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Product Description Sheet

FREKOTE® FRP-NC® Mold Release Agent

Industrial Products, October 2003

Description

Loctite® Frekote® FRP-NC® is a unique release interface specifically formulated for reinforced polyester gel coats (and other associated resin systems). This semi-permanent release coating chemically bonds to the mold surface, forming a micro thin release film. Frekote FRP-NC provides a high gloss finish and minimal mold build-up thus eliminating buffing and cleaning between applications. Multiple releases per application will also lead to significant reductions in mold prep time.

Features

Minimal mold build-up
Multiple releases per application
High gloss finish
Maximum mold utilization
Reduced mold maintenance
Fast cure

Properties

Appearance	Clear liquid
Odor	Hydrocarbon
Solvents	Aliphatic Hydrocarbon, Dibutyl Ether
Specific Gravity	0.770 +/- 0.010
Shelf Life	One year from date of manufacture
Special Cautions	Moisture sensitive, keep container closed when not in use.
Application Temp	13°C - 40°C (55°F - 105°F)
Thermal Stability	400°C (750°F)

Mold Preparation

To work effectively, Frekote Release products must be applied to thoroughly cleaned and dried mold surfaces. All traces of waxes, sealers, rubbing compounds or other release agents must be completely removed. Remove any contaminants with Frekote PMC or suitable cleaning solvents. Light industrial abrasives can be used to remove heavy resin build-up.

Mold Sealing

New Molds: Full curing of new molds is advisable to ensure the best bonding of the Frekote to the mold surface. New fiberglass and epoxy molds should be cured per manufacturer's instructions before starting full-scale production.

Green molds and recently repaired areas must be sealed with Frekote FMS prior to using Frekote releasing interfaces. Porous and damaged mold surfaces should also be sealed with FMS. Consult FMS Technical Data Sheet for specific application instructions.

Application *Consult MSDS Prior To Use.*

1. Apply with a clean lint free 100% cotton cloth. Soak cloth with FRP-NC until it is wet, but not dripping.
2. Wipe a smooth, wet film over a 2' x 2' to 2' x 3' area of the mold surface. Do not over apply.
3. Wait 10-20 seconds at 21°C (70°F) after application. Gently wipe dry with, a second clean dry, cotton cloth.

Note: Changes in temperature will affect solvent dry time. At temperatures below 18°C (65°F), waiting time between wiping on and drying off can be slightly longer than 20 seconds. At higher than normal temperatures (greater than 35°C or 95°F) the wait time is significantly reduced and can be as quick as 1-2 seconds. In these conditions it is also advisable to reduce your wipe area to 1' x 1' in order to eliminate streaking due to the increased solvent evaporation and polymer cure times. A general guideline is to wait until the edges of the wiped area begins to creep inwards indicating that evaporation has just begun. Wipe from the outside and slowly work your way towards the center. Light hand pressure is all that is needed. No hard rubbing is required. Change cloth frequently to ensure proper drying of the mold.

4. Coat entire mold surface in this manner slightly over-lapping the last area coated. Apply a maximum of 6 coats initially. A couple of extra coats can be applied in high wear areas for added slip. Allow 15-20 minutes cure time at room temperature between coats and after the final coat.
5. Commence molding. A single coat of FRP-NC should be applied after each release for the first two to three releases. This helps to condition the mold, which in turn offers multiple releases on future production.

Mold Touch up

Abrasion will gradually cause wear and parts will begin to adhere to the mold surface if a continuous release film is not maintained. If release becomes difficult, simply touch-up the area affected. Only one coat is usually required for touch-up.

Flammability/Storage

Frekote FRP-NC contains flammable solvents. The product should always be used in well-ventilated areas. Store in a cool, dry place. Consult MSDS for complete details.

Note

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more, United States, or foreign patents or patent applications.

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PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.
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