LOCTITE

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Product Description Sheet

FREKOTE® 815-NC

Mold Release Agent

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Description

Loctite® Frekote® 815-NC has been designed to form a semi-permanent release interface on mold surfaces with application temperatures from room temperature to 135°C (275°F). The non-migratory multiple release system chemically bonds to the mold surface to form a micro thin chemically resistant coating. Frekote 815-NC will release all natural and synthetic organic rubber compounds. It has minimal build-up on the mold surface and exhibits high thermal stability for all molding processes. During touch-up cycles where application temperatures are above 135°C (275°F) we recommend Frekote 800-NC.

Features

Room temperature application
No mold build-up
High thermal stability
Reduced reject rates
Releases most rubber compounds
Maximum mold utilization
Provides instant on line capability

Properties

Color	Clear liquid
Odor	Hydrocarbon
Solvents	Aliphatic Naphtha
Specific Gravity	0.750 +/- 0.020
Shelf Life	1 year from date of manufacture
Cured thermal stability	400ºC (750°F)
Special Cautions	Moisture sensitive, keep container tightly closed when not in use.

Mold Preparation

The mold surface must be clean and free of any release agent or other contaminants for Frekote 815-NC to be completely effective. Remove any contaminants with Frekote PMC or other suitable cleaning solvents. Light industrial abrasives can be used to remove heavy resin build up.

New Molds Full curing of new molds is advisable to ensure the best bonding of the Frekote to the mold surface. New fiberglass and epoxy molds should be cured per manufacturer's instructions before starting full scale production.

Note For porous, green or repaired molds, a Frekote Sealer should be used - technical data is available. Consult with your Frekote Representative for assistance.

Application *Consult MSDS prior to use*

Frekote 815-NC may be applied by spraying (ensuring a dry air source), airless spray, brushing, dipping or wiping. When wiping, 100% cotton cloths should be used. Care should be taken to avoid contact with hands and eyes. Always use in a well, ventilated area.

1. Apply a light uniform coat of Frekote 815-NC. Always apply in a well, ventilated area and allow complete solvent evaporation. Wipe or spray on a smooth, thin, continuous wet film. Avoid wiping or spraying over the same area that was just coated until the solvents have evaporated.

2. Apply a second coat perpendicular to the first, again avoiding pool or run marks due to over application. Allow to fully dry for 10-15 minutes between coats at room temperature.

3. A total of three light coats should be applied. The final coating will cure within one hour at room temperature or the cure process may be accelerated by baking the dried coating at 60°C (140°F) or above for fifteen minutes, i.e. by bringing mold to processing temperature for high temperature processes.

4. Maximum releases will be obtained as the mold becomes conditioned to Frekote. Performance will be improved by applying a touch-up coat of Frekote 815-NC after the first few multiple releases. Frekote 815-NC efficiency may be less in the process involving heavy filled polymers and additional touch-ups may be necessary in such areas.

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 reduce the chance for compound or polymer build-up. In situations where application temperatures fall below 135°C (275°F), Frekote 815-NC is recommended. For application temperatures above 135°C (275°F) Frekote 800-NC is recommended.

Flammability/ Storage

Frekote 815-NC 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.