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Visit the web for immediate access to:

- Distributor Information
- Technical Data Sheets
- Material Safety Data Sheets
- Product Literature

FREKOTE®

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**For technical product assistance, call:
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FREKOTE®

Mold Release Solutions Guide

2010 Volume 2



Frekote®

Superior mold release every time

The Frekote® Line of Products is the Broadest Mold Release Line – Frekote® mold release agents, backed by over 40 years of research and development, are the global industry standard for performance, quality, and value. By pioneering release solutions for many of the world’s largest manufacturing organizations, Henkel understands what it takes to release the most complex materials in the most demanding applications. Henkel has developed Frekote® mold release agents for virtually all types of composite and rubber molding operations. The Frekote® line offers the broadest product range in the industry. From jumbo jets to tennis racquets, truck tires to o-rings, from custom yachts to bathtubs, we have the release agent you need for most composite and rubber materials.

Lowest Cost per Release – Frekote® semi-permanent release agents minimize fouling and ensure the highest number of releases possible per application. Our customers realize higher productivity and profitability through reduced downtimes, lower reject rates, and higher quality products. Frekote® products are the industry standard replacement for sacrificial release agents. Unlike sacrificial waxes or silicones, Frekote® semi-permanent mold release agents do not transfer to your parts; instead they chemically bond to the mold surface, allowing the parts to release cleanly with no mold release transfer.

Frekote® products are designed to save you money. As an example, the following table represents how polyester molders minimize their molding cost with Frekote® semi-permanent mold release technology:

RELEASE PRODUCTS	TRADITIONAL	FREKOTE® BRAND		
	PASTE WAX	FRP-NC™	WOLO™	SOLO®
Labor time (hours)	10 to 15	6 to 7	4 to 5	0.5
Labor cost	\$100 to \$150	\$60 to \$70	\$40 to \$50	\$5
Material cost	\$25	\$95	\$95	\$120
Number of releases	5	20	25	30
Direct cost	\$25 to \$35	\$7.75 to \$8.25	\$5.40 to \$5.80	\$4.17

Values cited above represent approximated values as of July 2007.

World Standard Products for Release Application – Henkel has found “partnering” with customers is a highly effective way of finding solutions to tough molding and application problems. Customers around the globe turn to Frekote® products not just for our unique mold releases, but also for our expertise in developing “customized” solutions. We take pride in our knowledge, experience, and responsiveness in providing the best technical service to our customers around the globe.

Frekote® Product Selection

This comprehensive guide is designed to make it easy for you to select the right Frekote® mold release agent for a variety of markets and applications. Simply select a suitable release agent for demolding specific substrates and compare the characteristics of different products using the technical data. Choose the compatible dispensing equipment for your application and see the product list for ordering information. For additional assistance, visit www.frekode.com, or call **1-800-562-8483** in the U.S. or **1-800-263-5043** in Canada.

Advanced Composite Systems	2
• Aerospace - Aircraft, Helicopters . . .	
• Recreational - Bicycles, Skis, Racquets . . .	
• Specialty - Racing Parts, Medical, Electronics, Filament Windings . . .	
FRP Composites: Polyester, Vinyl Ester	4
• Marine - FRP Boats, Yachts, Jet-skis . . .	
• Transportation - FRP Panels, Roofs, Spoilers . . .	
• Construction - FRP Wind Rotor Blades, Cultured Marble Sinks and Countertops, Bathtubs . . .	
Rotational / Plastic Molding	6
• Recreational - Kayaks, Pedal Boats . . .	
• Construction - Containers, Tanks, Chains, Waste Bins . . .	
Rubber Industry	8
• Technical Rubber - Vibration Dampers, Roller Blade Wheels, Footwear, Custom Molding . . .	
Sacrificial Mold Releases	10
Sealers and Cleaners, and Specialty Products	12
Product Information	14
• Materials Application Guide and Troubleshooting Guide	
• Ordering Information / Index	

New Frekote® Wipes

Now Available!

Several Frekote® mold release agents are now available in easy-to-use, pre-packaged wipes, including Frekote® 44-NC™, 55-NC™ and 710-LV™. See page 15 for ordering information.



Frekote® Release Agents for

Advanced Composite Systems

YOUR APPLICATION

PRODUCT TYPE

APPLICATION

FINISH

FREKOTE® BRAND SEALER*

FREKOTE® BRAND SOLUTION

Solvent-based / Semi-Permanent

Compression Molding / Casting / Vacuum Bagging

High-Slip

High Performance Composites

Matte Finish

Satin Finish

Gloss Finish

Gloss Finish

B-15™

B-15™

B-15™ or FMS-100™

B-15™ or FMS-100™

44-NC™

55-NC™

700-NC™

770-NC™

710-LV™

Description:	Release Agent	Release Agent	Release Agent	Release Agent	Release Agent
Appearance:	Clear liquid	Clear liquid	Clear liquid	Clear liquid	Clear liquid
Application Temperature:	59°F to 140°F (15°C to 60°C)	59°F to 140°F (15°C to 60°C)	59°F to 275°F (15°C to 135°C)	59°F to 140°F (15°C to 60°C)	59°F to 275°F (15°C to 135°C)
Cure Time Between Coats at 70°F (21°C):	10 to 15 minutes	5 minutes	5 to 10 minutes	5 to 10 minutes	5 to 10 minutes
Final Cure Time at 70°F (21°C):	3 hours	30 minutes	15 to 20 minutes	5 to 10 minutes	15 to 20 minutes
Final Cure Time at 212°F (100°C):	15 minutes	5 minutes	15 to 20 minutes	5 minutes	15 to 20 minutes
Thermal Stability:	up to 752°F (400°C)	up to 752°F (400°C)	up to 752°F (400°C)	up to 752°F (400°C)	up to 750°F (399°C)

PRODUCT DESCRIPTION

Frekote® 44-NC™

- No mold build-up
- No contaminating transfer
- High thermal stability

Frekote® 44-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 15 minutes between coats to dry. Curing of the final coat takes 3 hours at room temperature and can be shortened by baking the mold for 15 minutes at 212°F to 302°F (100°C to 150°C). **Also available in wipes.**

Frekote® 55-NC™

- Fast cure time
- No mold build-up
- Reduced odor

Frekote® 55-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 5 minutes between coats to dry. Curing of the final coat takes 30 minutes at room temperature and can be shortened by heating the mold for 5 minutes at 212°F to 302°F (100°C to 150°C). **Also available in wipes.**

Frekote® 700-NC™

- Mild odor
- Slower room temperature cure
- High slip

Frekote® 700-NC™ is a versatile release agent that provides a high slip where mold geometry problems are encountered. It cures at room temperature to give a high gloss finish to the molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free, cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.

Frekote® 770-NC™

- Low odor
- Faster room temperature cure
- High slip

Frekote® 770-NC™ is a versatile release agent that provides a high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free, cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.

