

TECHNICAL DATA SHEET

MARBOCOTE MOULD SEALER

MARBOCOTE
RELEASE TECHNOLOGY

Product Description: Marbocote Mould Sealer is an advanced polymeric resin in an organic solvent blend. The resin seals micro porosity and fills minor scratches on the mould surface resulting in a smooth, high gloss surface primed for Marbocote top-coat application.

Recommended Uses: Marbocote Mould Sealer is especially recommended for use on new moulds and repaired areas on older moulds. Marbocote Mould Sealer can be applied on all types of glass reinforced polyester (gel coated or non-gel coated GRP), vinyl ester, epoxy or metal moulds.

Product Benefits:
Quick and easy application
Efficient mould sealer and primer
Enhances mould gloss
Low odour
Minimal mould build-up
Versatile, can be used on all mould surfaces
Durable, provides multiple releases per application

Product Characteristics:	
Appearance	Clear colourless liquid
Composition	Aliphatic hydrocarbon
Flash Point	<10°C
Thermal stability of cured film	250°C
Coverage	80 - 100 m ² / L per coat
Application Type	Wipe and spread
Shelf Life	12 months

Important: The polymeric resin used in Marbocote Mould Sealer reacts with moisture. Please ensure can is resealed after use.

Please read Safety Data Sheet before use. Do not mix with other products or solvents. Application should be conducted in a well-ventilated area. Solvent resistant gloves and eye protection must be worn during this process.

Mould Cleaning: This needs to be performed prior to product application

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 Mould Sealer can be applied over existing semi-permanent release agents without a further cleaning step. The mould must be clean and dry before use.

Application Type: Marbocote Mould Sealer is applied by a wipe and spread technique.

The choice of cloth is important; as the Marbocote Mould Sealer 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.

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Wipe Application Technique:

- 1) Apply Marbocote Mould Sealer to a clean, dry cotton cloth.
- 2) Gently wipe over mould surface covering an area of approximately 0.5-1m².
- 3) Wait for 10-20 seconds (until the edges of the wet film start to dry). Using a second dry cotton cloth gently spread the wet film. Do not wipe dry. Vigorous rubbing or polishing is not required.
- 4) Repeat until the mould is completely coated. Ensure a good overlap with the previous area to provide complete coverage.
- 5) Allow at least 10 minutes between coats for the film to cure.
- 6) Repeat Steps 1-5 above for a further coat (2 in total).
- 7) The final film needs to be cured before applying Marbocote top-coat. See table below.

Temp (°C)	Cure Time
Room temp (20°C)	30 minutes
60°C	10 minutes

Top-Coat: Marbocote Mould Sealer can be used as a sealer and primer for any Marbocote top-coat. See the specific technical data sheet for application information.

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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.