



TEK-KOTE **KoverTek Semi Permanent Release agent range**

Spray-Release Gloss

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

Recommended Uses: Tek-Kote Spray-Release Gloss can be applied on all types of gel coated/non porous moulds and will release glass reinforced polyester (GRP) or vinyl ester parts.

Product Benefits:

Quick and easy spray application

Reproduces finish on mould, i.e. high gloss on high gloss moulds, matte finish on matte moulds

Ideal for non-skid or textured moulds

Fast Dry; no waiting between coats

Minimal mould build-up

Versatile, can be used on all mould surfaces

Durable, provides multiple releases per application

Important: The polymeric resin used in Tek-Kote Spray-Release Gloss 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.

Ensure supplied air is dry and free of oil lubrication. If possible, use a desiccator dryer. If airline is not dry (i.e. there is water in the airline) this can cause pre-release, hazy and fish eyes.

For new, porous or damaged moulds, **Tek-Kote Mould Sealer** should be used prior to applying Tek-Kote Spray-Release Gloss. See Tek-Kote 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 Tek-Kote Mould Cleaner. Tek-Kote Spray-Release Gloss 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: Tek-Kote Spray-Release Gloss is applied by spray technique.

When spraying, the use of a High Volume Low Pressure (HVLP) spray gun is strongly recommended. This type of spray gun will give the best drying pattern and highest gloss finish while providing optimum transfer efficiency.



Spray Application Technique:

- 1) Holding the nozzle of the gun approximately 20-30cm from the mould surface, adjust the output so that the film dries in approximately 2-3 seconds when using a normal spray technique. If the film stays wet for >5 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 old moulds (moulds having been previously coated with release agent), clean the mould as described above and apply 3 coats.
- 5) Allow a minimum of 30 minutes after the final coat for the film to cure before moulding.

Tips:

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

- 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.
- If the product is over applied (i.e. hazes), rub the area with a clean dry cloth and reapply as described above.
- 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.

Note: Use the tape-test before and after application. This will initially ensure the mould is clean and latterly, 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 Tek-Kote Spray-Release Gloss in the same manner as described above.

GRP moulding outside the usual 15 - 30°C range:

GRP moulding outside the usual 15 – 30°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 Tek-Kote Spray-Release Gloss is also between 15 and 30°C, the product may be used outside this range providing the following precautions are observed:



Below 15°C:

- An extra coat of Tek-Kote Spray-Release Gloss is advised, i.e. 4 coats for old moulds, 6 coats for new moulds.
- The spray gun should be adjusted to allow for the slower drying time of Spray-Release Gloss. For example, at 10°C, instead of the usual ideal 2-3 second dry time, the product should dry in an ideal 4-6 seconds.
- Greater care is required not to over apply, i.e. the dry time should be on longer than 10 seconds.
- Ensure the temperature of the Tek-Kote Spray-Release Gloss 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 for the final cure; for examples, at 10°C, allow a minimum of 60 minutes before starting production. An over-night coat is recommended.

Above 30°C:

- Above 30°C, as the product will dry very quickly, there is a greater tendency to over apply. Ensure that a wet film is visible for ideally 1-2 seconds. A longer dry time may result in a hazy (white) film. If this occurs, clean mould with Tek-Kote Cleaner (see Cleaner Tech Data sheet for details) and re-apply 1 coat of Spray-Release Gloss.
- Apply one less coat than standard application, i.e. a total of 2 coats for old moulds and 4 for new moulds and repaired areas.

Product Spec:

Appearance	Clear colourless liquid
Composition	Aliphatic hydrocarbon
Flash Point	<10°C
Thermal stability of cured film	250°C
Coverage	75 - 100 m ² / L per coat
Application Type	Spray
Shelf Life	12 months

NB: The advice and information given in this data sheet is given freely and in good faith and is based upon data that we believe is reliable. The data herein is based on extensive laboratory testing and experience, but we cannot test for every eventuality. It is the customers Responsibility to ensure that the product is fit for their intended purpose. KoverTek cannot guarantee anything but the quality of the product and cannot be held responsible for results obtained.