Product Description Sheet

LOCTITE® FREKOTE FRP-NC

Known as
Frekote® FRP-NC
September 2015

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. Loctite® Frekote® FRP-NC provides a high gloss finish and minimal mold build-up thus eliminating buffing and cleaning between applications. Multiple releases per application also contributes to major time savings.

Features

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

Properties

Appearance	Clear liquid
Odor	Hydrocarbon
Solvents	Aliphatic Hydrocarbon, Dibutyl Ether
Specific Gravity	0.770 +/- 0.010
Flash Point	28°C (82°F) Tag Closed Cup.
Shelf Life	One year from date of manufacture
Special Cautions	Moisture sensitive, keep container tightly closed when not in use.
Application Temp	13ºC - 40ºC (55°F - 105°F)
Thermal Stability	400ºC (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, PMC Plus or suitable cleaning solvent. 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 Loctite® Frekote® 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 21ºC (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 18ºC (65°F), waiting time between wiping on and drying off will be longer than 20 seconds. A general guideline is to wait until the edges of the wiped area begin to creep inwards indicating that evaporation has progressed sufficiently. 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 Loctite® Frekote® 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. Use either Loctite® Frekote® FRP-RS or Loctite® Frekote® FRP-NC for touch-ups.

Flammability/Storage

Loctite® 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

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