Frekote® 710-LV™

- Fast room temperature cure
- Reduced VOC
- High slip
- Gloss finish

Frekote® 710-LV™ is a reduced VOC, semi-permanent release agent formulated specifically for release of high performance composite materials. Frekote® 710-LV™ will release thermoset and prepreg epoxies, polyester resins, and thermoplastic compounds. It cures quickly at room temperature, giving a high gloss finish on molded parts. Frekote® 710-LV™ provides a non-contaminating transfer so that parts can be painted or bonded in other assemblies. **Also available in wipes.**



Water-based / Semi-Permanent		Sacrificial	
Filament Winding	Application Temp. 20°C to 40°C	Application Temp. 60°C to 205°C	Filament Winding
Gloss Finish	Matte Finish	Matte Finish	Gloss Finish
B-15™ or FMS-100™	No Sealer	RS-100™*	N/A
720-NC™	C-600™	Aqualine® C-200™	EXITT™
Release Agent	Release Agent	Release Agent	Release Agent
Clear liquid	White emulsion	White emulsion	Clear liquid
59°F to 110°F (15°C to 43°C)	68°F to 104°F (20°C to 40°C)	68°F to 400°F (20°C to 205°C)	68°F to 140°F (20°C to 60°C)
15 minutes	10 to 15 minutes	10 minutes	Solvent Evaporation (up to 60 seconds)
15 to 20 minutes	30 minutes	40 min. @ 140°F (60°C) 20 min. @ 212°F (100°C) 15 min. @ 248°F (120°C)	Solvent Evaporation (up to 60 seconds)
N/A*	N/A*	20 minutes	N/A*
up to 752°F (400°C)	up to 600°F (315°C)	up to 600°F (315°C)	up to 500°F (260°C)

Helpful Hints

Frekote® B-15™ Mold Sealer is mostly used for metal and composite molds.

Frekote® FMS-100™ Mold Sealer is recommended for composite molds.

Frekote® RS-100™ is used with Aqualine® products.

Frekote® PMC™ is a universal cleaner prior to application of Frekote® Release Agents.

♦ Refer to page 12 for more info and proper application temperature.



Frekote® 720-NC™

- Fast room temperature cure
- High slip
- Gloss finish

Frekote® 720-NC™ is a semi-permanent release agent formulated specifically for release of all cast polymer products and for releasing highly filled resins. It cures quickly at room temperature, giving a gloss finish on finished parts. This product is also suitable for certain abrasive closed molding processes, such as RTM and filament winding, and is also ideal for use on highly porous mold surfaces.

Frekote® C-600™

- Water-based
- Mold release agent with inherent sealer

Frekote® C-600™ is a semi-permanent mold release agent that is a proprietary water-based emulsion. It is developed for releasing large scale parts such as wind blades. It is also ideal for numerous other high performance composite structures.

Frekote® Aqualine® C-200™

- Water-based
- No mold build-up
- No contaminating transfer

Frekote® Aqualine® C-200™ is a water-based release agent which provides multiple release with no contaminating transfer. It gives no mold build-up and exhibits high thermal stability for all molding processes. Apply 4 coats to clean mold surfaces at a mold temperature ≥140°F (60°C). Allow each coat to dry before applying subsequent coats. Dry time may be decreased by using a fan or infrared lamp. Post cure the final film for at least 40 minutes at 140°F (60°C) or 20 minutes at 212°F (100°C).

Frekote® EXITT™

- Sacrificial coating
- Silicone based
- High gloss finish

Frekote® EXITT™ provides a superior high gloss finish on molds. It is not recommended for use with parts that need to be painted, bonded, or stained. This product was developed for use with urethane elastomer systems but will also release urethane foams, organic rubber compounds, and most specialty molding resins. No mold build-up, precise retention of mold detail.



Frekote® Release Agents for

FRP Composites

Polyester, Vinyl Ester

YOUR APPLICATION

PRODUCT TYPE

SUBSTRATE

FINISH

APPLICATION

FREKOTE® BRAND SEALER*

FREKOTE® BRAND SOLUTION

Solvent-based

Cast Polymer / Solid Surface

Gel-Coat

Gloss Finish

Gloss Finish

Wipe On/Buf Out

Wipe On/Leave On

Spray On/Leave On

Wipe On/Wipe Off

Wipe On/Leave On

FMS-100™

FMS-100™

SOLO®

FMS-100™

FMS-100™

Frewax®

WOLO™

SOLO®

FRP-NC™

WOLO™

Description:	Release Agent	Release Agent	Release Agent	Release Agent	Release Agent
Appearance:	Milky white liquid	Clear liquid	Clear liquid	Clear liquid	Clear liquid
Application Temperature:	59°F to 95°F (15°C to 35°C)	59°F to 104°F (15°C to 40°C)	59°F to 113°F (15°C to 45°C)	59°F to 104°F (15°C to 40°C)	59°F to 104°F (15°C to 40°C)
Cure Time Between Coats at 70°F (21°C):	5 to 10 minutes (allow to haze dry)	5 minutes	N/A*	15 to 20 minutes	5 minutes
Final Cure Time at RT‡:	5 to 10 minutes	15 minutes	20 to 30 minutes	15 to 20 minutes	15 minutes
Final Cure Time at 212°F (100°C):	N/A*	N/A*	N/A*	N/A*	N/A*
Thermal Stability:	up to 536°F (280°C)	up to 752°F (400°C)	up to 752°F (400°C)	up to 752°F (400°C)	up to 752°F (400°C)

PRODUCT DESCRIPTION

Frekote® Frewax®

- Easy to use
- Visible release agent
- High gloss finish

Frekote® Frewax® is a combination of a wax and a polymer release agent. This combination provides the user with the advantages of an easy-to-apply liquid wax and the multiple release performance of a semi-permanent release. Shake Frekote® Frewax® well before and during use. Apply to clean mold surfaces with a clean, lint-free, cotton cloth. Allow Frekote® Frewax® 5 to 10 minutes to haze, then polish the coated mold until a high gloss is obtained. Change cloth frequently; apply a total of 4 coats.

Frekote® WOLO™

- Easy application
- Multiple releases
- High gloss finish

Frekote® WOLO™ is a unique polymer release agent that cures quickly and provides multiple release of all polyester resins. Application and use are simple – wipe it on and allow to evaporate to produce a high gloss finish. No polishing is needed. Apply Frekote® WOLO™ with a clean wiping cloth. Wipe a smooth, wet film over the mold surface. Continue to work the material into the mold by lightly wiping the wet film (10 to 30 seconds) until a thin and uniform coating is obtained and allow to evaporate.

Frekote® SOLO®

- High gloss finish
- Minimal mold build-up
- Fast curing/
Easy application

Frekote® SOLO® is a unique polymer release agent designed for all gel-coat fiberglass reinforced and filled polyester composites. Application of this product is spray on/leave on using a light and uniform spray pattern to obtain a high gloss finish without polishing. Apply a minimum of 7 coats to a clean mold surface; typically 1 gallon of Frekote® SOLO® will cover 150 square feet of mold surface.

Frekote® FRP-NC™

- Minimal mold build-up
- Maximum mold utilization
- High gloss finish

Frekote® FRP-NC™ is a semi-permanent release interface specifically formulated for reinforced polyester gel-coats. It provides minimal mold build-up thus eliminating buffing and cleaning between applications. Apply to clean mold surfaces with a clean cloth. Wipe on a smooth, wet film. Wait 10 to 20 seconds at room temperature after application. Gently wipe dry with a second dry, cotton cloth. Apply a maximum of 6 coats initially. Allow 15 to 20 minutes cure time between coats and after the final coat at room temperature.

Frekote® WOLO™

(See "Did You Know?")

- Easy application
- Multiple releases
- High gloss finish

Frekote® WOLO™ is a unique, polymer release agent that cures quickly and provides multiple release of all polyester resins. Application and use are simple – wipe it on and allow to evaporate to produce a high gloss finish. No polishing is needed. Apply Frekote® WOLO™ with a clean wiping cloth. Wipe a smooth, wet film over the mold surface. Continue to work the material into the mold by lightly wiping the wet film (10 to 30 seconds) until a thin and uniform coating is obtained and allow to evaporate.

Did You Know?

Frekote® WOLO™ is also available as a low VOC formulation: Frekote® WOLO-LV™. Visit us on the web at www.freko.com for more information.



