**The Frekote® Line of Products is the Broadest Mold Release Line** – Frekote® mold release agents, backed by over 40 years of research and development, are the global industry standard for performance, quality, and value. By pioneering release solutions for many of the world’s largest manufacturing organizations, Henkel understands what it takes to release the most complex materials in the most demanding applications. Henkel has developed Frekote® mold release agents for virtually all types of composite and rubber molding operations. The Frekote® line offers the broadest product range in the industry. From jumbo jets to tennis racquets, truck tires to o-rings, from custom yachts to bathtubs, we have the release agent you need for most composite and rubber materials.

**Lowest Cost per Release** – Frekote® semi-permanent release agents minimize fouling and ensure the highest number of releases possible per application. Our customers realize higher productivity and profitability through reduced downtimes, lower reject rates, and higher quality products. Frekote® products are the industry standard replacement for sacrificial release agents. Unlike sacrificial waxes or silicones, Frekote® semi-permanent mold release agents do not transfer to your parts; instead they chemically bond to the mold surface, allowing the parts to release cleanly with no mold release transfer.

Frekote® products are designed to save you money. As an example, the following table represents how polyester molders minimize their molding cost with Frekote® semi-permanent mold release technology:

<table>
<thead>
<tr>
<th>RELEASE PRODUCTS</th>
<th>TRADITIONAL</th>
<th>FREKOTE® BRAND</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>PASTE WAX</td>
<td>FRP-NC™</td>
</tr>
<tr>
<td>Labor time (hours)</td>
<td>10 to 15</td>
<td>6 to 7</td>
</tr>
<tr>
<td>Labor cost</td>
<td>$100 to $150</td>
<td>$60 to $70</td>
</tr>
<tr>
<td>Material cost</td>
<td>$25</td>
<td>$95</td>
</tr>
<tr>
<td>Number of releases</td>
<td>5</td>
<td>20</td>
</tr>
<tr>
<td>Direct cost</td>
<td>$25 to $35</td>
<td>$7.75 to $8.25</td>
</tr>
</tbody>
</table>

Values cited above represent approximated values as of July 2007.

**World Standard Products for Release Application** – Henkel has found “partnering” with customers is a highly effective way of finding solutions to tough molding and application problems. Customers around the globe turn to Frekote® products not just for our unique mold releases, but also for our expertise in developing “customized” solutions. We take pride in our knowledge, experience, and responsiveness in providing the best technical service to our customers around the globe.
This comprehensive guide is designed to make it easy for you to select the right Frekote® mold release agent for a variety of markets and applications. Simply select a suitable release agent for demolding specific substrates and compare the characteristics of different products using the technical data. Choose the compatible dispensing equipment for your application and see the product list for ordering information. For additional assistance, visit www.frekote.com, or call 1-800-562-8483 in the U.S. or 1-800-263-5043 in Canada.

New Frekote® Wipes

Several Frekote® mold release agents are now available in easy-to-use, pre-packaged wipes, including Frekote® 44-NC™, 55-NC™ and 710-LV™. See page 15 for ordering information.
# Frekote® Release Agents for Advanced Composite Systems

## Your Application

### Product Type

**Application**
- Compression Molding / Casting / Vacuum Bagging

**Finish**
- Matte Finish
- Satin Finish
- Gloss Finish

**Frekote® Brand Sealer**
- B-15™
- 44-NC™
- 55-NC™
- 700-NC™
- 770-NC™
- 710-LV™

**Frekote® Brand Solution**
- B-15™
- B-15™ or FMS-100™
- B-15™ or FMS-100™

---

### Description

<table>
<thead>
<tr>
<th>Product</th>
<th>Release Agent</th>
<th>Appearance</th>
<th>Application Temperature</th>
<th>Cure Time Between Coats at 70°F (21°C):</th>
<th>Final Cure Time at 70°F (21°C):</th>
<th>Final Cure Time at 212°F (100°C):</th>
<th>Thermal Stability</th>
</tr>
</thead>
<tbody>
<tr>
<td>44-NC™</td>
<td>Clear liquid</td>
<td>59°F to 140°F (15°C to 60°C)</td>
<td>10 to 15 minutes</td>
<td>3 hours</td>
<td>15 minutes</td>
<td>up to 752°F (400°C)</td>
<td></td>
</tr>
<tr>
<td>55-NC™</td>
<td>Clear liquid</td>
<td>59°F to 140°F (15°C to 60°C)</td>
<td>5 minutes</td>
<td>30 minutes</td>
<td>5 minutes</td>
<td>up to 752°F (400°C)</td>
<td></td>
</tr>
<tr>
<td>700-NC™</td>
<td>Clear liquid</td>
<td>59°F to 275°F (15°C to 135°C)</td>
<td>5 minutes</td>
<td>15 to 20 minutes</td>
<td>5 minutes</td>
<td>up to 752°F (400°C)</td>
<td></td>
</tr>
<tr>
<td>770-NC™</td>
<td>Clear liquid</td>
<td>59°F to 140°F (15°C to 60°C)</td>
<td>5 to 10 minutes</td>
<td>10 minutes</td>
<td>5 minutes</td>
<td>up to 752°F (400°C)</td>
<td></td>
</tr>
<tr>
<td>710-LV™</td>
<td>Clear liquid</td>
<td>59°F to 275°F (15°C to 135°C)</td>
<td>5 to 10 minutes</td>
<td>15 to 20 minutes</td>
<td>5 minutes</td>
<td>up to 750°F (399°C)</td>
<td></td>
</tr>
</tbody>
</table>

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### Frekote® 44-NC™
- No mold build-up
- No contaminating transfer
- High thermal stability

Frekote® 44-NC™ is a semi-permanent release polymer designed to provide a high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to molded parts. Apply to clean mold surfaces by wiping, brushing, or spraying a thin continuous wet film. Allow 5 minutes between coats to dry. Curing of the final coat takes 3 hours at room temperature and can be shortened by heating the mold for 15 minutes at 212°F to 302°F (100°C to 150°C). Also available in wipes.

