

#### Product Description:

Marbocote® RS415 ECO is designed as a mold sealer for glass reinforced polyester (GRP), vinyl ester, epoxy or metal molds. Marbocote RS415 ECO is an advanced polymeric resin in an organic solvent blend. The resin both seals microporosity and fills minor scratches on the mold surface. The result is a smooth, high gloss surface primed for Marbocote top-coat application. Marbocote RS415 ECO is especially recommended for use on new molds and repaired areas on older molds.

#### Product Benefits:

- Efficient mold sealer and primer
- Easy application
- Enhances mold gloss (see application details for appropriate coating technique)
- Low odor
- Minimal mold build-up
- Versatile, can be used on all mold surfaces
- Durable; provides semi-permanent base-coat for mold release agent

#### Physical Properties:

Appearance	- Clear, colourless liquid
Odour	- Hydrocarbon
Specific Gravity	- 0.80 g/cc
Flash Point	- >24°C
Solvents	- Aliphatic hydrocarbon
Coverage	- 20 - 25m <sup>2</sup> / L
Shelf life	- One year
Storage	- Flammable store (see Safety Data Sheet for further details).

#### Note:

The polymeric resin used in Marbocote RS415 ECO reacts with moisture. Please ensure can is resealed after use. Marbocote RS415 ECO 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. Marbocote RS415 ECO should only be applied to clean and dry mold surfaces. If a wax or silicone based release agent has been used previously, remove all traces of previous product using an solvent based cleaner such as Marbocote Mold Cleaner. Mold cleaning and Marbocote RS415 ECO application should be performed in a well-ventilated area.

1. Apply Marbocote RS415 ECO to clean, dry cotton cloth.
2. Gently wipe over mold surface covering an area of approximately 3 sq/ft. If a high gloss finish is NOT required, go to Step 4.
3. If a high gloss finish is desired, e.g. in GRP molding, use a second dry cotton cloth to gently wipe off the wet film. Once dry, move to adjacent area. Vigorous rubbing or polishing is not required.
4. Repeat until mold is completely coated. Ensure each application area overlaps the last to ensure complete coverage.
5. Allow at least 15 minutes to cure between coats.
6. Repeat Steps 1-5 above for a further 2 coats (3 in total).
7. Allow final film to cure for at least 30 minutes at room temperature before applying Marbocote top-coat. Allowing a longer cure or heat curing (e.g. 15 min at 60°C) will improve film durability.

#### Top-coat:

Marbocote RS415 ECO can be used a sealer and primer for any Marbocote top-coat, e.g. 75ECO, TRE45 ECO and 445ECO. 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.