

TECHNICAL DATASHEET

Marbocote® 227 Release Agent

Product Description:

Marbocote® 227 is designed to release all types of epoxy, phenolic, polyester (GRP) or vinyl ester resins from steel, aluminium or composite moulds. Marbocote® 227 is an advanced polymeric resin in a non-chlorinated organic solvent blend. Marbocote® 227 is applied by a simple wipe-on technique; there is no need for rubbing or polishing. The Marbocote® 227 is durable and capable of giving many releases per application. It will not contaminate the released surface.

Product Benefits:

- Easy, fast application
- Non contaminating
- Non-chlorinated solvents
- Low odour
- High slip, easy release
- Minimal mould build-up
- Versatile, can be used on all mould surfaces
- Durable; provides multiple releases per application

Physical Properties:

Appearance	: Clear, colourless liquid
Odour	: Hydrocarbon
Specific Gravity	: 0.730 g/cc
Flash Point	: <21°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® 227 reacts with moisture. Please ensure can is resealed after use. Marbocote® 227 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® RS415 ECO should be used prior to applying the

Marbocote® 227. See Marbocote® RS415 ECO 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® 227 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® 227 to clean, dry cotton cloth.
2. Wipe wet cloth over mould surface covering an area of approximately 0.5m². Vigorous rubbing or polishing is not required.
3. Repeat steps 1 and 2 on the adjacent area, frequently reapplying the product to the cloth. Ensure a good overlap with the previous area to provide complete coverage.
4. Repeat until mould is completely coated.
5. When dry, allow a further 15 minutes between coats for the film to cure.
6. Repeat Steps 1-5 above for a further 3 coats (4 in total).
7. 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® 227 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.