Solvent-based

Solvent-based		Non Gel-Coat	
High Gloss Finish	Matte Finish	Satin Finish	Gloss Finish
Wipe On/Leave On	Wipe On/Wipe Off	Wipe On/Wipe Off	Wipe On/Wipe Off
FMS-100™	B-15™	B-15™	B-15™ or FMS-100™
WOLO-HL™	44-NC™	55-NC™	770-NC™
Release Agent	Release Agent	Release Agent	Release Agent
Clear liquid	Clear liquid	Clear liquid	Clear liquid
55°F to 106°F (13°C to 41°C)	59°F to 140°F (15°C to 60°C)	59°F to 140°F (15°C to 60°C)	59°F to 140°F (15°C to 60°C)
15 minutes	10 to 15 minutes	5 minutes	5 to 10 minutes
30 minutes	3 hours	30 minutes	5 to 10 minutes
N/A*	15 minutes	5 minutes	N/A*
up to 752°F (400°C)	up to 752°F (400°C)	up to 752°F (400°C)	up to 752°F (400°C)

Helpful Hints

Frekote® B-15™ Mold Sealer is mostly used for metal and epoxy molds.

Frekote® FMS-100™ Mold Sealer is recommended for composite molds.

Frekote® RS-100™ is used with Aqualine® products.

Frekote® PMC™ is a universal cleaner prior to application of Frekote® Release Agents.

Refer to page 12 for more info.

Frekote® WOLO-HL™

- High Gloss
- Easy Application
- Multiple Releases
- Used for low VOC gelcoat

Frekote® WOLO-HL™ is a semi-permanent release agent for low VOC polyester gelcoat parts. WOLO-HL™ can be applied and cured at room temperature. No sealer is required. This product offers a reduction in mold release VOC's by as much as 72%. WOLO-HL™ offers maximum slip and high release performance.

Frekote® 44-NC™

- No mold build-up
- No contaminating transfer
- High thermal stability

Frekote® 44-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 15 minutes between coats to dry. Curing of the final coat takes 3 hours at room temperature and can be shortened by baking the mold for 15 minutes at 212°F to 302°F (100°C to 150°C). **Also available in wipes.**

Frekote® 55-NC™

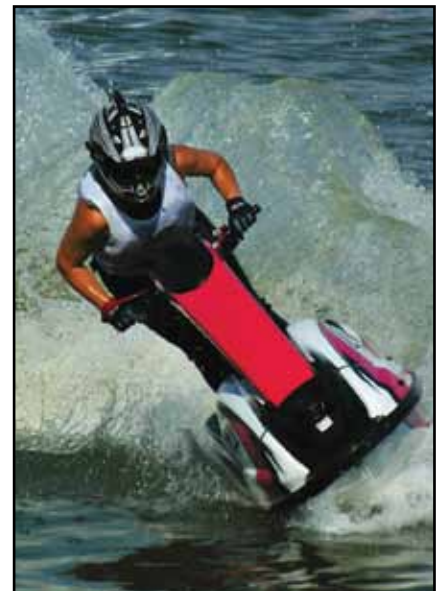
- Fast cure time
- No mold build-up
- Reduced odor

Frekote® 55-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 5 minutes between coats to dry. Curing of the final coat takes 30 minutes at room temperature and can be shortened by heating the mold for 5 minutes at 212°F to 302°F (100°C to 150°C). **Also available in wipes.**

Frekote® 770-NC™

- Fast room temperature cure
- High gloss and high slip
- Releases most polymers

Frekote® 770-NC™ is a versatile, semi-permanent release agent which provides high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to the molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.



Visit www.frekote.com

Frekote® Release Agents for

Rotational / Plastic Molding

YOUR APPLICATION

SUBSTRATE	Polyamide (PA / Nylon)		Polyethylene (PE)	
	Water-based	Solvent-based	Water-based	Solvent-based
PRODUCT TYPE	High Temperature	Low Temperature	High Temperature	Low Temperature
APPLICATION	RS-100™	B-15™	RS-100™	B-15™
FREKOTE® BRAND SEALER*	Aqualine® Rotolease®	55-NC™	Aqualine® Rotolease®	770-NC™
FREKOTE® BRAND SOLUTION				
Description:	Release Agent	Release Agent	Release Agent	Release Agent
Appearance:	White emulsion	Clear liquid	White emulsion	Clear liquid
Application Temperature:	140°F to 399°F (60°C to 204°C)	59°F to 140°F (15°C to 60°C)	140°F to 399°F (60°C to 204°C)	59°F to 140°F (15°C to 60°C)
Cure Time Between Coats at 70°F (21°C):	10 minutes	5 minutes	10 minutes	5 to 10 minutes
Final Cure Time at Room Temperature‡:	5 minutes @ 302°C (150°F) 15 minutes @ 248°C (120°F) 35 minutes @ 149°C (65°F)	30 minutes	5 minutes @ 302°C (150°F) 15 minutes @ 248°C (120°F) 35 minutes @ 149°C (65°F)	5 to 10 minutes
Final Cure Time at 212°F (100°C):		5 minutes		N/A*
Thermal Stability:	up to 750°F (400°C)	up to 752°F (400°C)	up to 750°F (400°C)	up to 752°F (400°C)

PRODUCT DESCRIPTION

Frekote® Aqualine® Rotolease® ♦

- No mold build-up
- High thermal stability

Frekote® Aqualine® Rotolease® is a water-based, semi-permanent release agent formulated for a multiple release system when used with rotationally molded resins. When applied correctly, this product offers no mold build-up, room temperature application, no contaminating transfer, and high thermal stability. When Frekote® Rotolease® is applied at room temperature, the mold surface should be post-cured at 149°F (65°C). If molds are >104°F (40°C), apply a minimum of three coats, allowing each to dry before subsequent coats are applied.

Frekote® 55-NC™

- Fast cure time
- No mold build-up
- Reduced odor

Frekote® 55-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 5 minutes between coats to dry. Curing of the final coat takes 30 minutes at room temperature and can be shortened by heating the mold for 5 minutes at 212°F to 302°F (100°C to 150°C).
Also available in wipes.

Frekote® Aqualine® Rotolease® ♦

- No mold build-up
- High thermal stability

Frekote® Aqualine® Rotolease® is a water-based, semi-permanent release agent formulated for a multiple release system when used with rotationally molded resins. When applied correctly, this product offers no mold build-up, room temperature application, no contaminating transfer, and high thermal stability. When Frekote® Rotolease® is applied at room temperature, the mold surface should be post-cured at 149°F (65°C). If molds are >104°F (40°C), apply a minimum of three coats, allowing each to dry before subsequent coats are applied.

Frekote® 770-NC™

- Fast room temperature cure
- High gloss and high slip
- Releases most polymers

Frekote® 770-NC™ is a versatile, semi-permanent release agent which provides high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.



Polypropylene (PP)

Water-based

Solvent-based

High Temperature

Low Temperature

RS-100™

B-15™

**Aqualine®
Rotolease®**

770-NC™

Release Agent

Release Agent

White emulsion

Clear liquid

140°F to 399°F
(60°C to 204°C)

59°F to 140°F
(15°C to 60°C)

10 minutes

5 to 10 minutes

5 minutes @ 302°C (150°F)
15 minutes @ 248°C (120°F)
35 minutes @ 149°C (65°F)

5 minutes

N/A*

up to 750°F (400°C)

up to 752°F (400°C)

Frekote® Aqualine® Rotolease® ♦

- No mold build-up
- High thermal stability

Frekote® Aqualine® Rotolease® is a water-based, semi-permanent release agent formulated for a multiple release system when used with rotationally molded resins. When applied correctly, this product offers no mold build-up, room temperature application, no contaminating transfer, and high thermal stability. When Frekote® Rotolease® is applied at room temperature, the mold surface should be post cured at 149°F (65°C). If molds are >104°F (40°C), apply a minimum of three coats, allowing each to dry before subsequent coats are applied.

