

Product Information

MATERIALS APPLICATION GUIDE

FREKOTE® BRAND MOLD RELEASE AGENTS		44-NC™	55-NC™	700-NC™	770-NC™	800-NC™	810-NC™	C-200™	901WB™	FREWAX®	FRP-NC™	HMT™	HMT-2™	R-110™	R-120™	R-150™	R-180™	R-500™	S-50™	WOLO™	WOLO-HS™	SOLO®		
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																◆	○	○	◆					

○ Highly Recommended ◆ Recommended

TROUBLE SHOOTING GUIDE

Problem	Cause	Solution
Complete failure to obtain release	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
Poor release accompanied by small particles of molding material left on mold surface	Micro-porosity present in mold	Thoroughly clean mold and apply a Frekote® mold sealer; reapply Frekote® top coats
Poor release accompanied by white patches on parts	Insufficiently cleaned mold surface that prevents Frekote® from bonding properly, resulting in transfer to parts	Thoroughly clean mold and reapply Frekote®
Poor release accompanied by discolored blemishes on parts	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
Poor release in high-draft areas	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™
Inability to achieve multiple release	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
Good release but build-up of Frekote® on mold surface	Overapplication of Frekote®	Thoroughly clean mold and reduce amount of Frekote® applied
Good release but parts exhibit white blemishes	Excessive Frekote® applied to mold, resulting in transfer to parts	Thoroughly clean mold and reduce amount of Frekote® applied

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
	83434	1 gallon can	4	2
	83433	5 gallon pail	1	2
	83432	55 gallon drum	1	2
44-NC™ Wipes	987545	1 case (20 packs w/10 wipes/pack)	200	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™	38428	10.5 oz. net wt. aerosol	12	2, 5
	38424	16 fl. oz. can (1 pint)	4	2, 5
	38425	1 gallon can	4	2, 5
	38426	5 gallon pail	1	2, 5
	38427	55 gallon drum	1	2, 5
710-LV™	41345	1 gallon can	4	2
	41344	5 gallon pail	1	2
710-LV™ Wipes	1053401†	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, 7
	83465	16 fl. oz. can (1 pint)	4	2, 5, 7
	83468	1 gallon can	4	2, 5, 7
	83467	5 gallon pail	1	2, 5, 7
	83466	55 gallon drum	1	2, 5, 7
800-NC™	83474	10.7 oz. net wt. aerosol	12	8
	83473	1 gallon can	4	8
	83472	5 gallon pail	1	8
810-NC™	83479	10.3 oz. net wt. aerosol	12	8
815-NC™	83483	1 gallon can	4	8
	83482	5 gallon pail	1	8
	83481	55 gallon drum	1	8
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	5
	967327	5 gallon pail	1	5
	967326	55 gallon drum	1	5
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
HMT-2™	38439	9.7 oz. net wt. aerosol can	4	9
	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	3, 5, 7, 12
	83496	1 gallon can	4	3, 5, 7, 12
	83494	5 gallon pail	1	3, 5, 7, 12
FMS™	38412	16 fl. oz. can (1 pint)	4	3, 5, 12
	38413	1 gallon can	4	3, 5, 12
	38414	5 gallon pail	1	3, 5, 12
	38415	55 gallon drum	1	3, 5, 12

FREKOTE® BRAND PRODUCT	ITEM NUMBER	CONTAINER SIZE	PIECES PER CASE	PAGE
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
	1711™	83426	9.2 oz. net wt. aerosol	12
1711-I™	83417	1 gallon can	4	10
	83416	5 gallon pail	1	10
	83415	55 gallon drum	1	10
EXITT™	83511	9.5 oz. net wt. aerosol	12	3, 11
EXITT-I™	83516	16 fl. oz. can (1 pint)	4	11
	83517	5 gallon pail	1	11
	83518	55 gallon drum	1	11
LIFFT™	83551	9.5 oz. net wt. aerosol	12	11
LIFFT-I™	83557	1 gallon can	4	11
	83554	5 gallon pail	1	11
	83553	55 gallon drum	1	11
RIMLEASE 8™	83610	55 gallon drum	1	11
FREWAX®	38410	16 fl. oz. can (1 pint)	4	4, 13
	38411	1 gallon pail	4	4, 13
915WB™	40614†	1 liter can	10	12
PMC™	83559	16 fl. oz. can (1 pint)	4	3, 5, 7, 9, 12
	83562	1 gallon can	4	3, 5, 7, 9, 12
	83561	5 gallon pail	1	3, 5, 7, 9, 12
	83560	55 gallon drum	1	3, 5, 7, 9, 12
CMR™	40613	1 gallon can	4	12
PUR-100™ Aqualine®	38172	1 gallon can	4	13
	38171	5 gallon pail	1	13
	38170	55 gallon drum	1	13
R-100™ Aqualine®	83572	5 gallon pail	1	Web*
	83571	55 gallon drum	1	Web*
R-110™ Aqualine®	83575	12.8 oz. net wt. aerosol	12	Web*
	83580	1 gallon can	4	Web*
	83579	5 gallon pail	1	Web*
	83578	55 gallon drum	1	Web*
R-120™ Aqualine®	83586	12.8 oz. net wt. aerosol	12	9
	83585	1 gallon can	4	9
	83584	5 gallon pail	1	9
R-150™ Aqualine®	83583	55 gallon drum	1	9
	83590	1 gallon can	4	8
R-180™ Aqualine®	83589	5 gallon pail	1	8
	83588	55 gallon drum	1	8
R-220™ Aqualine®	36751	1 gallon can	4	8
	36535	5 gallon pail	1	8
	38229	55 gallon drum	1	8
C-200™ Aqualine®	41731	5 gallon pail	1	8, 9
	41730	55 gallon drum	1	8, 9
C-210™ Aqualine®	83503	1 gallon can	4	3, 6, 7
	83502	5 gallon pail	1	3, 6, 7
R-550™ Aqualine®	83505	5 gallon pail	1	Web*
	83504	55 gallon drum	1	Web*
	83601	5 gallon pail	1	Web*
RC-321™ Aqualine®	83606	1 gallon can	4	13
	83635	5 gallon pail	1	13
	83604	55 gallon drum	1	13
Rotolease® Aqualine®	36750	1 gallon can	4	13
	36749	5 gallon pail	1	13
901WB™	966681	55 gallon drum	1	3, 6, 7
EXITT-EM™	83514	5 gallon pail	1	10
	83513	55 gallon drum	1	10
1450™	83412	5 gallon pail	1	10
	83413	55 gallon drum	1	10
S-50™	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

† Available in 3rd quarter of 2007.

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

Some products/pack sizes may not be available in stock and may have a lead time. Please consult your Henkel application engineer for more information.

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