

LOCTITE[®] FREKOTE RS-100[™]

Known as Aqualine[®] RS-100[™]
January 2015

PRODUCT DESCRIPTION

LOCTITE[®] FREKOTE RS-100[™] provides the following product characteristics:

Technology	Mold Sealer
Appearance	Clear, colorless ^{LMS}
Chemical Type	Water based emulsion
Odor	Mild
Cure	Heat Cure
Cured Thermal Stability	≤370 °C
Application	Mold Sealer
Application Temperature	90 to 200 °C
Specific Benefit	<ul style="list-style-type: none"> ● Freeze/Thaw stable ● Non-flammable ● Easy release ● Multiple releases ● Increase longevity of release coating ● Compatible with Steel, Stainless steel and Chrome

LOCTITE[®] FREKOTE RS-100[™] mold sealer is a proprietary, water based solution developed for sealing metal plated mold surfaces while increasing the ability to release various rubber materials including natural and synthetic rubber, HNBR, EPDM, and other rubber molding compounds.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 20 °C 0.98 to 1.02^{LMS}
Flash Point - See SDS

GENERAL INFORMATION

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 Frekote[®] PMC or other suitable cleaner. Frekote[®] 915WB[™] or light abrasives can be used for heavy build-up.

Directions for use:

1. Apply LOCTITE[®] FREKOTE RS-100[™] using a fine spray gun. Applicator should be set to a finely atomized spray pattern.
2. The flowrate of the material should be set between 1 to 1.5ml per second when the mold temperature is between 90 to 150°C and 1.5 to 2ml per second when the mold temperature is between 150 to 200°C.
3. The spray gun should pass across the mold surface at a distance of 20 to 30 cm traveling at about 30 cm/sec.
4. Four coats should be applied regardless of mold temperature. Each coat can be applied perpendicular to the previous coat as soon as the mold surface is dry.
5. Allow last coat to cure fully. 5 minutes at 200°C, 10 minutes at 160°C or 30 minutes at 90°C.

Loctite Material Specification^{LMS}

LMS dated January 27, 2009. 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

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

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 Corporation 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 Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

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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