

# TECHNICAL DATA SHEET

## HP7 RELEASE SYSTEM

### Product Description:

Marbocote HP7 is specifically designed to be used as a top-coat for the HP Mould and Tool Sealers and is especially suited to epoxy moulding. Marbocote® HP7 can also release all types of composite moulding resins, such as phenolic, polyester (GRP) or vinyl ester, from steel, aluminium or composite moulds. Marbocote HP7 is formulated from an advanced polymeric resin diluted in a non-chlorinated organic solvent blend. Marbocote HP7 is applied by a simple wipe-on technique; there is no need for rubbing or polishing. The Marbocote HP7 is durable and capable of giving many releases per application. It will not contaminate the released surface.

### Product Benefits:

- Easy, fast application
- High gloss
- Non contaminating
- Non-chlorinated solvents
- 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	-	0.724 g/cc
Flash Point	-	<21°C
Solvents	-	Aliphatic hydrocarbon
Coverage	-	20 - 25m <sup>2</sup> / L / coat
Shelf life	-	One year
Storage	-	Flammable store (see Safety Data Sheet for further details).

### Note:

The polymeric resin used in Marbocote HP7 reacts with moisture. Please ensure can is resealed after use. Marbocote HP7 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 Cleaner.

Marbocote HP7 can only be applied to non-porous surfaces. If necessary, seal the mould or tool with HP Sealers prior to using HP7 top-coat. If desired, polish mould to desired level of gloss. Marbocote HP7 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.

Choice of cloth is important; as the HP7 resin reacts with water, the cloth must be dry. A smooth, soft cloth with a high synthetic content, such as Kimberley-Clark® Wypall® X60, is ideal. Fold the cloth so that a smooth, flat surface is presented to the mould surface.

1. Apply Marbocote HP7 to a clean, dry cloth. Do not over-apply; the cloth must not be dripping.
2. Wipe wet cloth over mould surface covering an area of approximately 0.5 - 1m<sup>2</sup>. Vigorous rubbing or polishing is not required. The film should stay wet for up to 20-30 seconds.
3. Repeat steps 1 and 2 until the mould is completely coated. Ensure a good overlap of the coated areas to provide complete coverage.
4. When dry, allow a further 5-10 minutes between coats for the film to partially cure.
5. Repeat Steps 1-4 above for a further 2 coats (3 in total).
6. When dry, allow final film to cure for at least 20 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 HP7 in the same manner as described above.

Issue 4  
04.12.14

Marbocote Ltd  
Unit 9, Dalton Way, Middlewich  
Cheshire, CW10 0HU, UK  
Tel: +44 (0)1606 738737  
Fax: +44 (0)1606 738846  
Email: info@marbocote.co.uk