Frekote® 770-NC™

- Fast room temperature cure
- High gloss and high slip
- Releases most polymers

Frekote® 770-NC™ is a versatile, semi-permanent release agent which provides high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.

Helpful Hints

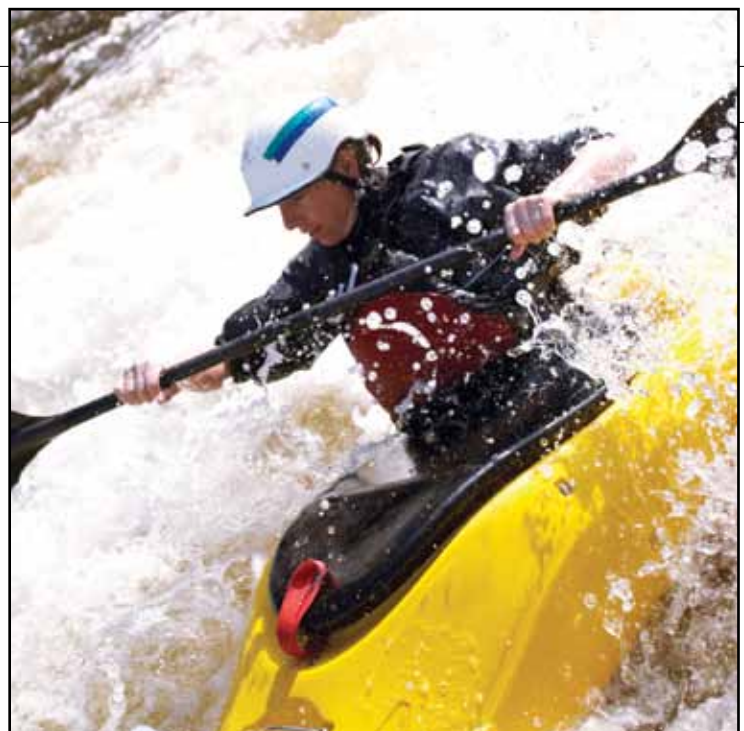
Frekote® B-15™ Mold Sealer is mostly used for metal and epoxy molds.

Frekote® RS-100™ is used with Aqualine® products.

Frekote® PMC™ is a universal cleaner prior to application of Frekote® Release Agents.

Refer to page 12 for more info.

♦ *Rotolease® is recommended for rotational molding applications.*

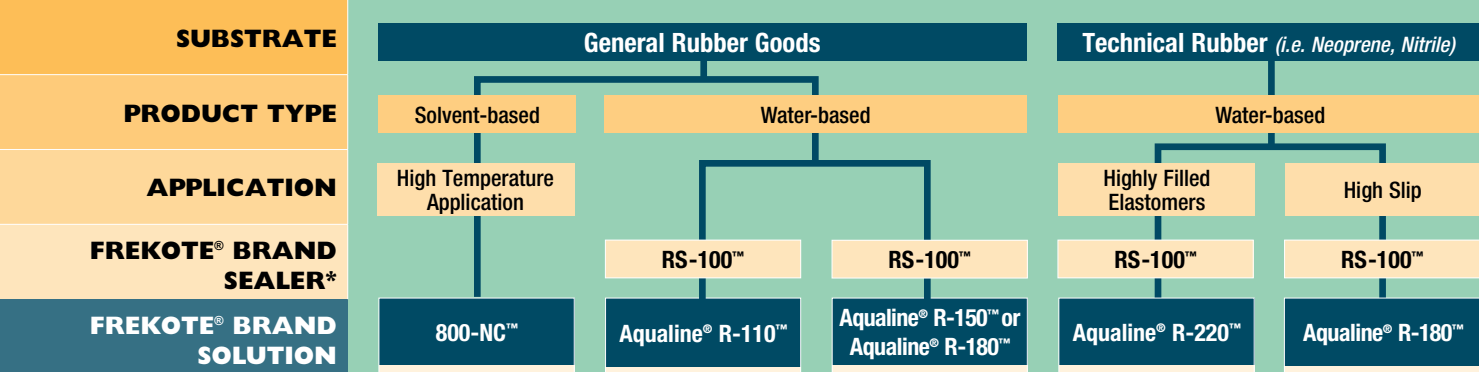


Visit www.frekote.com

Frekote® Release Agents for

Rubber Industry

YOUR APPLICATION



	800-NC™	Aqualine® R-110™	Aqualine® R-150™ or Aqualine® R-180™	Aqualine® R-220™	Aqualine® R-180™
Description:	Release Agent	Release Agent	Release Agent	Release Agent	Release Agent
Appearance:	Clear liquid	White emulsion	White emulsion	White emulsion	White emulsion
Application Temperature:	68°F to 275°F (20°C to 135°C)	140°F to 401°F (60°C to 205°C)	140°F to 401°F (60°C to 205°C)	140°F to 401°F (60°C to 205°C)	140°F to 401°F (60°C to 205°C)
Final Cure Time at 140°F (60°C):	15 minutes	30 minutes	30 minutes	25 minutes	30 minutes
Final Cure Time at 302°F (150°C):	N/A*	4 minutes	4 minutes	4 minutes	4 minutes
Thermal Stability:	up to 752°F (400°C)	up to 599°F (315°C)	up to 599°F (315°C)	up to 599°F (315°C)	up to 599°F (315°C)

PRODUCT DESCRIPTION

Frekote® 800-NC™

- No chlorinated solvents
- Maximum mold usage
- Reduced reject rates

Frekote® 800-NC™ is a semi-permanent release interface for molding rubber compounds. The multiple release, non-migratory system bonds to the mold surface to form micro-thin coatings. Spray apply 3 to 4 light, smooth uniform coats to clean mold surfaces. Use only a dry air source and ensure a continuous smooth wet film is achieved. Allow film to dry and cure prior to commencing molding.

Frekote® Aqualine® R-110™

- Fast curing
- No transfer
- High thermal stability

Frekote® Aqualine® R-110™ is a semi-permanent water-based release agent which provides maximum release performance with high slip properties. Apply by spraying to clean molds, pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

Frekote® R-150™ or Aqualine® R-180™

- Fast curing
- High slip
- Minimum reject rates

Frekote® Aqualine® R-150™ and Frekote® Aqualine® R-180™ are both water-based release agents which provide excellent slip properties. Recommended for the most difficult molding applications, especially for highly abrasive compounds. Apply by spraying to clean molds, pre-heated to ≥140°F (60°C). For warm molds 140°C to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot 248°F to 401°F (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

Frekote® Aqualine® R-220™

- Fast curing
- Excellent slip
- Releases most compounds

Frekote® Aqualine® R-220™ is a water-based release agent. It offers excellent release and slip properties and is recommended for the most difficult molding applications, especially for high aspect ratio parts. Apply by spraying to clean molds pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot 248°F to 401°F (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

Frekote® Aqualine® R-180™

- Fast curing
- High slip
- Minimum reject rates

Frekote® Aqualine® R-180™ is a water-based release agent, which provides excellent slip properties. Recommended for the most difficult molding applications, especially for highly abrasive compounds. Apply by spraying to clean molds pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot 248°F to 401°F (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.