### Frekote® 55-NC™
- Fast cure time
- No mold build-up
- Reduced odor

Frekote® 55-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 15 minutes between coats to dry. Curing of the final coat takes 30 minutes at room temperature and can be shortened by heating the mold for 5 minutes at 212°F to 302°F (100°C to 150°C). Also available in wipes.

### Frekote® 700-NC™
- Mild odor
- Slower room temperature cure
- High slip

Frekote® 700-NC™ is a versatile release agent that provides a high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to the molded parts. Apply to clean mold surfaces by spraying, brushing, or wiping with a clean, lint-free, cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.

### Frekote® 770-NC™
- Low odor
- Faster room temperature cure
- High slip

Frekote® 770-NC™ is a versatile release agent that provides a high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to molded parts. Apply to clean mold surfaces by spraying, brushing, or wiping with a clean, lint-free, cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.

### Frekote® 710-LV™
- Fast room temperature cure
- Reduced VOC
- High slip
- Gloss finish

Frekote® 710-LV™ is a reduced VOC, semi-permanent release agent formulated specifically for release of high performance composite materials. Frekote® 710-LV™ will release thermoset and prepreg epoxies, polyester resins, and thermoplastic compounds. It cures quickly at room temperature, giving a high gloss finish on molded parts. Frekote® 710-LV™ provides a non-contaminating transfer so that parts can be painted or bonded in other assemblies. Also available in wipes.

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* Refer to page 12 for more information on sealers and cleaners.  
• Not Applicable
Filament Winding

**Frekote® EXITT™**
- Sacrificial coating
- Silicone based
- High gloss finish

Frekote® EXITT™ provides a superior high gloss finish on molds. It is not recommended for use with parts that need to be painted, bonded, or stained. This product was developed for use with urethane elastomer systems but will also release urethane foams, organic rubber compounds, and most specialty molding resins. No mold build-up, precise retention of mold detail.

**Frekote® 720-NC™**
- Fast room temperature cure
- High slip
- Gloss finish

Frekote® 720-NC™ is a semi-permanent release agent formulated specifically for release of all cast polymer products and for releasing highly filled resins. It cures quickly at room temperature, giving a gloss finish on finished parts. This product is also suitable for certain abrasive closed molding processes, such as RTM and filament winding, and is also ideal for use on highly porous mold surfaces.

**Frekote® C-600™**
- Water-based
- Mold release agent with inherent sealer

Frekote® C-600™ is a semi-permanent mold release agent that is a proprietary water-based emulsion. It is developed for releasing large scale parts such as wind blades. It is also ideal for numerous other high performance composite structures.

**Frekote® Aqualine® C-200™**
- Water-based
- No mold build-up
- No contaminating transfer

Frekote® Aqualine® C-200™ is a water-based release agent which provides multiple release with no contaminating transfer. It gives no mold build-up and exhibits high thermal stability for all molding processes. Apply 4 coats to clean mold surfaces at a mold temperature ≥140°F (60°C). Allow each coat to dry before applying subsequent coats. Dry time may be decreased by using a fan or infrared lamp. Post cure the final film for at least 40 minutes at 140°F (60°C) or 20 minutes at 212°F (100°C).

**Frekote® EXITT™**
- Sacrificial coating
- Silicone based
- High gloss finish

Frekote® EXITT™ is mostly used for metal and composite molds.

**Frekote® B-15™ Mold Sealer** is recommended for composite molds.

**Frekote® FMS-100™ Mold Sealer** is recommended for composite molds.

**Frekote® RS-100™** is used with Aqualine® products.

**Frekote® PMC™** is a universal cleaner prior to application of Frekote® Release Agents.

Visit www.frekote.com
Did You Know?

Frekote® WOLO™ is also available as a low VOC formulation: Frekote® WOLO-LV™. Visit us on the web at www.frekote.com for more information.

**FREKOTE® BRAND SOLUTION**

<table>
<thead>
<tr>
<th>FREKOTE® BRAND</th>
<th>Description:</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Release Agent</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>BRAND SOLUTION</strong></td>
<td>Appearance:</td>
<td>Milky white liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
</tr>
<tr>
<td><strong>BRAND SOLUTION</strong></td>
<td>Application Temperature:</td>
<td>50°F to 95°F (15°C to 35°C)</td>
<td>50°F to 104°F (15°C to 40°C)</td>
<td>50°F to 113°F (15°C to 45°C)</td>
<td>50°F to 104°F (15°C to 40°C)</td>
<td>50°F to 104°F (15°C to 40°C)</td>
<td>50°F to 104°F (15°C to 40°C)</td>
</tr>
<tr>
<td><strong>BRAND SOLUTION</strong></td>
<td>Cure Time Between Coats at 70°F (21°C):</td>
<td>5 to 10 minutes (allow to haze dry)</td>
<td>5 minutes</td>
<td>N/A</td>
<td>15 minutes</td>
<td>5 minutes</td>
<td>5 minutes</td>
</tr>
<tr>
<td><strong>BRAND SOLUTION</strong></td>
<td>Final Cure Time at RT‡:</td>
<td>5 to 10 minutes</td>
<td>15 minutes</td>
<td>20 to 30 minutes</td>
<td>15 to 20 minutes</td>
<td>15 minutes</td>
<td>15 minutes</td>
</tr>
<tr>
<td><strong>BRAND SOLUTION</strong></td>
<td>Final Cure Time at 212°F (100°C):</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
</tr>
<tr>
<td><strong>BRAND SOLUTION</strong></td>
<td>Thermal Stability:</td>
<td>up to 536°F (280°C)</td>
<td>up to 752°F (400°C)</td>
<td>up to 752°F (400°C)</td>
<td>up to 752°F (400°C)</td>
<td>up to 752°F (400°C)</td>
<td>up to 752°F (400°C)</td>
</tr>
</tbody>
</table>

