

Rotational Molding

YOUR APPLICATION

SUBSTRATE

PRODUCT TYPE

APPLICATION METHOD

FREKOTE® BRAND SEALER*

FRFK	OTE® I	RRAN	n sai	IITION

Description:
Appearance:
Application
Temperature:
Cure Time Between
Coats at 70°F (21°C):
Final Cure Time at RT [‡] :

Final Cure Time

Thermal Stability:

at 100°C:

6

PRODUCT DESCRIPTION

Polyamide (PA / Nylon) Water Based Solvent Based Low Temperature **High Temperature** Application Application C-200™ 901WB™

B-15™ 55-NC™ Aqualine® Release Agent Release Agent

Clear liquid

59°F to 140°F

(15°C to 60°C)

5 minutes

30 minutes

5 minutes

up to 752°F (400°C)

Release Agent White emulsion 68°F to 95°F (20°C to 35°C) 15 minutes

Low Temperature

Application

901WB™

10 minutes 40 minutes @ 60°C (140°F) 20 minutes @ 100°C 15 minutes @ 120°C

High Temperature

Application

C-200"

Aqualine®

Release Agent

White emulsion

68°F to 400°F

(20°C to 205°C)

Polyethylene (PE)

Water Based

up to 536°F (280°C)

10 minutes

3 hours

up to 599°F (315°C)

20 minutes

Frekote® 901WB™

Release Agent

White emulsion

68°F to 95°F

(20°C to 35°C)

15 minutes

3 hours

10 minutes

up to 536°F (280°C)

- 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

White emulsion

68°F to 400°F

(20°C to 205°C)

10 minutes

40 minutes @ 60°C (140°F)

20 minutes @ 100°C

15 minutes @ 120°C

20 minutes

up to 599°F (315°C)

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"

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- 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.

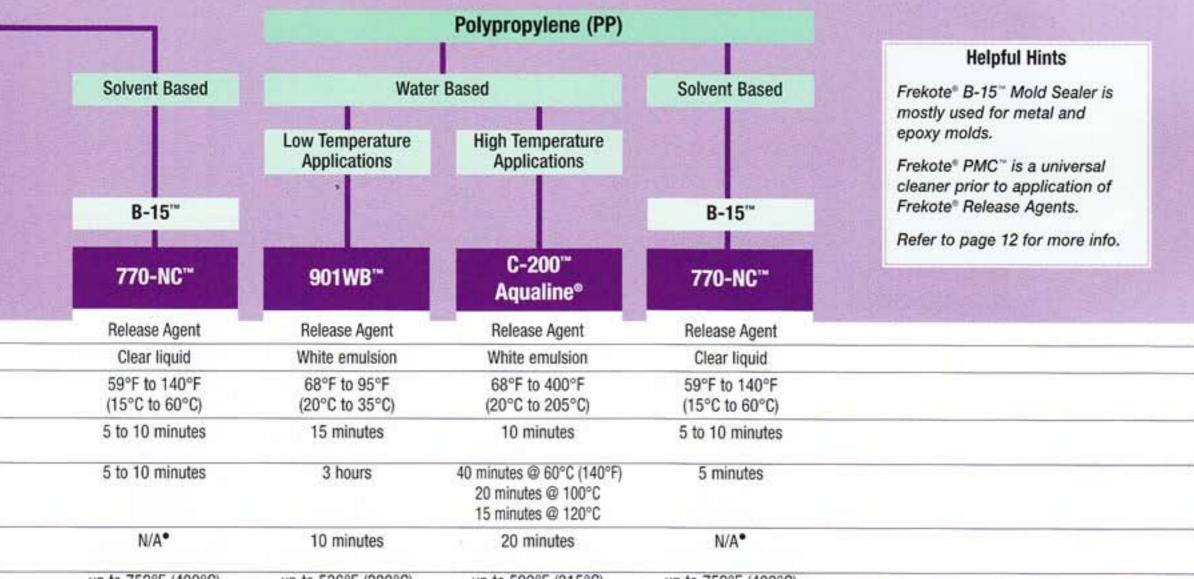
Frekote® C-200" Aqualine®

- 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).

^{*} Refer to page 12 for more information on Sealers and Cleaners.





up to 752°F (400°C)

up to 536°F (280°C)

up to 599°F (315°C)

up to 752°F (400°C)

Frekote® 770-NC™

- Fast RT cure
- High gloss and high slip
 Polesses meet polymers
- Releases most polymers

Frekote® 770-NCT 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®

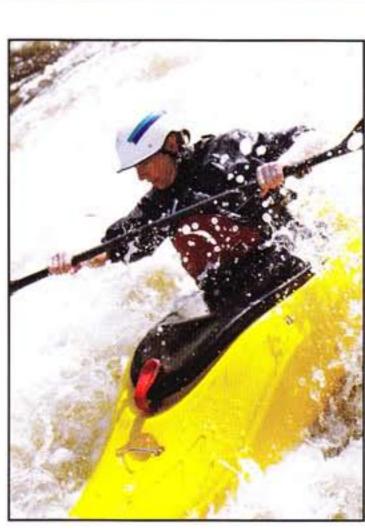
- Water based
- · No mold build-up
- · No contaminating transfer

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).

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