

**Product Description:**

Marbocote® Spraycote is designed to release glass reinforced polyester (GRP), vinyl ester or epoxy parts from non-porous or gelcoated moulds. Marbocote Spraycote is ideally suited for high gloss applications and provides a high gloss finish by simple spray application; there is no need for rubbing or polishing. The Marbocote Spraycote is durable and capable of giving many releases per application. It will not contaminate the released surface.

**Product Benefits:**

- Easy, fast spray application
- No waiting between coats
- Minimal mould build-up
- Versatile; will release most thermoset resins
- Durable; provides multiple releases per application

**Physical Properties:**

Appearance	- Clear, colourless liquid
Odour	- Hydrocarbon
Specific Gravity	- 0.743 g/cc
Thermal Stability	- >250°C
Flash Point	- 0°C
Solvents	- Aliphatic hydrocarbon
Coverage	- 15 - 20m <sup>2</sup> / L per coat
Shelf life	- 6 months
Storage	- Flammable store (see Safety Data Sheet for further details).

**Note:**

The polymeric resin used in Marbocote Spraycote reacts with moisture. Please ensure can is resealed after use. Marbocote Spraycote 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 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 (please see separate data sheet describing this process). Marbocote Spraycote can be applied over existing semi-permanent release agents without a further cleaning step. However, the mould should be clean and dry before use. As with all processes involving solvents,

mould cleaning and release agent application should be performed in a well ventilated area.

Marbocote Spraycote can be applied using any spray gun capable of fine atomisation. However, the use of a High Volume Low Pressure (HVLP) 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 1.4mm diameter.
2. Holding the nozzle of the gun approximately 20cm from the mould surface, adjust the output so that the film dries in approximately 2 - 3 seconds when using a normal spray technique. If the film stays wet for >5 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.
- If the product is over applied (i.e. hazes), rub the area with a clean dry cloth and reapply in the same manner as described above.
- 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 Spraycote in the same manner as described above.

23/4/03

**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.