



1001 Trout Brook Crossing
Rocky Hill, CT 06067-3910
Telephone: (860) 571-5100
FAX: (860) 571-5465

Product Description Sheet

FREKOTE[®] Rimlease 8 Mold Release Agent

Industrial Products, October 2003

Description

Loctite[®] Frekote[®] Rimlease 8 was specifically formulated for use as a release interface for RIM and R/RIM polyurethane processes. A high slip and semi-gloss finish are characteristics of Rimlease 8. The water-based formula transfers minimally to the molded part and can easily be cleaned with warm water prior to painting or any other post-molding process.

Features

Semi-gloss finish
Multiple releases per application
Excellent slip
Parts can be cleaned with warm water
Minimal transfer
Little to no build up

Properties

Appearance	Clear liquid
Odor	Mild
Solvent	Water/Isopropyl Alcohol
Specific Gravity	0.970 +/- 0.010
Shelf Life	12 months from date of manufacture
Cured thermal stability	315°C (600°F)

Mold Preparation

The mold surface must be cleaned and free of any release agent or sealer for Rimlease 8 to perform effectively.

Old Molds: Prior to applying Rimlease, Dynasolve CU-5 (Dynaloy Corp 800 669 5709) (or equivalent) is recommended for cleaning molds where PU had previously been used and built up. This should be followed by a Frekote PMC solvent wash to thoroughly clean the mold.

Heat mold to a temperature above 55°C (130°F) to ensure removal of residual moisture and a uniform film application of the Rimlease.

Application *Consult MSDS Prior To Use*

1. For optimum results spray apply Rimlease 8. Wipe and brush applications can also be used. Set line pressure at 30-50 psi with a flow rate of 50 mls per minute. Spray from a distance of 8-10 inches.
2. (Optional) Add a small quantity of water soluble food dye to the Rimlease 8 so the operator can determine proper coating of the mold. This process can be eliminated once operators optimize usage.
3. For the initial application, spray/apply two light coats of Rimlease 8. Apply the second coat at a 90° angle to the first coat ensuring total coverage of the mold.
4. Commence molding when film is dry and appearance has turned slightly dull. Total drying time is only a few seconds.
5. A light touch-up of Rimlease 8 is recommended for the first three molding cycles. This will condition the mold and provide multiple releases. After initial cycling and releases, a single touch-up coat is only necessary when there are signs of a slight hesitancy to release.

Cleaning

Use only water and a cotton cloth to wash off all the dull Rimlease 8 film. On a heated mold 40-50°C (104°F-122°F) use water at ambient temperature or on a cool mold use warm water 40°C -50°C (104°F-122°F).

Wash polyurethane RIM and R/RIM parts in warm water or by a power wash procedure then dry prior to the application of paints or primers.

Flammability/Storage

Rimlease 8 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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ROCKY HILL, CT FAX: +1 (860)-571-5473 DUBLIN, IRELAND FAX: +353-(1)-451 - 9959

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