

**Product Description:**

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

**Product Benefits:**

- Easy, fast application
- Minimal waiting between coats
- Minimal mold build-up
- Versatile, can be used on all mold surfaces
- Durable; provides multiple releases per application

**Physical Properties:**

Appearance	- Clear, colourless liquid
Odour	- Hydrocarbon
Specific Gravity	- 0.743 g/cc
Flash Point	- <72°F
Solvents	- Aliphatic hydrocarbon
Coverage	- 15 - 20m <sup>2</sup> / L per coat
Shelf life	- 1 Year
Storage	- Cool Dry location

**Note:**

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

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

Marbocote OneStep can be applied by wiping or spraying. When wiping, leave a wet film, and allow dry. A 15 minute cure time between coats is best. Do not continue to wipe during the cure time. Apply three coats before molding begins.

**Tips:**

- Test the mold surface with tape test frequently during application process as each coat cures.
- Correct application of the product produces a wet film without excessive puddles or starving the applicator cloth of product.
- 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 pre-release occurs, wipe surface with any clear that does not aggress mold surface or leave a film.
- 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 OneStep 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.

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