

TECHNICAL DATASHEET

Marbocote® CMR Release Agent

Product Description:

Marbocote® CMR (Closed Mould Release) is designed to release gel coated glass reinforced polyester (GRP), vinyl ester, DCPD or epoxy parts from gel coated /non porous moulds. Marbocote® CMR is an advanced polymeric resin in a non-chlorinated organic solvent blend, specially designed to reduce mould build up. Marbocote® CMR is ideally suited for high gloss applications and provides good gloss retention. 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
- Reduces mould build-up
- Superior gloss retention
- Durable; provides multiple releases per application

Physical Properties:

Appearance	: Clear, colourless liquid
Odour	: Hydrocarbon
Specific Gravity	: 0.75 g/cc
Flash Point	: 10°C
Solvents	: Aliphatic/aromatic 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® CMR reacts with moisture. Please ensure can is resealed after use. Marbocote® CMR 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® CMR. 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® CMR 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® CMR to clean, dry cotton cloth.
2. Wipe over mould surface covering an area of approximately 0.5m².
3. With a second dry cotton cloth, gently wipe over the wet coating to leave a thin wet film. Do not wipe until 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. Do not allow wet cloth to dry or to become contaminated with dirt etc. If necessary, replace with clean cloth and repeat above.
6. Repeat until mould is completely coated.
7. When dry, allow a further 10 minutes between coats for the film to cure.
8. Repeat Steps 1-6 above for a further 3 coats (4 in total).
9. When dry, allow final film to cure for at least 15 minutes at room temperature before moulding. Allowing a longer cure or heat curing (e.g. 5 min at 60°C) will improve film durability.

Reapplication:

When release becomes hesitant, reapply one coat of Marbocote® CMR 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.