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Product Description Sheet

Frekote[®] Aqualine[®] R-95 Mold Release Agent

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Description

Loctite[®] Frekote[®] Aqualine[®] R-95 is a water-based, semi-permanent release agent for rubber molding. When properly applied to a preheated surface, this easy to use product chemically bonds to the mold surface to form a thin, inert, thermally stable coating capable of releasing all natural and synthetic polymers including some silicone compounds and thermoplastic urethanes. Aqualine R-95 offers excellent release properties and is recommended for the most difficult molding applications where minimal mold build-up and no contaminating transfer is needed.

Features

- Fast curing
- No contaminating transfer
- Low mold buildup
- Non flammable
- Reduced reject rates
- Maximum multiple release
- Very low VOC <10 g/L

Properties

Appearance	White emulsion
Odor	Mild
Special Cautions	Store below 104°F (40°C)
Specific Gravity	1.00 +/- 0.02
Application Temperature	60°C-204°C (140°F-400°F)
Thermal stability when cured	315°C (600°F)
Shelf Life	12 months from the date of manufacture

Mold Preparation

Mold surfaces must be thoroughly cleaned and dried. All traces of prior release agents and contaminants must be removed. This may be accomplished by using Frekote PMC, or other suitable solvents. Heavy build-up will probably require abrasion (e.g., grit sand or glass beading) followed by solvent washing. This will remove polymer buildup or previous release contamination.

Application *Consult MSDS Prior To Use*

Apply Aqualine R-95 to molds preheated to a minimum of 140°F (60°C). Aqualine R-95 is suitable for application up to 400°F (204°C).

Apply Aqualine R-95 using a finely atomized fan pattern. Regulate gun output to 2-3 fl. oz./minute for molds heated to 140-300°F or 4-5 fl. oz./minute for molds above 300°F.

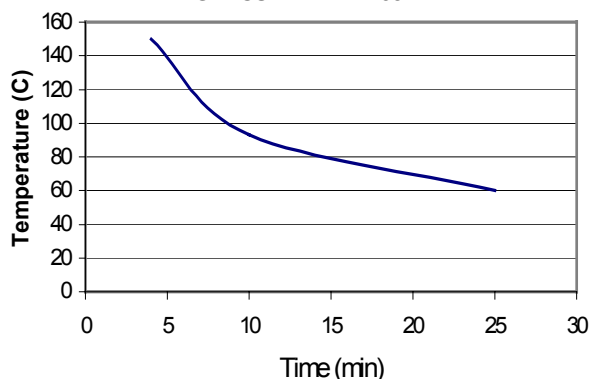
At 140°F (60°C), the release agent will dry in a few seconds and will be fully cured after 25 minutes. At 200°F (93°C), this cure time is reduced to 10 minutes. At 300°F (150°C), Aqualine R-95 dries instantly and requires only four minutes to fully cure (see Figure 1).

For hot (250°F-400°F; 121°C-204°C), or porous molds, apply a minimum of six coats. For warm molds (140°F-250°F; 60°C - 121°C), a minimum of four coats should be applied with care being taken to avoid emulsion accumulation and run marks due to over application. Allow time for the release agent to cure prior to production.

Touch Up

Touch up coats should only be applied to areas where poorer release is noticed. This will reduce the possibility of release agent or polymer build up. The frequency of touch up will depend on polymer type, mold configuration and abrasion parameters. Follow application guidelines outlined above.

FIG. 1 CURE TIME R-95



Storage

Aqualine R-95 should not be stored above 104°F (40°C).

Note

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