

# TECHNICAL DATA SHEET

## MARBOCOTE FASTCOTE



**Product Description:** Marbocote Fastcote is ideally suited for high gloss applications. The product is easy and quick to apply and produces a high gloss durable finish capable of giving many releases before re-application is necessary. It will not contaminate the released surface. Marbocote Fastcote is an advanced polymeric resin in a non-chlorinated organic solvent blend.

**Recommended Uses:** Marbocote Fastcote can be applied on all types of non porous molds such as steel, aluminum and composite and will release gel coated glass reinforced polyester (GRP), vinyl ester, phenolic or epoxy components.

Product Benefits:
Quick and easy application
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

Product Characteristics:	
Appearance	Clear colourless liquid
Composition	Aliphatic hydrocarbon
Flash Point	<10°C
Thermal stability of cured film	250°C
Coverage	100 - 125 m <sup>2</sup> / L per coat
Application Type	Wipe and leave
Shelf Life	12 months

**Important:** The polymeric resin used in Marbocote Fastcote 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.

For new, porous or damaged moulds, **Marbocote Mould Sealer** should be used prior to applying Marbocote Fastcote. See Marbocote Mould Sealer technical data sheet for application details.

**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 Fastcote 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 Fastcote is applied by a wipe and leave technique.

The choice of cloth is important; as the Marbocote Fastcote 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 Fastcote to a clean, dry cotton cloth. Do not over-apply; the cloth must not be soaked or dripping.
- 2) Gently wipe a **thin** film over mould surface covering an area of approximately 1m<sup>2</sup>. Vigorous rubbing or polishing is not required. The film should stay wet for up to 2 minutes.
- 3) Repeat steps 1 and 2 on the adjacent area. Ensure a good overlap with the previous area to provide complete coverage.
- 4) Frequently reapply Marbocote Fastcote to the cloth to ensure it stays wet.
- 5) Repeat until mould is completely coated.
- 6) When dry, allow a further 5-10 minutes between coats for the film to partially cure.
- 7) Repeat Steps 1-5 above for a further 2 coats (3 in total).
- 8) When dry, the final film needs to be cured before moulding. See table below.

Temp (°C)	Cure Time
Room temp (20°C)	15 minutes
60°C	5 minutes

**Note:** Use the tape-test before and after application. This will initially ensure the mould is clean and latterly, to ensure correct coverage and cure times have been observed and that the coating is ready for production. If the tape release is hesitant after application, simply apply another coat in the same manner as described above.

If the film appears hazy, it is likely that too much has been applied. Do NOT polish out the haze with a dry cloth. To remove the haze, re-apply a further thin coat of Marbocote Fastcote. Check product coverage and dry time. Frequently replace the cloth (this avoids product drying on the cloth after excessive use)

**Reapplication:** When release becomes hesitant, reapply one coat of Marbocote Fastcote in the same manner as described above. Again, allow a minimum of 15 minutes before commencing production. Often, reapplication is only required in high abrasion areas such as external corners and vertical surfaces.

## GRP moulding outside the usual 15 - 35°C range:

GRP moulding outside the usual 15 – 35°C range has many other detrimental effects, not just on the release agent. For example, gel coat application below 15°C may result in permanent under cure. The further from this ideal temperature range that moulding is performed, the highly the risk of problems occurring. Please observe the recommendations of the gel coat and/or resin manufacture(s) with respect to the use of their products at these temperatures.

Although the recommended application temperature for Marbocote Fastcote is also between 15 and 35°C, the product may be used outside this range providing the following precautions are observed:

### Below 15°C:

- Ensure mould has been sealed with Marbocote Mould Sealer
- An extra coat of Marbocote Fastcote is advised, i.e. 4 coats for old moulds, 6 coats for new moulds.
- Ensure the temperature of the Marbocote Fastcote is the same as that of the mould (to avoid condensation), i.e. store the can and the mould inside.
- Extra time should be allowed between coats; for example, at 10°C, allow a minimum of 30 minutes before the next coat is applied.
- Extra time should be allowed for the final cure; for example, at 10°C, allow a minimum of 60 minutes before starting production. An over-night cure is recommended.
- The slower drying time of Marbocote Fastcote means that greater care is required not to over apply.

### Above 35°C:

- Greater care is required to ensure the cloth does not dry-out; i.e. reapply the product frequently
- One less coat is recommended, i.e. 2 coats for old moulds and 4 coats for new moulds and repaired areas
- Ensure the use of the recommended cloths, i.e. Kimberly-Clark Wipe All X60
- Frequently replace the cloth (this avoids product drying on the cloth after excessive use).

**If in any doubt, please contact a Marbocote Technician at the number above.**

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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.