**PRODUCT DESCRIPTION**

- **Frekote® Firewax®**
  - Easy to use
  - Visible release agent
  - High gloss finish
  - Frekote® Firewax® 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® Firewax® well before and during use. Apply to clean mold surfaces with a clean, lint-free, cotton cloth. Allow Frekote® Firewax® 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® WOLO™**
  - Easy application
  - Multiple releases
  - High gloss finish
  - Frekote® WOLO™ is a unique polymer release agent that cures quickly and provides multiple release of all polyester resins. Application and use are simple – wipe it on and allow to evaporate to produce a high gloss finish. No polishing is needed. Apply Frekote® WOLO™ with a clean wiping cloth. Wipe a smooth, wet film over the mold surface. Continue to work the material into the mold by lightly wiping the wet film (10 to 30 seconds) until a thin and uniform coating is obtained and allow to evaporate.

- **Frekote® SOLO®**
  - High gloss finish
  - Minimal mold build-up
  - Fast curing
  - Easy application
  - Frekote® SOLO® is a unique polymer release agent designed for all gel-coat fiberglass reinforced and filled polyester composites. Application of this product is spray on/leave on using a light and uniform spray pattern to obtain a high gloss finish without polishing. Apply a minimum of 7 coats to a clean mold surface; typically 1 gallon of Frekote® SOLO® will cover 150 square feet of mold surface.

- **Frekote® FRP-NC™**
  - Minimal mold build-up
  - Maximum mold utilization
  - High gloss finish
  - Frekote® FRP-NC™ is a semi-permanent release interface specifically formulated for reinforced polyester gel-coats. It provides minimal mold build-up while eliminating buffing and cleaning between applications. Apply to clean mold surfaces with a clean cloth. Wipe on a smooth, wet film. Wait 10 to 20 seconds at room temperature after application. Gently wipe dry with a second dry, cotton cloth. Apply a maximum of 6 coats initially. Allow 15 to 20 minutes cure time between coats and after the final coat at room temperature.

- **Frekote® WOLO™**
  - See “Did You Know?”
  - Easy application
  - Multiple releases
  - High gloss finish
  - Frekote® WOLO™ is a unique, polymer release agent that cures quickly and provides multiple release of all polyester resins. Application and use are simple – wipe it on and allow to evaporate to produce a high gloss finish. No polishing is needed. Apply Frekote® WOLO™ with a clean wiping cloth. Wipe a smooth, wet film over the mold surface. Continue to work the material into the mold by lightly wiping the wet film (10 to 30 seconds) until a thin and uniform coating is obtained and allow to evaporate.

**YOUR APPLICATION**

- **PRODUCT TYPE**
  - Cast Polymer / Solid Surface
  - Solvent-based
  - Gel-Coat
  - Gloss Finish

- **SUBSTRATE**
  - Wipe on/Buff out
  - Wipe on/Leave on
  - Wipe on/Leave on
  - Wipe on/leave on
  - Gloss Finish

- **FINISH**
  - Wipe on/Leave On
  - Spray On/Leave On
  - Wipe On/Wipe Off
  - Wipe On/Leave On

- **APPLICATION**
  - FMS-100™
  - Wolo™
  - FrP-nC™
  - FMs-100™
  - solo®
  - Wolo™

- **Did You Know?**

- **Refer to page 12 for more information on Sealers and Cleaners.**

- **Not Applicable**

- **70°F (21°C)**
### Solvent-based

<table>
<thead>
<tr>
<th>Non Gel-Coat</th>
<th>B-15™</th>
<th>B-15™ or FMs-100™</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>High Gloss Finish</strong></td>
<td>Matte Finish</td>
<td>Matte Finish</td>
</tr>
<tr>
<td>Wipe On/Leave On</td>
<td>Wipe On/Wipe Off</td>
<td>Wipe On/Wipe Off</td>
</tr>
<tr>
<td>FMs-100™</td>
<td>B-15™</td>
<td>B-15™ or FMs-100™</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th><strong>Wolo-HL™</strong></th>
<th><strong>44-NC™</strong></th>
<th><strong>55-NC™</strong></th>
<th><strong>770-NC™</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td>Release Agent</td>
<td>Release Agent</td>
<td>Release Agent</td>
<td>Release Agent</td>
</tr>
<tr>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
</tr>
<tr>
<td>55°F to 106°F (15°C to 41°C)</td>
<td>59°F to 140°F (15°C to 60°C)</td>
<td>59°F to 140°F (15°C to 60°C)</td>
<td>59°F to 140°F (15°C to 60°C)</td>
</tr>
<tr>
<td>15 minutes</td>
<td>5 minutes</td>
<td>5 minutes</td>
<td>5 to 10 minutes</td>
</tr>
<tr>
<td>30 minutes</td>
<td>3 hours</td>
<td>30 minutes</td>
<td>3 hours</td>
</tr>
<tr>
<td>N/A*</td>
<td>15 minutes</td>
<td>5 minutes</td>
<td>N/A*</td>
</tr>
<tr>
<td>up to 752°F (400°C)</td>
<td>up to 752°F (400°C)</td>
<td>up to 752°F (400°C)</td>
<td>up to 752°F (400°C)</td>
</tr>
</tbody>
</table>

