

Frekote®

# Sealers & Cleaners, and Specialty Products

YOUR APPLICATION	Sealers and Cleaners				
PRODUCT TYPE	Sealers		Cleaners		Cleaner Mold Release
SUBSTRATE	Metal Molds	Polyester and Fiberglass Molds	Polyester, Epoxy, and Metal Molds	Polyester, Epoxy, and Composite Molds	Polyester, Epoxy, and Metal Molds
APPLICATION REQUIREMENT	Solvent Based	Solvent Based	Solvent Based	Water Based	Solvent Based
FREKOTE® BRAND SOLUTION	B-15™	FMS™	PMC™	915WB™	CMR™

<b>Description:</b>	Mold Sealer	Mold Sealer	Mold Cleaner	Mold Cleaner	Cleaner / Mold Release
<b>Appearance:</b>	Clear liquid	Clear liquid	Clear liquid	Beige, pasty liquid	Clear liquid
<b>Application Temperature:</b>	59°F to 140°F (15°C to 60°C)	59°F to 95°F (15°C to 35°C)	68°F to 86°F (20°C to 30°C)	68°F to 104°F (20°C to 40°C)	55°F to 105°F (13°C to 41°C)
<b>Cure Time Between Coats at 70°F (21°C):</b>	30 minutes	15 minutes	N/A*	N/A*	N/A*
<b>Final Cure Time at 70°F (21°C):</b>	24 hours [60 min. at 212°F (100°C)]	15 to 20 minutes	N/A*	N/A*	15 minutes
<b>Thermal Stability:</b>	up to 750°F (400°C)	up to 750°F (400°C)	N/A*	N/A*	up to 750°F (400°C)

## 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 RT.

### Frekote® FMS™

- Easy to apply
- Fast cure
- Seals mold porosity

Frekote® FMS™ Mold Sealer for fiberglass reinforced polyester, epoxy and other resin-type molds. Use to seal new molds and older molds with micro-porosity and light surface blemishes. An excellent base coat, enhancing the release advantages of all Frekote® products. Apply at RT by wiping on with a clean, dry, lint-free cotton cloth. Wipe on a smooth, wet film; wait 15 to 20 seconds, then gently wipe dry. Apply 1 to 3 coats, allowing 15 to 20 minutes between coats and after the final coat.

### 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).

### 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.





## Specialty Products

### Semi-Permanent Release

Rotomolding	FRP	Organic Rubber	Highly Filled Polymer	Cast Urethane	Polyurethane
Water Based	Solvent Based	Water Based	Solvent Based	Solvent Based	Water Based
<b>Rotolease® Aqualine®</b>	<b>Frewax®</b>	<b>RC-321™</b>	<b>EFR™</b>	<b>CUR™</b>	<b>PUR-100™</b>
Release Agent	Release Agent	Release Agent	Release Agent	Cleaner / Mold Release	Release Agent
White emulsion	Milky, white suspension	White emulsion	Clear liquid	Clear liquid	Milky, white emulsion
140°F to 399°F (60°C to 204°C)	59°F to 95°F (15°C to 35°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)
10 minutes	5 to 10 minutes (allow to haze dry)	Liquid Evaporation	5 minutes	5 minutes	Liquid Evaporation [Instant at 302°F (150°C)]
5 min. at 302°F (150°C) 15 min. 248°F (120°C) 35 min. at 149°F (65°C)	5 to 10 minutes (allow to haze dry)	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 (150°C) 10 min. 212°F (100°C) 30 min. at 140°F (60°C)
up to 750°F (400°C)	up to 500°F (260°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® Rotolease® Aqualine®

- No mold build-up
- High thermal stability

Frekote® Rotolease® Aqualine® 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® 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® 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.

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