

TECHNICAL DATA SHEET

227CEE MOULD RELEASE AGENT

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Product Description:

Marbocote[®] 227CEE is designed to release all types of epoxy, phenolic, polyester (GRP) or vinyl ester resins from steel, aluminium or composite moulds. Marbocote 227CEE is an advanced polymeric resin in a non-chlorinated organic solvent blend. Marbocote 227CEE is applied by a simple wipe-on technique; there is no need for rubbing or polishing. The Marbocote 227CEE 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	-	<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 227CEE reacts with moisture. Please ensure can is resealed after use. Marbocote 227CEE 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 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 227CEE 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 227CEE 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 2 coats (3 in total).
7. For new, porous or damaged moulds, apply an extra 1-2 coats of 227 in the manner described above.
8. 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.
9. Confirm 227 film coverage using adhesive tape (e.g. masking tape should release easily from the coated mould).

Reapplication:

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

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