### Frekote® Wolo-HL™
- High Gloss
- Easy Application
- Multiple Releases
- Used for low VOC gelcoat

Frekote® Wolo-HL™ is a semi-permanent release agent for low VOC polyester gelcoat parts. Wolo-HL™ can be applied and cured at room temperature. No sealer is required. This product offers a reduction in mold release VOC’s by as much as 72%. Wolo-HL™ offers maximum slip and high release performance.

### Frekote® 44-NC™
- No mold build-up
- No contaminating transfer
- High thermal stability

Frekote® 44-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 15 minutes between coats to dry. Curing of the final coat takes 3 hours at room temperature and can be shortened by baking the mold for 15 minutes at 212°F to 302°F (100°C to 150°C). Also available in wipes.

### Frekote® 55-NC™
- Fast cure time
- No mold build-up
- Reduced odor

Frekote® 55-NC™ is a semi-permanent release polymer designed to provide multiple release for most molding processes with no contaminating transfer. Apply 3 to 6 coats to clean mold surfaces by wiping, brushing or spraying a thin continuous wet film. Allow 5 minutes between coats to dry. Curing of the final coat takes 30 minutes at room temperature and can be shortened by heating the mold for 5 minutes at 212°F to 302°F (100°C to 150°C). Also available in wipes.

### Frekote® 770-NC™
- Fast room temperature cure
- High gloss and high slip
- Releases most polymers

Frekote® 770-NC™ is a versatile, semi-permanent release agent which provides high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to the molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.

### Helpful Hints

- Frekote® B-15™ Mold Sealer is mostly used for metal and epoxy molds.
- Frekote® FMS-100™ Mold Sealer is recommended for composite molds.
- Frekote® RS-100™ is used with Aqualine® products.
- Frekote® PMC™ is a universal cleaner prior to application of Frekote® Release Agents.

Refer to page 12 for more info.

Visit www.frekote.com
Frekote® Release Agents for

Rotational / Plastic Molding

<table>
<thead>
<tr>
<th>Your Application</th>
<th>Substrate</th>
<th>Product Type</th>
<th>Application</th>
<th>Frekote® Brand Sealer*</th>
<th>Frekote® Brand Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>YOUR APPLICATION</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Product Type</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Polyamide (PA / Nylon)</td>
<td>Water-based</td>
<td>High Temperature</td>
<td>RS-100™</td>
<td>Aqualine® Rotolease®*</td>
<td>Description: Release Agent Appearance: White emulsion Application Temperature: 140°F to 399°F (60°C to 204°C) Cure Time Between Coats at 70°F (21°C): 10 minutes Final Cure Time at Room Temperature*: 5 minutes @ 302°F (150°C) 15 minutes @ 248°F (120°F) 35 minutes @ 149°F (65°F) Final Cure Time at 212°F (100°C): up to 750°F (400°C) Thermal Stability: up to 750°F (400°C)</td>
</tr>
<tr>
<td>Polyethylene (PE)</td>
<td>Solvent-based</td>
<td>Low Temperature</td>
<td>B-15™</td>
<td>55-NC**</td>
<td>Description: Release Agent Appearance: Clear liquid Application Temperature: 59°F to 140°F (15°C to 60°C) Cure Time Between Coats at 70°F (21°C): 5 minutes Final Cure Time at Room Temperature*: 30 minutes Final Cure Time at 212°F (100°C): up to 752°F (400°C) Thermal Stability: up to 752°F (400°C)</td>
</tr>
</tbody>
</table>

**Product Description**

Frekote® Aqualine® Rotolease®*
- No mold build-up
- High thermal stability

Frekote® 55-NC**
- Fast cure time
- No mold build-up
- Reduced odor

Frekote® Aqualine® Rotolease®*
- No mold build-up
- High thermal stability

Frekote® 770-NC™
- Fast room temperature cure
- High gloss and high slip
- Releases most polymers

Frekote® 770-NC™ is a versatile, semi-permanent release agent which provides high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free cotton cloth. Touch-up as necessary.
**Frekote® 770-NC™**
- Fast room temperature cure
- High gloss and high slip
- Releases most polymers

Frekote® 770-NC™ is a versatile, semi-permanent release agent which provides high slip where mold geometry problems are encountered. It cures rapidly at room temperature to give a high gloss finish to molded parts. Apply to clean mold surfaces by spraying, brushing or wiping with a clean, lint-free cotton cloth. Apply up to 4 coats, allowing 5 to 10 minutes between coats. Touch-up as necessary.

---

### Polypropylene (PP)

<table>
<thead>
<tr>
<th></th>
<th>Water-based</th>
<th>Solvent-based</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>High Temperature</td>
<td>Low Temperature</td>
</tr>
<tr>
<td>RS-100™</td>
<td>B-15™</td>
<td></td>
</tr>
</tbody>
</table>

### Freekote® Aqualine®
- No mold build-up
- High thermal stability

Frekote® Aqualine® Rotolease® 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® RS-100™
- Recommended for rotational molding applications.