Rubber-to-Metal Bonding

Silicone Elastomer

Water-based

Solvent-based

Water-based

Highly Filled Elastomers

Ready to Use

RS-100™

RS-100™

Aqualine® R-220™

Aqualine® R-120™

HMT™ or HMT-2™

S-50™

Release Agent

Release Agent

Release Agent

Release Agent

White emulsion

White emulsion

Clear liquid

Yellowish liquid

140°F to 401°F
(60°C to 205°C)

140°F to 401°F
(60°C to 205°C)

140°F to 374°F
(60°C to 190°C)

221°F to 401°F
(105°C to 205°C)

25 minutes

30 minutes

5 minutes

N/A*

4 minutes

4 minutes

1 minute

Instantly

up to 599°F (315°C)

up to 599°F (315°C)

up to 752°F (400°C)

up to 401°F (205°C)

Frekote® Aqualine® R-220™

- Fast curing
- Excellent slip
- Releases most compounds

Frekote® Aqualine® R-220™ is a water-based release agent. It offers excellent release and slip properties and is recommended for the most difficult molding applications, especially for high aspect ratio parts. Apply by spraying to clean molds pre-heated to $\geq 140^\circ\text{F}$ (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

Frekote® Aqualine® R-120™

- Fast curing
- No transfer
- High thermal stability

Frekote® Aqualine® R-120™ is a semi-permanent water-based release agent which provides maximum release performance with high slip properties. Apply by spraying to clean molds, pre-heated to $\geq 140^\circ\text{F}$ (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

Frekote® HMT™ or HMT-2™

- Multiple releases
- Minimum reject rates
- No contaminating transfer

Frekote® HMT™ and Frekote® HMT-2™ are both excellent solvent-based release products designed for multiple release applications to hot molds $\geq 140^\circ\text{F}$ (60°C). Frekote® HMT-2™ is less moisture sensitive than Frekote® HMT™. Brush or spray apply (ensure dry air source) 4 to 6 wet film coatings to clean mold surfaces. Allow a few minutes between coats for solvent evaporation. Cure is completed during solvent evaporation. Molding can commence immediately.

Frekote® S-50™

- Instant cure at elevated temperatures
- Excellent slip
- Maximum multiple releases

Frekote® S-50™ is a unique water-based release agent which cures rapidly at elevated temperatures. It offers excellent slip properties and is suitable for the most demanding silicone rubber molding applications. Apply to clean mold surfaces by spraying and ensure a dry air source or airless spray system. Initially, 2 to 3 coats of full strength Frekote® S-50™ should be applied to condition the mold. Touch-up coats should only be applied to areas where poorer release is noticed.

Helpful Hints

Frekote® PMC™ is a universal cleaner prior to application of Frekote® Release Agents.

Frekote® RS-100™ is used with Aqualine® products.

Frekote® R-110™, R-120™, R-220™, S-10WB™ available as aerosol.

Frekote® HMT-2™, 770™, 800™, 810™ solvent-based available as aerosol.

Refer to page 12 for more info.



Visit www.frekote.com

Frekote®

Sacrificial Mold Releases

YOUR APPLICATION

SUBSTRATE

General Purpose

Phenolic

Silicone

Epoxies and Thermoset Resins

PRODUCT TYPE

Water-based

Solvent-based

APPLICATION REQUIREMENT

General Purpose

FREKOTE® BRAND SOLUTION

EXITT-EM™

1450™

S-50™

1711™ or 1711-I™

Description:

Release Agent

Release Agent

Release Agent

Release Agent

Appearance:

White emulsion

Light Amber

Yellowish liquid

Clear liquid

Application Temperature:

140°F to 355°F
(60°C to 180°C)

140°F to 355°F
(60°C to 180°C)

220°F to 390°F
(104°C to 200°C)

68°F to 140°F
(20°C to 60°C)

Cure Time Between Coats at 70°F (21°C):

Liquid Evaporation
(up to 10 min. at room temp.)

Liquid Evaporation
(up to 10 min. at room temp.)

Liquid Evaporation
(up to 10 min. at room temp.)

Solvent Evaporation
(up to 60 seconds)

Final Cure Time at 70°F (21°C):

Liquid Evaporation
(up to 10 min. at room temp.)

Liquid Evaporation
(up to 10 min. at room temp.)

Liquid Evaporation
(up to 10 min. at room temp.)

Solvent Evaporation
(up to 60 seconds)

Final Cure Time at 100°C:

Liquid Evaporation

Liquid Evaporation

Liquid Evaporation

N/A*

Thermal Stability:

up to 500°F (260°C)

N/A*

< 392°F (200°C)

up to 500°F (260°C)

PRODUCT DESCRIPTION

Frekote® EXITT-EM™

- High gloss finish
- No mold build-up
- Precision retention of mold detail

Frekote® EXITT-EM™ is a water-based silicone emulsion that offers superb release properties, excellent part detail, and provides a water-based alternative to solvent-based products to meet your specific molding requirements. Frekote® EXITT-EM™ is capable of releasing most thermoset and thermoplastic resins, including polyurethanes and can be applied to steel, aluminum, epoxy, urethane, and ceramic mold surfaces.

Frekote® 1450™

- Economical use
- Minimal build-up
- Easy to clean molds

Frekote® 1450™ is a water-based solution, specifically formulated for use with resin/asbestos products. It has been extremely effective in releasing resin/asbestos mixtures molded at 302°F to 329°F (150°C to 165°C) as well as automotive disc brake linings. This product can be diluted from 10:1 to 20:1, which makes it an economical choice for use when a sacrificial product is desired.

Frekote® S-50™

- Instant cure at elevated temperature
- Excellent slip

Frekote® S-50™ is a water-based material designed for excellent slip in the most difficult-to-release silicone rubber applications. Frekote® S-50™ has no required cure time, low VOC, excellent slip, and low mold build-up. This product forms a thin, inert, thermally stable coating capable of releasing many types of silicone rubbers and is capable of being diluted to a wide range of ratios.

Frekote® 1711™

- Aerosol
- General purpose
- High gloss
- Stable at 500°F (260°C)

Frekote® 1711™ and Frekote® 1711-I™ are silicone, solvent-based, mold release agents that offer a high gloss finish with excellent part detail and mold geometry retention. These products can be applied to steel, aluminum, epoxy, ceramic, and flexible mold surfaces, and are stable up to 500°F (260°C).

Frekote® 1711-I™

- Non-aerosol liquid
- General purpose
- High gloss
- Stable at 500°F (260°C)



Urethanes				
Solvent-based	Solvent-based			
High Slip	High Gloss	Semi-Gloss, Easy Clean		Reaction Injection Molding
AC-4368™	EXITT™ or EXITT-I™	LIFFT™ or LIFFT-I™		Rimlease 8™
Release Agents	Release Agents	Release Agents		Release Agent
Clear liquid	Clear liquid	Clear liquid		Clear liquid
68°F to 140°F (20°C to 60°C)	68°F to 140°F (20°C to 60°C)	68°F to 140°F (20°C to 60°C)		68°F to 140°F (20°C to 60°C)
Solvent Evaporation (5 to 10 minutes)	Solvent Evaporation (up to 60 seconds)	Solvent Evaporation (up to 60 seconds)		Solvent Evaporation (up to 60 seconds)
Solvent Evaporation (5 to 10 minutes)	Solvent Evaporation (up to 60 seconds)	Solvent Evaporation (up to 60 seconds)		Solvent Evaporation (up to 60 seconds)
N/A*	N/A*	N/A*		N/A*
up to 500°F (260°C)	up to 500°F (260°C)	up to 500°F (260°C)		up to 599°F (315°C)

**Frekote®
AC-4368™**

- Excellent slip
- Multi-purpose release

Frekote® AC-4368™ is an all-purpose, silicone based release agent. This product contains a special lubricant which provides optimum release along with surface conditioning on any metal or plastic mold. Frekote® AC-4368™ works equally well releasing epoxies, polyurethanes, and polyesters in room temperature and elevated cure systems.

