



TEK-KOTE KoverTek Semi Permanent Release agent range

Fast-Release XPRE

Product Description: Tek-Kote Fast-Release XPRE 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. Its unique formulation enables easy release without the fear of pre-release or fish-eyes, common problems with other semi-permanent release agents. Tek-Kote Fast-Release XPRE is an advanced polymeric resin in a non-chlorinated organic solvent blend.

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

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



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

Important: The polymeric resin used in Tek-Kote Fast-Release XPRE 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, **Tek-Kote Mould Sealer** should be used prior to applying Tek-Kote Fast-Release XPRE. 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 Fast-Release XPRE 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 Resi-Release is applied by a wipe and leave technique.

The choice of cloth is important; as the Tek-Kote Resi-Release 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. **DO NOT ATTEMPT TO USE NORMAL COTTON CLOTHS AS THEY CONTAIN MOISTURE.**

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Wipe Application Technique:

Apply Tek-Kote Fast-Release XPRE to a clean, dry cotton cloth. Do not over-apply; the cloth must not be soaked or dripping.

Gently wipe a **thin** film over mould surface covering an area of approximately 1m². Vigorous rubbing or polishing is not required. The film should stay wet for up to 2 minutes.

Repeat steps 1 and 2 on the adjacent area. Ensure a good overlap with the previous area to provide complete coverage.

Frequently reapply Tek-Kote Fast-Release XPRE to the cloth to ensure it stays wet.

Repeat until mould is completely coated.

When dry, allow a further 5-10 minutes between coats for the film to partially cure.

Repeat Steps 1-5 above for a further 2 coats (3 in total).

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 Tek-Kote Fast-Release XPRE 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 - 30°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 Tek-Kote Fast-Release XPRE 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 Tek-Kote Mould Sealer
- An extra coat of Tek-Kote Fast-Release XPRE is advised, i.e. 4 coats for old moulds, 6 coats for new moulds.
- Ensure the temperature of the Tek-Kote Fast-Release XPRE 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 Tek-Kote Fast-Release XPRE means that greater care is required not to over apply.

Above 30°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 for old moulds and 4 for new moulds and repaired areas
- Ensure the use of the recommended cloths, i.e. Kimberly-Clark Wipe All X60

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