### Helpful Hints
- Frekote® B-15™ Mold Sealer is mostly used for metal and epoxy molds.
- Frekote® RS-100™ is used with Aqualine® products.
- Frekote® PMC™ is a universal cleaner prior to application of Frekote® Release Agents.

Refer to page 12 for more info. **Rotolease® is recommended for rotational molding applications.**

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**Visit www.frekote.com**
## Frekote® Release Agents for Rubber Industry

### Direct Mold Release Agents

<table>
<thead>
<tr>
<th><strong>Product Type</strong></th>
<th><strong>Description</strong></th>
<th><strong>Appearance</strong></th>
<th><strong>Application Temperature</strong></th>
<th><strong>Final Cure Time at 140°F (60°C)</strong></th>
<th><strong>Final Cure Time at 302°F (150°C)</strong></th>
<th><strong>Thermal Stability</strong></th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Solvent-based</strong></td>
<td><strong>General Rubber Goods</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>RS-100™</strong></td>
<td>Release Agent</td>
<td>Clear liquid</td>
<td>68°F to 275°F (20°C to 135°C)</td>
<td>15 minutes</td>
<td>N/A**</td>
<td>up to 752°F (400°C)</td>
</tr>
<tr>
<td><strong>Aqualine® R-110™</strong></td>
<td>Release Agent</td>
<td>White emulsion</td>
<td>140°F to 401°F (60°C to 205°C)</td>
<td>30 minutes</td>
<td>4 minutes</td>
<td>up to 599°F (315°C)</td>
</tr>
<tr>
<td><strong>Aqualine® R-150™ or Aqualine® R-180™</strong></td>
<td>Release Agent</td>
<td>White emulsion</td>
<td>140°F to 401°F (60°C to 205°C)</td>
<td>30 minutes</td>
<td>4 minutes</td>
<td>up to 599°F (315°C)</td>
</tr>
<tr>
<td><strong>Water-based</strong></td>
<td><strong>Technical Rubber (i.e. Neoprene, Nitrile)</strong></td>
<td></td>
<td></td>
<td></td>
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<td></td>
</tr>
<tr>
<td><strong>RS-100™</strong></td>
<td>Release Agent</td>
<td>White emulsion</td>
<td>140°F to 401°F (60°C to 205°C)</td>
<td>30 minutes</td>
<td>4 minutes</td>
<td>up to 599°F (315°C)</td>
</tr>
<tr>
<td><strong>Aqualine® R-220™</strong></td>
<td>Release Agent</td>
<td>White emulsion</td>
<td>140°F to 401°F (60°C to 205°C)</td>
<td>30 minutes</td>
<td>4 minutes</td>
<td>up to 599°F (315°C)</td>
</tr>
<tr>
<td><strong>Aqualine® R-180™</strong></td>
<td>Release Agent</td>
<td>White emulsion</td>
<td>140°F to 401°F (60°C to 205°C)</td>
<td>30 minutes</td>
<td>4 minutes</td>
<td>up to 752°F (400°C)</td>
</tr>
</tbody>
</table>

### Technical Rubber

- **Frekote® 800-NC™**
  - No chlorinated solvents
  - Maximum mold usage
  - Reduced reject rates
  - Frekote® 800-NC™ is a semi-permanent release interface for molding rubber compounds. The multiple release, non-migratory system bonds to the mold surface to form micro-thin coatings. Spray apply 3 to 4 light, smooth uniform coats to clean mold surfaces. Use only a dry air source and ensure a continuous smooth wet film is achieved. Allow film to dry and cure prior to commencing molding.

- **Frekote® Aqualine® R-110™**
  - Fast curing
  - No transfer
  - High thermal stability
  - Frekote® Aqualine® R-110™ is a semi-permanent water-based release agent which provides maximum release performance with high slip properties. Apply by spraying to clean molds, pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot (120°F to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

- **Frekote® R-150™ or Aqualine® R-180™**
  - Fast curing
  - High slip
  - Minimum reject rates
  - Frekote® Aqualine® R-150™ and Frekote® Aqualine® R-180™ are both water-based release agents which provide excellent slip properties. Recommended for the most difficult molding applications, especially for highly abrasive compounds. Apply by spraying to clean molds, pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot 248°F to 401°F (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

- **Frekote® Aqualine® R-220™**
  - Fast curing
  - Excellent slip
  - Releases most compounds
  - Frekote® Aqualine® R-220™ is a water-based release agent. It offers excellent release and slip properties and is recommended for the most difficult molding applications, especially for high aspect ratio parts. Apply by spraying to clean molds pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot 248°F to 401°F (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

- **Frekote® Aqualine® R-180™**
  - Fast curing
  - High slip
  - Minimum reject rates
  - Frekote® Aqualine® R-180™ is a water-based release agent, which provides excellent slip properties. Recommended for the most difficult molding applications, especially for highly abrasive compounds. Apply by spraying to clean molds pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot 248°F to 401°F (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

---

**YOUR APPLICATION**

**SUBSTRATE**

**PRODUCT TYPE**

**APPLICATION**

**FREKOTE® BRAND SOLUTION**

**PRODUCT DESCRIPTION**

---

* Refer to page 12 for more information on Sealers and Cleaners.

---

**Technical rubber**

- High Slip
- Aqualine® R-100™
- Aqualine® R-180™ or Aqualine® R-150™

---

**Your Application**

**FREKOTE® BRAND SOLUTION**

**PRODUCT DESCRIPTION**

---

* Refer to page 12 for more information on Sealers and Cleaners.

