

TECHNICAL DATA SHEET

227 HT MOULD RELEASE AGENT

Product Description:

Marbocote[®] 227 HT is designed to release all types of epoxy, phenolic, polyester (GRP) or vinyl ester resins from steel, aluminium or composite moulds. Marbocote 227 HT is an advanced polymeric resin in a non-chlorinated organic solvent blend. Marbocote 227 HT can be applied by wipe or spray techniques; there is no need for rubbing or polishing. The Marbocote 227 HT 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	-	23°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 HT reacts with moisture. Please ensure can is resealed after use. Marbocote 227 HT 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 Mould Sealer should be used prior to applying the Marbocote 227 HT. See Marbocote Mould Sealer 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 HT 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.

Wipe Application:

1. Using a lint free cloth, apply a thin wet film of Marbocote 227 HT to the mould surface. If a higher gloss finish is required, the wet film can be further spread by gently wiping with a second dry cloth. Vigorous rubbing or polishing is not required.
2. Repeat above on the adjacent area, frequently reapplying the product to the cloth. Ensure a good overlap with the previous area to provide complete coverage. Repeat until mould is completely coated.
3. When dry, allow a further 15 minutes between coats for the film to cure.
4. Repeat Steps 1-3 above for a further 3 coats (4 in total).
5. 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

Issue 3
23.12.08

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Spray Application:

Marbocote 227 HT can be applied using any spray gun capable of fine atomisation. However, the use of a High Volume Low Pressure spray gun is strongly recommended. This type of spray gun will give the best drying pattern and highest gloss finish while providing optimum transfer efficiency.

1. The spray gun should be set at 2 – 2.5 bar pressure (30-35 psi) and ideally fitted with a fluid needle of less than 1.2mm diameter.
2. Holding the nozzle of the gun approximately 20-30cm from the mould surface, adjust the output so that the film dries in approximately 4-5 seconds when using a normal spray technique. If the film stays wet for >10 seconds, too much product is being applied.
3. Systematically coat the entire surface of the mould. As the film dries clear, care must be taken to over-lap sprayed areas.
4. Immediately after applying the first coat, apply the second at 90° to the first. No waiting is required between coats.
5. For new moulds or repaired areas on old moulds, a total of 5 coats are required. For old moulds (moulds having been previously coated with release agent), clean the mould as described above and apply 3 coats.
6. Allow a minimum of 30 minutes after the final coat for the film to cure before moulding.

Tips:

- Test the gun settings and spray technique on the mould flange/edge to give ideal coverage.
- Correct application of the product produces a light mist on the surface of the mould that dries in a few seconds.
- Depending on quantity applied, the final film may be hazy; this is normal. For a high gloss finish, Marbocote Spraycote is recommended.
- If any product drips from the spray gun, wipe dry immediately and continue spraying.
- Only dispense sufficient product for immediate use. Do not pour material back into the can.

Reapplication:

When release becomes hesitant, reapply one coat of Marbocote 227 HT in the same manner as described above.

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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.

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