

TECHNICAL DATA SHEET

MARBOCOTE 101 MOULD RELEASE AGENT

Product Description:

Marbocote[®] 101 is designed to release glass reinforced polyester (GRP), vinyl ester or epoxy parts from GRP, epoxy or metal moulds. Marbocote 101 is ideally suited for applications where high slip is required such as when releasing abrasive, complex or deep draft components. Marbocote 101 is an advanced polymeric resin in a non-chlorinated organic solvent blend. The product is easy and quick to apply and produces a medium to high gloss durable finish capable of giving many releases before re-application is necessary.

Product Benefits:

- High slip
- 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	- 0.754 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 101 reacts with moisture. Please ensure can is resealed after use. Marbocote 101 is supplied ready to use, no shaking or mixing is required. Do not mix with other products or solvents.

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 101 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 101 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 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 2 coats (3 in total).
8. For new, porous or damaged moulds, 2 additional coats are recommended (5 in total). A separate mould sealer is not required.
9. When the final coat has dried, allow a further 30 minutes (minimum) 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 101 in the same manner as described above.

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