



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

Product Description Sheet

FREKOTE[®] B-15

Mold Sealer

Industrial Products, October 2003

Description

Loctite[®] Frekote[®] B-15 is formulated as a sealer for metal molds with micro porosity problems, small surface scratches or imperfections. Used in conjunction with other Frekote products, B-15 provides an excellent base coat enhancing the release advantages offered.

Features

Seals mold porosity, scratches or imperfections
No contaminating transfer
High thermal stability

Properties

Appearance	Clear liquid
Odor	Sweet Ether
Solvents	Dibutyl Ether
Specific Gravity	0.760 +/-0.015
Special Cautions	Moisture sensitive, keep container tightly closed when not in use
Cured Thermal Stability	400°C (750°F)
Application Temp	20°C - 60°C (68°F - 140°F)
Shelf Life	One year from date of manufacture

Mold Preparation

The mold surface must be clean and free of any release agent or other contaminants for Frekote B-15 to be completely effective. Remove any contaminants with Frekote PMC or another suitable cleaning solvent. Light industrial abrasives can be used to remove heavy resin build up.

New Molds: Remove any machining oils or greases with Frekote PMC or suitable solvent. Vapor degreasing may also be used if available. Special care should be taken not to damage resin molds. Molds previously coated with silicones can be cleaned with Frekote PMC, removing any trace of solvent with a clean cloth. Light industrial abrasives can be used to remove heavier build-up.

Application ****Consult MSDS prior to use****

Frekote B-15 can be applied to mold surfaces by spraying, brushing, dipping or wiping with a clean lint free cloth. When spraying, ensure a dry air source is used or use an airless spray system making sure the nozzles is 8" to 10" from the mold surface.

Brushing and dipping are effective methods of application, but care should be taken to avoid excessive pooling and to ensure that the part is well drained. Wiping on is the best method of application.

1. Only a thin wet film is required. It is suggested that small areas be coated, working progressively from one mold to the other.
2. Apply a minimum of two coats, allowing 30 minutes between coats.
3. The final coating will cure within 24 hours at room temperature, or the cure process can be shortened by baking the mold for 60 minutes at 94°C (200°F) after ensuring that the mold is dry and all solvents have flashed off.

4. The mold is now ready to be coated with Frekote Mold Release products. Please refer to individual product data sheets for the proper application of the release agent.

Flammability/Storage

Frekote B-15 contains flammable solvents. The product should always be used in well-ventilated areas. Store in a cool, dry place. Keep container tightly closed when not in use. Consult MSDS for complete details.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more, United States, or foreign patents or patent applications.

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

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