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Product Description Sheet

FREKOTE® Cast Urethane Release

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Description

Loctite® Frekote® Cast Urethane Release has been designed to form a semi-permanent release coating on the mold surface for rigid, cast polyurethane products. Frekote Cast Urethane Release is intended to be applied to a mold surface at a temperature between 20°-150°C (68°-302°F). The multiple release non-transferring system chemically bonds to the mold surface to form a micro thin chemically resistant coating. Frekote Cast Urethane Release cures very rapidly on the mold surface. It has minimal build-up and exhibits high thermal and chemical stability for most PU molding processes.

Features

Fast cure
No transfer
Minimal mold build-up
Multiple releases

Properties

Color	Clear liquid
Odor	Hydrocarbon
Solvent	Aliphatic Hydrocarbon
Specific Gravity	0.71 g/cm ³
Special Caution	Moisture sensitive, keep container tightly closed when not in use
Application Temp	20°C - 150° C (68°F -302°F)
Cured thermal stability	400°C (750°F)

Mold Preparation

Mold surfaces must be thoroughly cleaned and dried. All traces of prior release agents and urethane build-up must be removed. This may be accomplished, by using "Dynasolve" (Dynaloy Corporation, Indianapolis, IN, 800 669 5709) cleaner or other suitable cleaner followed by a PMC wipe. Heavy build-up will probably require abrasion such as bead blasting, followed by solvent washing.

Application *Consult MSDS prior to use*

When the mold is clean and free from other release agent or contaminant, it can be heated to its molding temperature. Frekote Cast Urethane Release may be applied by spraying (ensuring a dry air source), airless spray, wiping, or brushing. Spray applications are the preferred method for applying this material to a pre-heated mold. Always use in a well-ventilated area.

Spraying/Wiping/Brushing

1. When spraying the material, it is essential to always use a dry, oil free air source or electric airless spray guns. Keeping the nozzle 8-10 inches from mold surface spray on a light uniform coating.
2. When brushing or wiping on to the mold make sure a smooth and uniform coat is deposited on the mold surface.

3. Apply a minimum of three base coats to the pre-heated mold allowing 5 minutes between coats for solvent evaporation, and 5 minutes for curing after the last coat. Care should be taken not to over apply the material to the mold surface. Maximum release will be obtained as the mold becomes conditioned to Frekote Cast Urethane Release. Applying a touch-up coat when difficult release occurs can restore release performance.

Touch up

Touch up coats should be applied at regular intervals determined by the operator. This will depend on the polymer type, mold configuration and abrasion parameters. Touch up coats will maintain the base coats, hence reducing the chance for compound or polymer build-up.

Flammability/Storage

Cast Urethane Release contains flammable solvents. The product should always be used in well-ventilated areas. Store in a cool dry place. Consult MSDS for complete details.

Note

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