



REXCO MOLD RELEASES FOR GLASS REINFORCED CONCRETE / GLASS FIBRE REINFORCED CONCRETE (GRC / GFRC)



Glass Reinforced Concrete (GRC) or Glass Fiber Reinforced Concrete (GFRC) is a type of fiber reinforced concrete used in building façade panels and architectural decoration. Mold or form substrates range from wood to fiberglass to CNC milled urethane and polystyrene foams. Form releases aid in a clean release of the part from the mold while offering protection for the mold surface. Fragile mold surfaces including rigid foams and elastomeric rubbers can benefit from the use of release agents through reduction of abrasion from aggregates and demolding and chemical attack. Rexco Mold Care Products offers the following mold releases suitable for GRC/GRFC that are easy to use and will aid in clean part removal, extended mold service and enhanced part detail. Note that wax based mold releases are sacrificial in nature and will transfer to the part surface leaving a protective coating. Normal acid bath or sandblasting processes will remove wax transfer that may impede painting or coating operations.



MARBALEASE® SLURRY WAX

A semi-paste mold release wax, water-white in color and silicone-free used to prevent the unwanted bonding of the composite material to the mold/tooling and assists in the removal of the part from the mold. Typical application is with a medium density bristle brush. Paint an even coating of Marbalease® Slurry Wax on mold surface and allow to dry. Apply a second coat of Marbalease® Slurry Wax and allow to dry to the touch. Not intended to be polished to a shine. Avoid excessive build up of release in corners and decorative textures to prevent loss of detail. Clean up with mineral spirits or with TSP (trisodium phosphate) solution and scrub brush or ScotchBrite pad.



MARBALEASE® POLYMER CONCRETE RELEASE

Marbalease® Polymer Concrete Release is a fast-drying solvent-based liquid mold release made from a blend of hydrocarbon and micro-crystalline waxes. Packaged in durable 5-gallon containers with a convenient pour spout, this liquid wax is an economical single-use release for use on most mold substrates and with a variety of room temperature cure matrices including polyester and vinylester resins or Portland cement. With a high flash point of >61 °C Marbalease® Polymer Concrete Release is not regulated for air, ocean or ground transportation. A fast-drying liquid mold release wax designed for polymer concrete and GFRC applications for use on polyester, elastomeric, metal and expanded or extruded foam molds. Low viscosity liquid formulation that allows for spray or easy brush on application. Mix well before use as solids may settle in storage. Spray, wipe or brush on an even coat of Marbalease® Polymer Concrete Release to mold surface including flanges, edges and supports that may come in contact with matrix. Allow to dry. For initial part apply a total of three coats, allowing to dry between coats and before casting the first part. Apply additional coats as needed for each additional part cast. Clean up with mineral spirits or with TSP (trisodium phosphate) solution and scrub brush or ScotchBrite pad.





*REXCO MOLD RELEASES FOR GLASS REINFORCED CONCRETE / GLASS FIBRE
REINFORCED CONCRETE (GRC / GFRC)*

PARTALL® POWER LIQUID MOLD RELEASE

PARTALL® POWER Liquid Mold Release is a nonhazardous water-based polymeric external mold release that gives a matte finish (non-cosmetic finish) to parts and aids in the casting of Glass Fiber Reinforced concrete (GFRC). It is designed for use on most mold substrates including expanded and extruded foams, FRP/GRP composite, glass, aluminum and steel. This product provides multiple releases, ease of application, and minimal fouling of tooling during processing. Ideal for spraying but may be brushed, wiped or rolled on mold surface. Nonflammable, nonhazardous. Using a traditional or HVLP spray gun apply an even coating of PARTALL® POWER Liquid Mold Release to form. Allow to dry. Apply three coats allowing to dry between each before casting the first part; no polishing required but polishing will give a smoother finish to part. Reapply for each part as required. Formulation will not interfere with post-finishing operations. Alternative application is to brush or wipe on initial PARTALL® POWER Liquid Mold Release to form, allow to dry and then spray additional coats as required for continued part casting.

FORMULA FIVE® MATTE TOP COAT

An extremely durable solvent-based semi-permanent mold release for non-cosmetic part production; will maintain a matte finish on parts made from matte finish molds; and aids in the casting of Glass Fiber Reinforced concrete (GFRC). Apply with spray equipment or soft density solvent resistant paint brush being careful not to over saturate polystyrene surfaces as solvent carrier may damage form surface. Build up three coats of Formula Five® Matte Top Coat allowing each coat to cure, up to 15 minutes at ambient temperature, before applying the next and before casting first part. Will not transfer to finished part or interfere with post-finishing or bonding operations. Minimal mold buildup to reduce loss of detail.



SPRAY EQUIPMENT FOR LIQUID MOLD RELEASES

Pictured are an number of options for spraying of REXCO brand liquid mold releases for GFRC / GRC. Left to right: Compression Sprayer, Cup Gun, Pressure Pot and Spray Gun, Gravity Fed HVLP Gun.



The information and recommendations contained in this bulletin are, to the best of our knowledge, accurate and reliable. No guarantee of their accuracy is made, however, and the products discussed are sold without warranty, express or implied, and upon conditions that the purchasers shall make their own tests to determine the suitability of such products for their particular purposes and uses. Revision I, July 2009.

REXCO • P.O. Box 80996 • Conyers, GA 30013 • U.S.A.
Telephone +1-770-483-7610 • Fax +1-770-483-8550
E-mail: info@rexco-usa.com • Website: www.rexco-usa.com