---

**Technical rubber**

- High Slip
- Aqualine® R-100™
- Aqualine® R-180™ or Aqualine® R-150™

---
Rubber-to-Metal Bonding

Silicone Elastomer

Helpful Hints

Frekote® PMC™ is a universal cleaner prior to application of Frekote® Release Agents.

Frekote® RS-100™ is used with Aqualine® products.

Frekote® R-110™, R-120™, R-220™, S-10WB™ available as aerosol.

Frekote® HMT-2™, 770™, 800™, 810™ solvent-based available as aerosol.

Refer to page 12 for more info.

Frekote® Aqualine® R-220™
- Fast curing
- Excellent slip
- Releases most compounds

Frekote® Aqualine® R-220™ is a water-based release agent. It offers excellent release and slip properties and is recommended for the most difficult molding applications, especially for high aspect ratio parts. Apply by spraying to clean molds pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

Frekote® Aqualine® R-120™
- Fast curing
- No transfer
- High thermal stability

Frekote® Aqualine® R-120™ is a semi-permanent water-based release agent which provides maximum release performance with high slip properties. Apply by spraying to clean molds, pre-heated to ≥140°F (60°C). For warm molds, 140°F to 248°F (60°C to 120°C), a minimum of 4 coats should be applied. For hot (120°C to 205°C), new or porous molds, apply a minimum of 6 coats. Allow curing prior to production.

Frekote® HMT™ or HMT-2™
- Multiple releases
- Minimum reject rates
- No contaminating transfer

Frekote® HMT™ and Frekote® HMT-2™ are both excellent solvent-based release products designed for multiple release applications to hot molds ≥140°F (60°C). Frekote® HMT-2™ is less moisture sensitive than Frekote® HMT™. Brush or spray apply (ensure dry air source) 4 to 6 wet film coatings to clean mold surfaces. Allow a few minutes between coats for solvent evaporation. Cure is completed during solvent evaporation. Molding can commence immediately.

Frekote® S-50™
- Instant cure at elevated temperatures
- Excellent slip
- Maximum multiple releases

Frekote® S-50™ is a unique water-based release agent which cures rapidly at elevated temperatures. It offers excellent slip properties and is suitable for the most demanding silicone rubber molding applications. Apply to clean mold surfaces by spraying and ensure a dry air source or airless spray system. Initially, 2 to 3 coats of full strength Frekote® S-50™ should be applied to condition the mold. Touch-up coats should only be applied to areas where poorer release is noticed.
**Frekote®**

# Sacrificial Mold Releases

## YOUR APPLICATION

### SUBSTRATE

<table>
<thead>
<tr>
<th>General Purpose</th>
<th>Phenolic</th>
<th>Silicone</th>
<th>Epoxies and Thermoset Resins</th>
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</thead>
<tbody>
<tr>
<td>Water-based</td>
<td></td>
<td></td>
<td>Solvent-based</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>General Purpose</td>
</tr>
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</table>

## PRODUCT TYPE

### APPLICATION

### REQUIREMENT

### FREKOTE® BRAND SOLUTION

<table>
<thead>
<tr>
<th>Description:</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Release Agent</th>
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<tbody>
<tr>
<td>Appearance:</td>
<td>White emulsion</td>
<td>Light Amber</td>
<td>Yellowish liquid</td>
<td>Clear liquid</td>
</tr>
<tr>
<td>Application Temperature:</td>
<td>140°F to 355°F (60°C to 180°C)</td>
<td>140°F to 355°F (60°C to 180°C)</td>
<td>220°F to 390°F (104°C to 200°C)</td>
<td>68°F to 140°F (20°C to 60°C)</td>
</tr>
<tr>
<td>Cure Time Between Coats at 70°F (21°C):</td>
<td>Liquid Evaporation (up to 10 min. at room temp.)</td>
<td>Liquid Evaporation (up to 10 min. at room temp.)</td>
<td>Liquid Evaporation (up to 10 min. at room temp.)</td>
<td>Solvent Evaporation (up to 60 seconds)</td>
</tr>
<tr>
<td>Final Cure Time at 70°F (21°C):</td>
<td>Liquid Evaporation (up to 10 min. at room temp.)</td>
<td>Liquid Evaporation (up to 10 min. at room temp.)</td>
<td>Liquid Evaporation (up to 10 min. at room temp.)</td>
<td>Solvent Evaporation (up to 60 seconds)</td>
</tr>
<tr>
<td>Final Cure Time at 100°C:</td>
<td>Liquid Evaporation</td>
<td>Liquid Evaporation</td>
<td>Liquid Evaporation</td>
<td>N/A*</td>
</tr>
<tr>
<td>Thermal Stability:</td>
<td>up to 500°F (260°C)</td>
<td>N/A*</td>
<td>&lt; 392°F (200°C)</td>
<td>up to 500°F (260°C)</td>
</tr>
</tbody>
</table>

### PRODUCT DESCRIPTION

**Frekote® EXITT-EM™**
- High gloss finish
- No mold build-up
- Precision retention of mold detail

Frekote® EXITT-EM™ is a water-based silicone emulsion that offers superb release properties, excellent part detail, and provides a water-based alternative to solvent-based products to meet your specific molding requirements. Frekote® EXITT-EM™ is capable of releasing most thermoset and thermoplastic resins, including polyurethanes and can be applied to steel, aluminum, epoxy, urethane, and ceramic mold surfaces.

