

# TECHNICAL DATA SHEET

## PRODUCT SUMMARY SHEET - COMPOSITE

**Marbocote Mould Cleaner:** A clean mould is essential to enable a semi-permanent mould release agent to give maximum performance. Marbocote Mould Cleaner is a blend of organic solvents designed to make mould cleaning as easy and effective as possible. For its all-round cleaning ability, Marbocote Mould Cleaner has been described as the best on the market.

**Marbocote HP Series Mould & Tool Sealers:** Marbocote HP Sealers are high solids products designed to seal all types of highly porous substrates including epoxy and polyurethane tooling board, MDF, gelcoated and non-gelcoated polyester and epoxy composite moulds. The HP sealers are single component moisture cure systems that can be applied to the mould or tool by wipe or spray. The HP Series products are capable of generating a high gloss finish without the need of additional polishing. These fast cure systems produce a tough, durable film that is chemically inert to all solvents and resins, and provide an ideal base-coat for the Marbocote release agents. See specific data sheets for further details.

**Marbocote Mould Sealer:** The Mould Sealer is recommended to seal micro-porosity in polyester or vinyl ester GRP moulds. After cleaning the mould, apply 2 coats of Sealer to prime and seal the mould surface. Following a short cure, the mould is ready for application of the release agent.

**Marbocote 227CEE:** The Marbocote 227CEE is a general purpose semi-permanent mould release agent. Marbocote 227CEE is designed to release most thermosetting polymers (except isocyanate based polymers and silicones). The 227CEE is typically used to release composite materials. Using a blend of organic solvents enables the product to achieve a quick dry and cure at room temperature. As with all products in the Marbocote range, once cured, the 227CEE gives many releases before re-application is required.

**Marbocote HP7:** Marbocote HP7 is specifically designed for use in conjunction with the Marbocote HP Sealers. Marbocote HP7 releases all types of resins and can be used on all mould types; it is an easy, quick application and is a fast cure system. Marbocote HP7 is applied by a simple wipe-on technique and will maintain the high gloss surface of the HP Sealer. Marbocote HP7 is an ideal product for processes where the moulded part requires bonding or painting.

**Marbocote Fastcote LP:** Marbocote Fastcote LP is specifically formulated to release open moulded glass reinforced polyesters and vinyl esters. The additional advantage is that Fastcote produces an instant gloss finish with no need for polishing.

**Marbocote Spraycote:** An easy to use spray applied semi-permanent capable of generating an instant gloss and multiple releases per application. Marbocote Spraycote is ideally suited for application to large open moulds (most GRP moulds) in the minimum time. The ability to spray apply makes the release agent application up to 20 x faster than traditional paste waxes – **and** the product is durable, meaning that many releases can be achieved before reapplication is necessary. Several versions of Spraycote are available; tailored to meet your specific needs. Contact Marbocote Ltd on the number below for further details.

**Marbocote 220:** Marbocote 220 is specifically formulated for Glass Reinforced Polymers such as open moulded glass reinforced polyesters and vinyl esters. Marbocote 220 enables a high gloss finish to be obtained easily and with minimal effort. Marbocote 220 also offers excellent durability/multiple release performance.

**Marbocote TRE 45 ECO:** Marbocote TRE45 ECO is an **Aerospace Specified** product designed to release epoxy, polyester, vinyl ester, phenolic, BMI and other thermosetting resins. The Marbocote TRE45 ECO will not contaminate the released surface, essential when post moulding adhesion processes are involved.

**Marbocote 625X:** is a combination of semi-permanent resin and microcrystalline wax. The product is applied in a similar manner to a liquid wax, giving the advantages of film visibility, high slip and enhanced gloss finish. As the product also contains a curing polymer, multiple releases per application are also obtained. The product is ideal for applications that prefer the cost benefits of a semi-permanent but also want the ease of use of a wax.

**Marbocote W2494:** Marbocote W2494 is a water based semi permanent release agent designed for the release of reinforced composites based on epoxy, polyester and phenolic resins. Marbocote W2494 can be applied at mould temperatures from 20°C to 200°C and gives high slip, minimal mould build up and provides multiple releases per application and is stable at temperatures greater than 250°C

**Marbocote products are supplied in:**

- 250ml/500ml (HP Sealers)
- 1 Litre (selected products)
- 5 Litre
- 25 Litre
- 200 Litre



## COMPOSITE SELECTOR CHART

PROCESS		HP SERIES	220	FASTCOTE	SPRAYCOTE	TRE45ECO	227	625X	W2494
<b>HAND LAYUP</b>	Gel coat - gloss		★	★	★			★	★
	Gel coat - matte					★			
	Non-gel coat						★		★
<b>RTM/ INFUSION</b>	Standard		★	★	★	★			
	Low shrink		★			★	★	★	
<b>CAST</b>	Gel coat		★	★	★			★	
	Non- gel coat						★		
<b>VACUUM BAGGING</b>	Aerospace Approved					★	★		
<b>TOOLING BOARD</b>	PU or EPOXY	★					★		
<b>MOULD RENOVATION</b>	E.g. Carbon Fibre	★					★		

For further information on these products or other products in the Marbocote range, or to request a demonstration, please contact us at:

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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.