

Frekote® Release Agents for

# Rotational Molding

## YOUR APPLICATION

### SUBSTRATE

### PRODUCT TYPE

### APPLICATION METHOD

### FREKOTE® BRAND SEALER\*

### FREKOTE® BRAND SOLUTION

### Polyamide (PA / Nylon)

### Polyethylene (PE)

### Water Based

### Solvent Based

### Water Based

### Low Temperature Application

### High Temperature Application

### Low Temperature Application

### High Temperature Application

### B-15™

### 901WB™

### C-200™ Aqualine®

### 55-NC™

### 901WB™

### C-200™ Aqualine®

<b>Description:</b>	Release Agent	Release Agent	Release Agent	Release Agent	Release Agent
<b>Appearance:</b>	White emulsion	White emulsion	Clear liquid	White emulsion	White emulsion
<b>Application Temperature:</b>	68°F to 95°F (20°C to 35°C)	68°F to 400°F (20°C to 205°C)	59°F to 140°F (15°C to 60°C)	68°F to 95°F (20°C to 35°C)	68°F to 400°F (20°C to 205°C)
<b>Cure Time Between Coats at 70°F (21°C):</b>	15 minutes	10 minutes	5 minutes	15 minutes	10 minutes
<b>Final Cure Time at RT‡:</b>	3 hours	40 minutes @ 60°C (140°F) 20 minutes @ 100°C 15 minutes @ 120°C	30 minutes	3 hours	40 minutes @ 60°C (140°F) 20 minutes @ 100°C 15 minutes @ 120°C
<b>Final Cure Time at 100°C:</b>	10 minutes	20 minutes	5 minutes	10 minutes	20 minutes
<b>Thermal Stability:</b>	up to 536°F (280°C)	up to 599°F (315°C)	up to 752°F (400°C)	up to 536°F (280°C)	up to 599°F (315°C)

## PRODUCT DESCRIPTION

### Frekote® 901WB™

- Water based
- RT cure
- Multiple releases

Frekote® 901WB™ is a spray-on, water based emulsion developed for releasing high performance composite structures commonly found in the aerospace industry. It is cured at room temperature, allowing multiple releases and extremely low VOC content. This product, once cured, can be autoclaved at either 250°C or 350°F (121°C or 177°C). Apply a minimum of 4 thin box coats to a clean mold surface by spraying with a dry air source.

### Frekote® C-200™ Aqualine®

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

Frekote® C-200™ Aqualine® 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® 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 RT and can be shortened by heating the mold for 5 minutes at 212°F to 302°F (100°C to 150°C).

### Frekote® 901WB™

- Water based
- RT cure
- Multiple releases

Frekote® 901WB™ is a spray-on, water based emulsion developed for releasing high performance composite structures commonly found in the aerospace industry. It is cured at room temperature, allowing multiple releases and extremely low VOC content. This product, once cured, can be autoclaved at either 250°F or 350°F (121°C or 177°C). Apply a minimum of 4 thin box coats to a clean mold surface by spraying with a dry air source.

### Frekote® C-200™ Aqualine®

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

Frekote® C-200™ Aqualine® 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).



Polypropylene (PP)			
Solvent Based	Water Based		Solvent Based
	Low Temperature Applications	High Temperature Applications	
<b>B-15™</b>			<b>B-15™</b>
<b>770-NC™</b>	<b>901WB™</b>	<b>C-200™ Aqualine®</b>	<b>770-NC™</b>
Release Agent	Release Agent	Release Agent	Release Agent
Clear liquid	White emulsion	White emulsion	Clear liquid
59°F to 140°F (15°C to 60°C)	68°F to 95°F (20°C to 35°C)	68°F to 400°F (20°C to 205°C)	59°F to 140°F (15°C to 60°C)
5 to 10 minutes	15 minutes	10 minutes	5 to 10 minutes
5 to 10 minutes	3 hours	40 minutes @ 60°C (140°F) 20 minutes @ 100°C 15 minutes @ 120°C	5 minutes
N/A*	10 minutes	20 minutes	N/A*
up to 752°F (400°C)	up to 536°F (280°C)	up to 599°F (315°C)	up to 752°F (400°C)

**Helpful Hints**

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

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

*Refer to page 12 for more info.*

**Frekote® 770-NC™**

- Fast RT 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 RT 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® 901WB™**

- Water based
- RT cure
- Multiple releases

Frekote® 901WB™ is a spray-on, water based emulsion developed for releasing high performance composite structures commonly found in the aerospace industry. It is cured at room temperature, allowing multiple releases and extremely low VOC content. This product, once cured, can be autoclaved at either 250°F or 350°F (121°C or 177°C). Apply a minimum of 4 thin box coats to a clean mold surface by spraying with a dry air source.

**Frekote® C-200™ Aqualine®**

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

Frekote® C-200™ Aqualine® 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® 770-NC™**

- Fast RT 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 RT 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.