**Frekote® 1450™**
- Economical use
- Minimal build-up
- Easy to clean molds

Frekote® 1450™ is a water-based solution, specifically formulated for use with resin/asbestos products. It has been extremely effective in releasing resin/asbestos mixtures molded at 302°F to 329°F (150°C to 165°C) as well as automotive disc brake linings. This product can be diluted from 10:1 to 20:1, which makes it an economical choice for use when a sacrificial product is desired.

**Frekote® S-50™**
- Instant cure at elevated temperature
- Excellent slip

Frekote® S-50™ is a water-based material designed for excellent slip in the most difficult-to-release silicone rubber applications. Frekote® S-50™ has no required cure time, low VOC, excellent slip, and low mold build-up. This product forms a thin, inert, thermally stable coating capable of releasing many types of silicone rubbers and is capable of being diluted to a wide range of ratios.

**Frekote® 1711™**
- Aerosol
- General purpose
- High gloss
- Stable at 500°F (260°C)

Frekote® 1711™ and Frekote® 1711-I™ are silicone, solvent-based, mold release agents that offer a high gloss finish with excellent part detail and mold geometry retention. These products can be applied to steel, aluminum, epoxy, ceramic, and flexible mold surfaces, and are stable up to 500°F (260°C).

**Frekote® 1711-I™**
- Non-aerosol liquid
- General purpose
- High gloss
- Stable at 500°F (260°C)

Refer to page 12 for more information on Sealers and Cleaners.

*Not Applicable*
Frekote® Rimlease 8™
• Semi-gloss finish
• Excellent slip
• Minimal transfer

Frekote® Rimlease 8™ was specifically formulated for use as a release interface for RIM and R/RIM polyurethane processes. Frekote® Rimlease 8™ offers a high slip, semi-gloss finish and transfers to the part slightly, but can be easily cleaned using warm water prior to painting or any other post-molding process.

Frekote® EXITT™ and Frekote® EXITT-I™ provide a semi-gloss finish on molds and allow for easy part clean-up. These products were developed for use with urethane foams and cast elastomers, and are not recommended for use with parts that need to be painted or bonded.

Frekote® LIFFT™
• Non-aerosol liquid
• Silicone based
• High gloss finish

Frekote® LIFFT-I™
• Non-aerosol liquid
• Silicone based
• High gloss finish

Frekote® EXITT™
• Aerosol
• Silicone based
• High gloss finish

Frekote® EXITT-I™
• Aerosol
• Silicone based
• High gloss finish

Frekote® AC-4368™
• Excellent slip
• Multi-purpose release

Frekote® AC-4368™ is an all-purpose, silicone based release agent. This product contains a special lubricant which provides optimum release along with surface conditioning on any metal or plastic mold. Frekote® AC-4368™ works equally well releasing epoxies, polyurethanes, and polyesters in room temperature and elevated cure systems.

Frekote® LIFFT™
• Aerosol
• Silicone based
• High gloss finish

Frekote® LIFFT-I™
• Aerosol
• Silicone based
• High gloss finish

Frekote® EXITT™
• Aerosol
• Silicone based
• High gloss finish

Frekote® EXITT-I™
• Aerosol
• Silicone based
• High gloss finish

Visit www.frekote.com
### Sealers and Cleaners

#### FREKOTE® BRAND SOLUTION

<table>
<thead>
<tr>
<th>PRODUCT TYPE</th>
<th>Metal Molds</th>
<th>Metal Molds</th>
<th>Polyester, Composite and Fiberglass Molds</th>
<th>Polyester, Epoxy, and Metal Molds</th>
<th>Polyester, Epoxy, and Composite Molds</th>
</tr>
</thead>
<tbody>
<tr>
<td>SUBSTRATE</td>
<td>Solvent-based</td>
<td>Water-based</td>
<td>Solvent-based</td>
<td>Solvent-based</td>
<td>Water-based</td>
</tr>
<tr>
<td>APPLICATION REQUIREMENT</td>
<td>B-15™</td>
<td>Aqualine® RS-100™</td>
<td>FMS-100™</td>
<td>PMC™</td>
<td>915WB™</td>
</tr>
<tr>
<td>DESCRIPTION</td>
<td>Mold Sealer</td>
<td>Mold Sealer</td>
<td>Mold Sealer</td>
<td>Mold Cleaner</td>
<td>Mold Cleaner</td>
</tr>
<tr>
<td>Appearance</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Beige, pasty liquid</td>
</tr>
<tr>
<td>Application Temperature</td>
<td>59°F to 140°F (15°C to 60°C)</td>
<td>199°F to 401°F (93°C to 205°C)</td>
<td>55°F to 105°F (13°C to 41°C)</td>
<td>68°F to 86°F (20°C to 30°C)</td>
<td>68°F to 104°F (20°C to 40°C)</td>
</tr>
<tr>
<td>Cure Time Between Coats at 70°F (21°C):</td>
<td>30 minutes</td>
<td>15 minutes</td>
<td>15 minutes</td>
<td>N/A*</td>
<td>N/A*</td>
</tr>
<tr>
<td>Final Cure Time at 70°F (21°C):</td>
<td>24 hours [60 min. at 212°F (100°C)]</td>
<td>20 minutes</td>
<td>20 minutes</td>
<td>N/A*</td>
<td>N/A*</td>
</tr>
<tr>
<td>Thermal Stability:</td>
<td>up to 750°F (400°C)</td>
<td>up to 698°F (370°C)</td>
<td>up to 750°F (400°C)</td>
<td>N/A*</td>
<td>N/A*</td>
</tr>
</tbody>
</table>

#### 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 room temperature.

**Frekote® RS-100™**
- Water-based product
- Seals mold porosity
- High thermal stability

Frekote® RS-100™ is a water-based sealer used to seal micro-porosity in steel, and chrome plated molds. Frekote® RS-100™ provides an excellent base coat that significantly increases the number of releases.

