

TECHNICAL DATA SHEET

290 MOULD RELEASE AGENT

Product Description:

Marbocote[®] 290 is designed to release all types of epoxy, phenolic, polyester (GRP) or vinyl ester resins from steel, aluminium or composite moulds. Marbocote 290 is a blend of an advanced polymeric resin and functional silicones in a non-chlorinated organic solvent. Marbocote 290 is applied by a simple wipe-on technique; there is no need for rubbing or polishing. The Marbocote 290 is durable and capable of giving many releases per application.

Product Benefits:

- Easy, fast application
- Non-chlorinated solvents
- Fast dry
- Low odour
- 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	-	0.733 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 290 reacts with moisture. Please ensure can is resealed after use. Marbocote 290 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 290. 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 290 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 290 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 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 290 in the same manner as described above.

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