® 625 X ECO** described above.

## Packaging:

- 5 liter can
- 25 liter can

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## Technical data sheet

# Marbocote® Spraycote

## Semi-permanent mould separating agent

### Product description:

**Marbocote® Spraycote** is determined for the mould release of FRP (epoxy-, polyester-, vinylester-, phenol- or other duroplast resins) of non-porous or gel coated moulds. **Marbocote® Spraycote** is ideal for high gloss surfaces of the moulded blank and creates a high glossy surface only by spray application. No rubbing or polishing is necessary. The separating layer is steady and allows several mould releases per application. The separating agent will not be transferred to the moulded blank.

### Product advantages:

- ▶ easy spray application
- ▶ no holding time between the layers
- ▶ not chlorinated, only environment friendly solvents
- ▶ low smell
- ▶ minimum mould set up
- ▶ steady, allows many mould releases per application
- ▶ high gloss of the moulded part

### Physical characteristics:

Appearance	- clear liquid
Smell	- weak
Density	- 0.74 g/cc
Separating agent	- aliphatical carbon hydrides
Burning point	- 10°C
Shelf life	- 6 months
Covering	- 15 to 20 m <sup>2</sup>
Storage	- flameproof warehouse

### Note:

The polymer resin in **Marbocote® Spraycote** reacts with air moisture. Please close the container after use. **Marbocote® Spraycote ECO**, no shaking and mixing necessary. Don't mix it with other separating agents.

## Use instructions :

Please read the safety data sheet before use. If necessary, polish the mould till the requested gloss grade. If one used before a waxy or silicone containing separating agent, please remove the traces of this separating agent with the help of a solvent based cleaner like e.g. Marbocote mould cleaner. Marbocote Spraycote can be applied over other semi-permanent separating agents, without removing them before. In spite of this the mould should be clean and dry before application. Care for good ventilation and aeration whilst spraying process. Most suitable for spray application is a HVLP (low pressure, high volume) spraying equipment.

## Working steps:

1. The spraying equipment should be adjusted to 2 till 2,5 bar and should have a nozzle smaller than 1,4 mm.
2. Hold the nozzle in about 20 cm distance from the mould surface, and regulate the spray volume, so that the spray film on the surface becomes dry after 2-3 seconds. If the drying last longer than 5 seconds the application is too much.
3. Coat the complete mould surface systematically as described und 1 and 2. Since the separating layer appears transparent whilst drying and is hardly visible, one has to take care that all spaces of the mould are coated very well.
4. At once after application of the first layer please apply the next one in an angle of 90° to the first one. No holding time between the layers necessary.
5. For new or repaired moulds 5 layers are needed. For already before coated moulds 3 layers are enough.
6. After drying of the last layer wait at least 30 minutes at room temperature for hardening of the layer before moulding process.

## Tipps:

- Before spraying check the adjustment of the spraying equipment on the mould edges.
- At correct adjustment of the spraying equipment one creates a little moisture on the mould surface that dries after a few seconds.
- If the product is applied too much (and after drying, a light cloud becomes visible), rub the place with a clean dry fabric and apply again as recommended.
- If some product drops from the spraying equipment, dry it at once and repeat the spraying process.
- Fill only so much liquid, as used at once. Spare quantities may not be filled back again in the original package.

## Finishing coating:

If mould release becomes heavier, apply a layer **Marbocote® Spraycote** described above.

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