**Frekote® FMS-100™**
- Easy to use
- High gloss finish
- Fast curing

Frekote® FMS-100™ is a high performance sealer. It is formulated to use on FRP, epoxy, and other composite mold surfaces. Frekote® FMS-100™ can be applied at room temperature, and cures within 30 minutes of application.

**Frekote® PMC™**
- High gloss finish
- Minimal mold build-up
- Fast curing

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™**
- Easy to use
- Eliminates contaminants
- Enhances release effectiveness

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®*
<table>
<thead>
<tr>
<th>Cleaner</th>
<th>Specialty Products</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Polyester, Composite and Fiberglass Molds</strong></td>
<td><strong>Semi-Permanent Release</strong></td>
</tr>
<tr>
<td>Solvent-based</td>
<td><strong>Cleaner Mold Release</strong></td>
</tr>
<tr>
<td>CMR™</td>
<td><strong>Rel-Eaze™</strong></td>
</tr>
<tr>
<td>Rel-Eaze™</td>
<td><strong>RC-321™</strong></td>
</tr>
<tr>
<td>RC-321™</td>
<td><strong>EFR™</strong></td>
</tr>
<tr>
<td>CUR™</td>
<td><strong>PUR-100™</strong></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Cleaner / Mold Release</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Release Agent</th>
<th>Cleaner / Mold Release</th>
<th>Release Agent</th>
</tr>
</thead>
<tbody>
<tr>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>White emulsion</td>
<td>Clear liquid</td>
<td>Clear liquid</td>
<td>Milky, white emulsion</td>
</tr>
<tr>
<td>55°F to 105°F (13°C to 41°C)</td>
<td>55°F to 302°F (13°C to 150°C)</td>
<td>140°F to 400°F (60°C to 205°C)</td>
<td>55°F to 109°F (13°C to 43°C)</td>
<td>55°F to 105°F (13°C to 41°C)</td>
<td>Above 120°F (48°C)</td>
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<tr>
<td>15 minutes</td>
<td>N/A</td>
<td>5 min. at 302°F (150°C)</td>
<td>5 minutes</td>
<td>15 minutes</td>
<td>5 min. at 302°F (150°C)</td>
</tr>
<tr>
<td>N/A</td>
<td>N/A</td>
<td>up to 750°F (400°C)</td>
<td>up to 600°F (315°C)</td>
<td>up to 600°F (315°C)</td>
<td>up to 600°F (315°C)</td>
</tr>
</tbody>
</table>

**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 buildup resulting from repeated releases using Frekote® WLO™. Additional releases can be obtained after cleaning the mold surface without touching up with a traditional mold release agent.

**Frekote® Rel-Eaze™**
- Utilized in sand core release
- Cold box applications
- Multiple releases

Frekote® Rel-Eaze™ is a high performance product developed for releasing sand cores used in foundry operations. It can be applied at room temperature. The product offers multiple releases of sand cores and sand molds.

**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, polymer 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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# Frekote®

## Product Information

### MATERIALS APPLICATION GUIDE

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<th>FREKOTE® BRAND MOLD RELEASE AGENTS</th>
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<th>55-nC™</th>
<th>700-nC™</th>
<th>770-nC™</th>
<th>800-nC™</th>
<th>810-nC™</th>
<th>C-600™</th>
<th>C-650™</th>
<th>FRP-NC™</th>
<th>HMT-1™</th>
<th>HMT-2™</th>
<th>R-110™</th>
<th>R-120™</th>
<th>R-130™</th>
<th>R-140™</th>
<th>R-150™</th>
<th>R-160™</th>
<th>R-170™</th>
<th>R-180™</th>
<th>R-220™</th>
<th>S-50™</th>
<th>Wolo-NC™</th>
<th>Wolo-HS™</th>
<th>REL-50™</th>
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<tbody>
<tr>
<td>Epoxy (Non Gel-Coat)</td>
<td>O</td>
<td>O</td>
<td>O</td>
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### COMPOUND

- Highly Recommended
- Recommended

### PROCESS

- Cast Polymer / Solid Surface
- Compression / Transfer / Vacuum Bagging
- Filament Winding
- Hand Lay up / Spray up
- Injection Molding
- Rotational Molding
- Rubber-to-Metal Bonding
- Tire Treads
- Sand Casting

For technical product assistance, call 1-800-562-8483 in the U.S. or 1-800-263-5043 in Canada.
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<td>1 gallon can</td>
<td>4</td>
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<td>5 gallon pail</td>
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<tr>
<td></td>
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<td>55 gallon drum</td>
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<td>200 gallon tote</td>
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<td></td>
<td>83445</td>
<td>55 gallon drum</td>
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<td>Web*</td>
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<td>1</td>
<td>Web*</td>
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<td></td>
<td>83413</td>
<td>1 gallon can</td>
<td>1</td>
<td>Web*</td>
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<td></td>
<td>83412</td>
<td>16 fl. oz. can (1 pint)</td>
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<td>Web*</td>
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<td>FMS™</td>
<td>1012885</td>
<td>1 pint</td>
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<td></td>
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<td>1102886</td>
<td>5 gallon container</td>
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<td>40613</td>
<td>1 gallon can</td>
<td>4</td>
<td>13</td>
</tr>
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</table>

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✓ Material Safety Data Sheets  ✓ Product Literature

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