

CRYSTIC[®] MOULDGUARD (B)

Mould Protection Coating

Introduction

Crystic Mouldguard (B) is a flexible pre-accelerated thixotropic coating material for mould protection. It has been formulated for brush application and is available in a restricted range of colours. The information contained in this technical datasheet also applies to these pigmented versions.

Applications

Crystic Mouldguard (B) has been specifically developed for the protection of composite moulds when put into storage or for transportation. The cured coating has been designed to give easy stripping from stored moulds prior to re-use.

Features and Benefits

Crystic Mouldguard (B) remains permanently flexible when cured.

Formulation

Crystic Mouldguard (B) should be allowed to attain workshop temperature (18°C - 20°C) before use. Stir well by hand, or with a low shear mixer to avoid aeration, and then allow to stand to regain thixotropy. Crystic Mouldguard (B) requires only the addition of catalyst to start the curing reaction. The recommended catalyst is Butanox M50 (or other equivalent catalyst), which should be added at a level of 2%. (Please consult our Technical Service Department if other catalysts are to be used). The catalyst should be thoroughly incorporated into Crystic Mouldguard (B), with a low shear mechanical stirrer where possible.

Crystic Mouldguard (B), mould and workshop should all be at, or above, 15°C before curing is carried out.

Application

For normal requirements, the application of Crystic Mouldguard (B) should be controlled to 0.5 - 0.6mm (0.020 - 0.024 inches) wet film thickness. As a guide, approximately 600-700g/m² of Crystic Mouldguard (B) (depending on pigment) will give the required thickness when evenly applied.

See the separate application guide for recommendations for the use Crystic Mouldguard (B).

Removal of Crystic Mouldguard (B)

In order to strip off the coating the mould should be cleared of any water and accumulated debris. The mould should then be brought into the workshop and allowed to reach ambient temperature prior to the start of removal in order to reduce the risk of condensation on the actual mould surface. The coating should be initially released from the complete perimeter of the mould edge. Stripping should take place by applying an even force and pulling the coating consistently across the surface of the mould. Once removed the coating can be rolled up for disposal as due to its flexibility it should not generate sharp edges.

Additives

Crystic Mouldguard (B) is supplied in a restricted range of colours. This eliminates the potential for mixing errors with small quantities of pigment paste. The addition of fillers or pigments can adversely affect the properties of the cured product.

Typical Properties

The following tables give typical properties of Crystic Mouldguard (B).

Property		Liquid Gelcoat
Appearance		Coloured
Viscosity at 25°C		Thixotropic
Specific Gravity at 25°C		1.12
Volatile Content	%	29
Stability at 20°C	months	3
Gel time at 25°C using 2% Butanox M50 (or other equivalent catalyst)	minutes	15

Storage

Crystic Mouldguard (B) should be stored in its original container and out of direct sunlight. It is recommended that the storage temperature should be less than 20°C, where practical, but should not exceed 30°C. Ideally, containers should only be opened immediately prior to use.

Packaging

Crystic Mouldguard (B) is supplied in 25kg containers.

Health and Safety

Please see separate Material Safety Data Sheet.

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