

# TECHNICAL DATA SHEET

## MARBOCOTE 227-CEE



**Product Description:** Marbocote 227-CEE is easy and quick to apply and produces a durable film capable of giving many releases before re-application is necessary and will not contaminate the released surface. Marbocote 227-CEE is an advanced polymeric resin in a non-chlorinated organic solvent blend.

**Recommended Uses:** Marbocote 227-CEE can be applied on all types of non porous molds such as steel, aluminum and composite and will release epoxy, polyester (GRP), vinyl ester and phenolic resins. Marbocote 227-CEE will not release polyurethanes.

Product Benefits:
Quick and easy application
Non-contaminating
Non-chlorinated solvents
Low odour
High slip, easy release
Minimal mould build-up
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	60 - 75 m <sup>2</sup> / L per coat
Application Type	Wipe and leave
Shelf Life	12 months

**Important:** The polymeric resin used in Marbocote 227-CEE reacts with moisture. Please ensure can is resealed after every 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 227-CEE 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 227-CEE is applied by a wipe and leave technique.

The choice of cloth is important; as the Marbocote 227-CEE 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 227-CEE to a clean, dry cotton cloth.
- 2) Gently wipe over mould surface covering an area of approximately 0.5m<sup>2</sup>. Vigorous rubbing or polishing is not required.
- 3) Repeat steps 1 and 2 on the adjacent area. 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 additional 1-2 coats in the manner described above.
- 8) When dry, the final film needs to be cured before moulding. See table below.

Temp (°C)	Cure Time
Room temp (20°C)	30 minutes
60°C	15 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.

**Reapplication:** When release becomes hesitant, reapply one coat of 227-CEE in the same manner as described above.

### Spray Application Technique:

Spray Gun Parameters	
Air pressure	2-2.5 bar (30-35 psi)
Fluid needle size	<1.2mm
Distance from mould	20-30cm

- 1) Holding the nozzle of the gun approximately 20-30cm from the mould surface, adjust the output so that the film dries in approximately 4-5 seconds when using a normal spray technique. If the film stays wet for >10 seconds, too much product is being applied.
- 2) Systematically coat the entire surface of the mould. As the film dries clear, care must be taken to over-lap sprayed areas.
- 3) Immediately after applying the first coat, apply the second at 90° to the first. No waiting is required between coats.
- 4) 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.
- 5) When dry, the final film needs to be cured before moulding. See table below

Temp (°C)	Cure Time
Room temp (20°C)	30 minutes
60°C	15 minutes

### 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.
- Depending on quantity applied, the final film may be hazy; this is normal. For a high gloss finish, Marbocote Spraycote FD is recommended.
- 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 227-CEE in the same manner as described 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.