Frekote® EXITT™ Frekote® EXITT-I™

- Aerosol
- Silicone based
- High gloss finish
- Non-aerosol liquid
- Silicone based
- High gloss finish

Frekote® EXITT™ and Frekote® EXITT-I™ are sacrificial mold releases, developed specifically for urethane elastomer systems. They give a high gloss finish with a precise retention of the mold detail and no build-up. These products will also release urethane foams, organic rubber compounds, and most specialty molding resins, but are not recommended where parts are to be painted, bonded, or stained. Ideally applied at room temperature. Once the solvents have flashed, these coatings are stable up to 482°F (250°C).

Frekote® LIFFT™ Frekote® LIFFT-I™

- Aerosol
- Silicone based
- High gloss finish
- Non-aerosol liquid
- Silicone based
- High gloss finish

Frekote® LIFFT™ and Frekote® LIFFT-I™ provide a semi-gloss finish on molds and allow for easy part clean-up. These products were developed for use with urethane foams and cast elastomers, and are not recommended for use with parts that need to be painted or bonded.

**Frekote®
Rimlease 8™**

- Semi-gloss finish
- Excellent slip
- Minimal transfer

Frekote® Rimlease 8™ was specifically formulated for use as a release interface for RIM and R/RIM polyurethane processes. Frekote® Rimlease 8™ offers a high slip, semi-gloss finish and transfers to the part slightly, but can be easily cleaned using warm water prior to painting or any other post-molding process.

Frekote®

Sealers and Cleaners, and Specialty Products

YOUR APPLICATION	Sealers and Cleaners				
PRODUCT TYPE	Sealers			Cleaners	
SUBSTRATE	Metal Molds	Metal Molds	Polyester, Composite and Fiberglass Molds	Polyester, Epoxy, and Metal Molds	Polyester, Epoxy, and Composite Molds
APPLICATION REQUIREMENT	Solvent-based	Water-based	Solvent-based	Solvent-based	Water-based
FREKOTE® BRAND SOLUTION	B-15™	Aqualine® RS-100™	FMS-100™	PMC™	915WB™
Description:	Mold Sealer	Mold Sealer	Mold Sealer	Mold Cleaner	Mold Cleaner
Appearance:	Clear liquid	Clear liquid	Clear liquid	Clear liquid	Beige, pasty liquid
Application Temperature:	59°F to 140°F (15°C to 60°C)	199°F to 401°F (93°C to 205°C)	55°F to 105°F (13°C to 41°C)	68°F to 86°F (20°C to 30°C)	68°F to 104°F (20°C to 40°C)
Cure Time Between Coats at 70°F (21°C):	30 minutes	15 minutes	15 minutes	N/A*	N/A*
Final Cure Time at 70°F (21°C):	24 hours [60 min. at 212°F (100°C)]	20 minutes	20 minutes	N/A*	N/A*
Thermal Stability:	up to 750°F (400°C)	up to 698°F (370°C)	up to 750°F (400°C)	N/A*	N/A*

PRODUCT DESCRIPTION

Frekote® B-15™

- Easy to apply
- Seals mold porosity
- High thermal stability

Frekote® B-15™ mold sealer is formulated to seal mold micro-porosity and light surface scratches. Used in conjunction with other Frekote® products, Frekote® B-15™ provides an excellent base coat, enhancing the release advantages offered. Apply light uniform coats to clean mold surfaces by spraying, brushing, dipping, or wiping with a clean, lint-free cotton cloth. Apply a minimum of 2 coats, allowing 30 minutes between coats. The final coating will cure within 24 hours at room temperature.

Frekote® RS-100™

- Water-based product
- Seals mold porosity
- High thermal stability

Frekote® RS-100™ is a water-based sealer used to seal micro-porosity in steel, and chrome plated molds. Frekote® RS-100™ provides an excellent base coat that significantly increases the number of releases.

Frekote® FMS-100™

- Easy to use
- High gloss finish
- Fast curing

Frekote® FMS-100™ is a proprietary solvent-based, high performance sealer. It is formulated to use on FRP, epoxy, and other composite mold surfaces. Frekote® FMS-100™ can be applied at room temperature, and cures within 30 minutes of application.

Frekote® PMC™

- Easy to use
- Eliminates contaminants
- Enhances release effectiveness

Frekote® PMC™ is a special blend of solvents that dissolves and removes wax from composite molds without dulling the surface. Excellent for epoxy and metal mold surfaces as well as brushes and equipment. Apply Frekote® PMC™ to mold surfaces with a clean, cotton cloth. Wax (or other surface contamination) will immediately begin to dissolve and should be removed from the surface with a second clean cloth while the wax is still dissolved in the Frekote® PMC™.

Frekote® 915WB™

- High gloss finish
- Minimal mold build-up
- Fast curing/easy application

Frekote® 915WB™ is a water-based cleaner, developed for removing residue from mold surfaces. The high grade surfactants and emulsifiers, along with the combination of fine abrasives, give excellent results without dulling the mold surface. This product is wiped on and allowed to haze dry, much like a conventional wax, then buffed out to a high gloss finish. Frekote® 915WB™ is designed to be applied and buffed at room temperature, but the temperature should not exceed 105°F (40°C).



Cleaner	Specialty Products				
Cleaner Mold Release	Semi-Permanent Release				
Polyester, Composite and Fiberglass Molds	Sand Casting	Organic Rubber	Highly Filled Polymer	Cast Urethane	Polyurethane
Solvent-based	100% Solids	Water-based	Solvent-based	Solvent-based	Water-based
CMR™	Rel-Eaze™	RC-321™	EFR™	CUR™	PUR-100™
Cleaner / Mold Release	Release Agent	Release Agent	Release Agent	Cleaner / Mold Release	Release Agent
Clear liquid	Clear Liquid	White emulsion	Clear liquid	Clear liquid	Milky, white emulsion
55°F to 105°F (13°C to 41°C)	55°F to 302°F (13°C to 105°C)	140°F to 400° (60°C to 205°C)	55°F to 109°F (13°C to 43°C)	55°F to 105°F (13°C to 41°C)	Above 120°F (48°C)
N/A*	N/A*	Liquid Evaporation	5 minutes	5 minutes	Liquid Evaporation [Instant at 302°F (150°C)]
15 minutes	N/A*	5 min. at 302°F (150°C) 10 min. 212°F (100°C) 30 min. at 140°F (60°C)	15 minutes	15 minutes	5 min. at 302°F 10 min. 212°F (100°C) 30 min. at 140°F (60°C)
up to 750°F (400°C)	up to 750°F (400°C)	up to 600°F (315°C)	up to 750°F (400°C)	up to 750°F (400°C)	up to 600°F (315°C)

Frekote® CMR™

- Easy application
- Fast curing
- High gloss
- No touch-up needed after cleaning

Frekote® CMR™ is a unique polymer release agent containing a special blend of resins and cleaning solvents designed to dissolve and remove polymer, composite, and other residues from polyester molds without dulling the surface. Frekote® CMR™ is highly recommended for cleaning polyester mold surfaces with mold build-up resulting from repeated releases using Frekote® WOLO™. Additional releases can be obtained after cleaning the mold surface without touching up with a traditional mold release agent.

