

TECHNICAL DATASHEET

Marbocote[®] 220 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[®] GRP Sealer or Marbocote[®] RS415 ECO should be used prior to applying the Marbocote[®] 220. See Marbocote[®] GRP Sealer or Marbocote[®] RS415 ECO technical data sheet for application details.

Please read safety data sheet before use.

Application:

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 an 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.

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.