

LOCTITE

1001 Trout Brook Crossing
Rocky Hill, CT 06067-3910
Telephone: (860) 571-5100
FAX: (860) 571-5465

Product Description Sheet

FREKOTE[®] Aqualine[®] R-150

Mold Release Agent

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Description

Loctite[®] Frekote[®] Aqualine[®] R-150 offers excellent release and slip properties and is recommended for the most demanding molding applications, especially for highly abrasive compounds. When properly applied to a preheated surface, this water based product chemically bonds to the mold surface to form a thin, inert, thermally stable coating capable of releasing all natural and synthetic rubber compounds as well as thermoplastic urethanes and some solid polyurethane cast elastomers.

Features

- Fast curing
- Excellent slip
- Non flammable
- Low mold buildup
- Maximum number of multiple releases
- Reduced reject rates
- Very low VOC, < 10 g/L
- Freeze/Thaw Stable

Properties

Appearance	White emulsion
Application Temperature	60°C - 204°C (140 - 400°F)
Odor	Mild
Special Cautions	Store below 40°C (104°F).
Specific Gravity	1.00 +/- 0.02
Thermal stability when cured	315°C (600°F)
Shelf Life	12 months from the date of manufacture

Mold Preparation

Mold surfaces must be thoroughly cleaned and dried. All traces of prior release agents and contaminants must be removed. This may be accomplished by using Frekote PMC or other suitable solvents. Heavy build-up will probably require abrasion (e.g., grit sand or glass beading) followed by solvent washing. This will remove polymer build-up or previous release contamination.

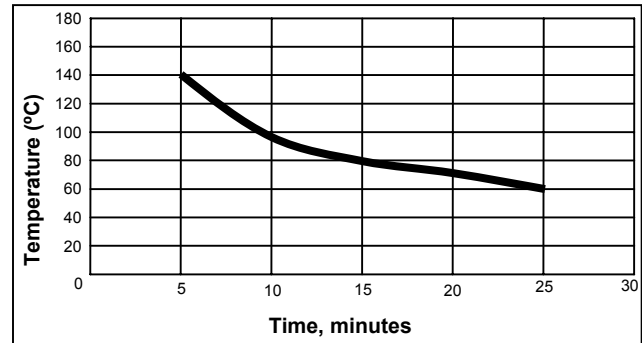
Application 'Consult MSDS Prior To Use'

Apply Aqualine R-150 to molds preheated to a minimum of 60°C (140°F). Application of Aqualine R-150 is suitable for application up to 204°C (400°F).

Apply Aqualine R-150 using a finely atomized fan pattern. Regulate gun output to 2-3 fl. oz./minute for molds heated to 60°C - 149°C (140°F - 300°F) or 4-5 fl. oz./minute for molds above 149°C (300°F).

At 60°C (140°F), the release agent will dry in a few seconds and will be fully cured after 25 minutes. At 93°C (200°F), this cure time is reduced to 10 minutes. At 149°C (300°F), Aqualine R-150 dries instantly and requires only four minutes to fully cure (see cure curve).

Cure Time R-150



For hot 121°C - 204°C; (250°F - 400°F), or porous molds, apply a minimum of six coats. For warm 60°C - 121°C (140°F - 250°F), a minimum of four coats should be applied with care being taken to avoid emulsion accumulation and run marks due to over application. Allow time for the release agent to cure prior to production.

Touch Up

Touch up coats should only be applied to areas where poorer release is noticed. This will reduce the possibility of release agent or polymer build up. Again, allow at least 4 minutes at 149°C (300°F), 10 minutes at 93°C (200°F), or 30 minutes at 60°C (140°F) for the touch up coat to cure before continuing production. The frequency of touch up will depend on polymer type, mold configuration, and abrasion parameters.

Storage

Aqualine R-150 should not be stored above 40°C (104°F).

Note

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ROCKY HILL, CT FAX: +1 (860)-571-5473 DUBLIN, IRELAND FAX: +353-(1)-451-9959

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