Frekote® Rel-Eaze™

- Utilized in sand core release
- Cold box applications
- Multiple releases

Frekote® Rel-Eaze™ is a high performance product developed for releasing sand cores used in foundry operations. It can be applied at room temperature. The product offers multiple releases of sand cores and sand molds.

Frekote® RC-321™

- Fast curing
- No contaminating transfer
- Dilutable (3:1)
- Freeze/thaw stable

Frekote® RC-321™ is a water dilutable concentrate that provides a durable release film for most rubber molding applications. Frekote® RC-321™ chemically bonds to the mold surface to provide a non-transferring film capable of releasing all natural and synthetic polymers (except silicone elastomers). This product cures in 5 minutes at 300°F (149°C), provides minimal mold build-up, and does not transfer to the molded parts.

Frekote® EFR™

- Fast curing
- Easy application
- Seals porous flanges

Frekote® EFR™ is designed specifically as a semi-permanent, polymeric release agent for flange sealing on composite molds. Frekote® EFR™ chemically bonds to the mold surface and is ideal for use with highly abrasive processes, such as polymer concrete molding.

Frekote® CUR™

- Fast cure
- No transfer
- Minimal mold build-up
- Multiple releases

Frekote® CUR™ was formulated to form a semi-permanent release coating on the mold surface for rigid, cast polyurethane products. Frekote® CUR™ was designed to be applied to mold surfaces at 68°F to 302°F (20°C to 150°C). The multiple release, non-transferring system chemically bonds to the mold surface to form a micro-thin chemically resistant coating. Cures very rapidly on the mold surface, has minimal mold build-up, and high thermal and chemical stability.

Frekote® PUR-100™

- Non-toxic, water-based system
- Freeze-thaw stable
- Multiple releases
- Parts can be painted after molding without preparation

Frekote® PUR-100™ is a proprietary, water-based emulsion developed for releasing rigid, high-density polyurethane foam and cast polyurethane parts. This unique formulation is capable of multiple releases from a single application. Parts molded with Frekote® PUR-100™ can be painted without any additional preparation.

Visit www.frekode.com

Product Information

MATERIALS APPLICATION GUIDE

FREKOTE® BRAND MOLD RELEASE AGENTS		44-NC™	55-NC™	700-NC™	770-NC™	800-NC™	810-NC™	C-200™	C-600™	FREWAX®	FRP-NC™	HMT™	HMT-2™	R-110™	R-120™	R-150™	R-180™	R-220™	S-50™	WOLO™	WOLO-HL™	SOLD®	REL-EAZE™		
POLYMER	Epoxy (Non Gel-Coat)	○	○	○	○			○	○		○	○	○												
	Polyester Gel-Coat – Glossy			◆	◆					◆	○	○	○								○		○		
	Polyester Gel-Coat – Matte	○	◆									○	◆												
	Polyester Gel-Coat / Resin – Low Shrink		◆	○	○						◆		◆								◆	○	◆		
	Polyamide (PA / Nylon)	○	◆	◆	◆				○				○	◆											
	Polyester (Non Gel-Coat)	◆	◆	○	○					◆		◆	◆	◆											
	Polyethylene (PE)	◆	◆	◆	○				○				◆	◆											
	Polypropylene (PP)	◆	◆	◆	○				○				◆	◆											
	Vinyl Ester	◆	◆	○	○					○			◆	◆											
COMPOUND	Butyl														○	○	○								
	EPDM														◆	○	○								
	HNBR															○	○	○							
	Natural													○	○	○	○								
	Neoprene														◆	◆	◆								
	Nitrile														◆	◆	◆								
	Silicone															◆	◆		○						
	Thermoplastic Urethane (TPU)															○	○								
	Vamac														○	○	○								
	Viton														◆	◆	◆								
PROCESS	Cast Polymer / Solid Surface	◆	◆	◆	◆					◆	○	◆	◆								○				
	Compression / Transfer / Vacuum Bagging	○	○	○	○			○				○	○	○	○	○	○		○						
	Filament Winding			◆	○																				
	Hand Lay up / Spray up	◆	◆	◆	◆					◆	○	◆	◆									○			
	Injection Molding													◆	◆	○	○		○						
	Rotational Molding				○				○																
	Rubber-to-Metal Bonding					◆	◆								○	○	○	○		◆					
	Tire Treads															◆	○		◆						
	Sand Casting																							○	

○ Highly Recommended ◆ Recommended

TROUBLESHOOTING GUIDE

Problem	Cause	Solution
<i>Complete failure to obtain release</i>	Insufficiently cleaned mold surface has prevented Frekote® from bonding to the mold	Strip out part; thoroughly clean mold and reapply Frekote®
	Improperly cured Frekote® film	Ensure that Frekote® is fully cured before molding
	Precipitated and thus ineffective Frekote®	Examine Frekote®, if separation is present, replace with fresh material; clean mold and reapply
<i>Poor release accompanied by small particles of molding material left on mold surface</i>	Micro-porosity present in mold	Thoroughly clean mold and apply a Frekote® mold sealer; reapply Frekote® top coats
<i>Poor release accompanied by white patches on parts</i>	Insufficiently cleaned mold surface that prevents Frekote® from bonding properly, resulting in transfer to parts	Thoroughly clean mold and reapply Frekote®
<i>Poor release accompanied by discolored blemishes on parts</i>	Solvent-based Frekote® contaminated by use of synthetic application cloths and contaminants applied to tool surface	Thoroughly clean mold and reapply Frekote®, ensuring the use of non-synthetic application cloths
<i>Poor release in high-draft areas</i>	Lack of slip due to mold geometry to difficult high-draft areas	Apply one or two extra coats of Frekote® or touch-up coats with Frekote® WOLO-HS™
<i>Inability to achieve multiple release</i>	Unconditioned mold surface	Reapply Frekote® frequently for initial production shift; thereafter gradually decrease the frequency of application
	Separated and thus ineffective Frekote®	Examine Frekote®, if separation is present, use fresh material
<i>Good release but build-up of Frekote® on mold surface</i>	Over application of Frekote®	Thoroughly clean mold and reduce amount of Frekote® applied
<i>Good release but parts exhibit white blemishes</i>	Excessive Frekote® applied to mold, resulting in transfer to parts	Thoroughly clean mold and reduce amount of Frekote® applied

For technical product assistance, call 1-800-562-8483 in the U.S. or 1-800-263-5043 in Canada.

