Technical Data Sheet

LOCTITE® Frekote® FMS-100™

March 2008

PRODUCT DESCRIPTION

LOCTITE® Frekote® FMS-100™ provides the following product characteristics:

Technology	Mold Release
Appearance	Clear, colorless[LMS]
Chemical Type	Solvent Based Polymer
Odor	Solvent
Cure	Room temperature cure
Cured Thermal Stability	≤400 °C
Application	Mold Sealer
Application Temperature	13 to 41 °C
Specific Benefit	• High gloss finish • Easy application • Fast curing • Eliminates Porosity/Microporosity • Seals "green" molds and repaired areas

LOCTITE® Frekote® FMS-100™ is a solvent-based sealer specifically formulated for use on FRP, epoxy, or other composite mold surfaces. LOCTITE® Frekote® FMS-100™ must be used when using green, or new, molds with microporosity and other slight surface imperfections.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	0.733 to 0.753[LMS]
Flash Point - See SDS	

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Mold Preparation

Cleaning:

Mold surfaces must be thoroughly cleaned and dried. All traces of prior release must be removed. This may be accomplished by using Loctite® Frekote® PMC or other suitable cleaner. Loctite® Frekote® 915WB™ or light abrasives can be used for heavy build-up.

Directions for use:

1. Apply LOCTITE® Frekote® FMS-100™ with a clean, lint free, cotton wiping cloth. Wet the cloth with LOCTITE® Frekote® FMS-100™ until it is damp but not dripping.
2. Wipe a smooth, wet film over the entire mold surface. For larger molds, apply LOCTITE® Frekote® FMS-100™ to the surface one section at a time starting at one end and working towards the other. Using a clean cloth, wipe off the area that was just treated to obtain a smooth thin wet layer.
3. Allow a minimum of 15 minutes before applying next coat. New molds require 1 to 2 coats of sealer.
4. **NOTE:** If the cloth dries out during your coating process, use a fresh clean cloth to apply the next coat. This prevents resin accumulation on the cloth from being deposited on the mold surface. If streaking occurs, replace the cloth with a clean dry one and/or make sure that the cloth is just damp and not soaking wet. Avoid over-application, as this will cause streaking on the tooling surface. Streaks or wipe lines can be removed easily by wiping the mold surface lightly with a dry cloth. Product is moisture sensitive, keep container tightly closed when not in use.
5. Allow the final coat to cure for 20 minutes at 20°C.

Loctite Material Specification[LMS]

LMS dated September 18, 2007. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

The product is classified as flammable and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties. Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representive.

Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Note:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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