Ordering Information / Index

FREKOTE® BRAND PRODUCT	ITEM NUMBER	CONTAINER SIZE	PIECES PER CASE	PAGE
44-NC™	83430	16 fl. oz. can (1 pint)	4	2, 5
	83434	1 gallon can	4	2, 5
	83433	5 gallon pail	1	2, 5
	83432	55 gallon drum	1	2, 5
44-NC™ Wipes	987545	1 case (20 packs w/10 wipes/pack)	200	2, 5
48-NC™	83435	16 fl. oz. can (1 pint)	4	Web*
	83438	1 gallon can	4	Web*
	83437	5 gallon pail	1	Web*
55-NC™	83444	9.6 oz. net wt. aerosol	12	2, 5, 6
	83440	16 fl. oz. can (1 pint)	4	2, 5, 6
	83443	1 gallon can	4	2, 5, 6
	83442	5 gallon pail	1	2, 5, 6
	83441	55 gallon drum	1	2, 5, 6
55-NC™ Wipes	41694	1 case (20 packs w/10 wipes/pack)	200	2, 5, 6
700-NC™	83428	10.5 oz. net wt. aerosol	12	2
	38424	16 fl. oz. can (1 pint)	4	2
	38425	1 gallon can	4	2
	38426	5 gallon pail	1	2
	38427	55 gallon drum	1	2
710-LV™	41345	1 gallon can	4	2
	41344	5 gallon pail	1	2
710-LV™ Wipes	105340†	1 case (20 packs w/10 wipes/pack)	200	2
710-NC™	38429	1 gallon can	4	Web*
	38430	5 gallon pail	1	Web*
	38431	55 gallon drum	1	Web*
720-NC™	38422	16 fl. oz. can (1 pint)	4	3
	38423	1 gallon can	4	3
770-NC™	83469	9.6 oz. net wt. aerosol	12	2, 5, 6, 7
	83465	16 fl. oz. can (1 pint)	4	2, 5, 6, 7
	83468	1 gallon can	4	2, 5, 6, 7
	83467	5 gallon pail	1	2, 5, 6, 7
800-NC™	83466	55 gallon drum	1	2, 5, 6, 7
	83474	10.7 oz. net wt. aerosol	12	8
	83473	1 gallon can	4	8
810-NC™	83472	5 gallon pail	1	8
	83479	10.3 oz. net wt. aerosol	12	Web*
815-NC™	83483	1 gallon can	4	Web*
	83482	5 gallon pail	1	Web*
	83481	55 gallon drum	1	Web*
EFR™	38432	16 fl. oz. can (1 pint)	4	13
	38434	5 gallon can	1	13
FRP-NC™	38416	16 fl. oz. can (1 pint)	4	4
	38417	1 gallon can	4	4
	38418	5 gallon pail	1	4
	38419	55 gallon drum	1	4
PUR-NC™	83570	1 gallon can	4	Web*
	83569	5 gallon pail	1	Web*
CUR™	83508	16 fl. oz. can (1 pint)	4	13
	83510	1 gallon can	4	13
	83509	5 gallon pail	1	13
SOLO®	38406	16 fl. oz. can (1 pint)	4	4
	38407	1 gallon can	4	4
	38408	5 gallon pail	1	4
	38409	55 gallon drum	1	4
WOLO™	83631	16 fl. oz. can (1 pint)	4	4
	83634	1 gallon can	4	4
	83633	5 gallon pail	1	4
WOLO-HS™	967328	1 gallon can	4	Web*
	967327	5 gallon pail	1	Web*
	967326	55 gallon drum	1	Web*
WOLO-LV™	40029	1 gallon can	4	Web*
	40030	5 gallon pail	1	Web*
HMT™	83540	1 gallon can	4	9
	83539	5 gallon pail	1	9
	83538	55 gallon drum	1	9
WOLO HL™	1102837	1 gallon can	1	5
	1102839	5 gallon container	1	5
	1104253	55 gallon drum	1	5
	38439	9.7 oz. net wt. aerosol can	4	9
HMT-2™	38435	16 fl. oz. can (1 pint)	4	9
	38436	1 gallon can	1	9
	38437	5 gallon pail	1	9
	38438	55 gallon drum	1	9
B-15™	83493	16 fl. oz. can (1 pint)	4	12
	83496	1 gallon can	4	12
	83494	5 gallon pail	1	12
FMS™	38412	16 fl. oz. can (1 pint)	4	Web*
	38413	1 gallon can	4	Web*
	38414	5 gallon pail	1	Web*
	38415	55 gallon drum	1	Web*
FMS™-100	1102885	1 pint	12	
	1102884	1 gallon can	12	
	1102886	5 gallon container	12	
CMR™	40613	1 gallon can	4	13

SOLVENT-BASED, SEMI-PERMANENT PRODUCTS AND SEALERS

FREKOTE® BRAND PRODUCT	ITEM NUMBER	CONTAINER SIZE	PIECES PER CASE	PAGE	
SOLVENT-BASED, SACRIFICIAL PRODUCTS	AC-4368™	83490	9.2 oz. net wt. aerosol	12	11
		83486	16 fl. oz. can (1 pint)	4	11
		83489	1 gallon can	4	11
		83488	5 gallon pail	1	11
		83487	55 gallon drum	1	11
		83426	9.2 oz. net wt. aerosol	12	10
	1711™	83417	1 gallon can	4	10
		83416	5 gallon pail	1	10
		83415	55 gallon drum	1	10
	1711-1™	83511	9.5 oz. net wt. aerosol	12	3, 11
		83516	16 fl. oz. can (1 pint)	4	11
	EXITT™	83518	5 gallon pail	1	11
83517		55 gallon drum	1	11	
EXITT-1™	83551	9.5 oz. net wt. aerosol	12	11	
	83557	1 gallon can	4	11	
LIFFT™	83554	5 gallon pail	1	11	
	83553	55 gallon drum	1	11	
LIFFT-1™	83610	55 gallon drum	1	11	
	38410	16 fl. oz. can (1 pint)	4	4	
RIMLEASE 8™	38411	1 gallon pail	4	4	
	915WB™	40614†	1 liter can	10	12
CLEANERS	PMC™	83559	16 fl. oz. can (1 pint)	4	12
		83562	1 gallon can	4	12
		83561	5 gallon pail	1	12
		83560	55 gallon drum	1	12
		38172	1 gallon can	4	13
Aqualine® PUR-100™	38171	5 gallon pail	1	13	
	38170	55 gallon drum	1	13	
	83572	5 gallon pail	1	Web*	
Aqualine® R-100™	83571	55 gallon drum	1	Web*	
	83575	12.8 oz. net wt. aerosol	12	8	
Aqualine® R-110™	83580	1 gallon can	4	8	
	83579	5 gallon pail	1	8	
	83578	55 gallon drum	1	8	
Aqualine® R-120™	83586	12.8 oz. net wt. aerosol	12	9	
	83585	1 gallon can	4	9	
	83584	5 gallon pail	1	9	
Aqualine® R-150™	83583	55 gallon drum	1	9	
	83590	1 gallon can	4	8	
	83589	5 gallon pail	1	8	
Aqualine® R-180™	83588	55 gallon drum	1	8	
	36751	1 gallon can	4	8	
	36535	5 gallon pail	1	8	
Aqualine® R-220™	38229	55 gallon drum	1	8	
	41731	5 gallon pail	1	8, 9	
	41730	55 gallon drum	1	8, 9	
Aqualine® C-200™	83503	1 gallon can	4	3	
	83502	5 gallon pail	1	3	
Aqualine® C-210™	83505	5 gallon pail	1	Web*	
	83504	55 gallon drum	1	Web*	
	1102213	1 gallon container	1	3	
Aqualine® C-600™	1102214	5 gallon container	1	3	
	1102215	55 gallon drum	1	3	
	83606	1 gallon can	4	13	
Aqualine® RC-321™	83635	5 gallon pail	1	13	
	83604	55 gallon drum	1	13	
	36750	1 gallon can	4	6, 7	
Aqualine® Rotolease®	36749	5 gallon pail	1	6, 7	
	1301928	1 gallon can	1	12	
RS-100™	1301929	5 gallon pail	1	12	
	83514	5 gallon pail	1	10	
EXITT-EM™	83513	55 gallon drum	1	10	
	83412	5 gallon pail	1	10	
	83413	55 gallon drum	1	10	
1450™	37086	12.8 oz. net wt. aerosol	12	9, 10	
	36529	1 gallon can	4	9, 10	
	36530	5 gallon pail	1	9, 10	
	36534	55 gallon drum	1	9, 10	
S-50™	1289250	1 gallon container	1	13	
	1330931	5 gallon container	1	13	
	1330951	55 gallon container	1	13	
Rel-Eaze™	1276166	250 gallon tote	1	13	

* Visit www.frekote.com for more information on these products.



Frekote®

Notes

