Description
Loctite® Frekote® Rotolease is a unique water based release agent designed to provide multiple releases with no contaminating transfer. Loctite® Frekote® Rotolease can be applied to molds at any temperature between room temperature and 205°C (400°F). Loctite® Frekote® Rotolease chemically bonds to the mold surface to form a micro-thin, chemically resistant coating capable of releasing most rotationally molded resins. Loctite® Frekote® Rotolease is a water-based product that contains no CFC's and no chlorinated, aromatic or petroleum based solvents thus making it one of the safest, non-flammable, lowest VOC products available. When used according to directions, Loctite® Frekote® Rotolease gives no mold build-up, allows for easy, multiple releases and exhibits high thermal stability for all molding processes.

Features
No Contaminating Transfer
Very low VOC content
No mixing required
Water-based/Non-flammable
Multiple releases per application
High thermal stability (>230°C; 450°F)
Non-irritating
No mold build-up

Properties
Appearance White emulsion
Odor Slight mild odor
Specific Gravity 0.99
Special Cautions Store below 40°C (104°F)
Shelf Life 6 months from 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 Loctite 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**
Loctite® Frekote® Rotolease is designed to be applied to molds at any temperature between 20°C (68°F) and 205°C (400°F). Spray application is recommended, although brushing or wiping may also be used. Optimum multiple release performance is obtained by applying to molds preheated above 60°C (140°F). The ease of release, number of releases/application and surface finish will depend on application technique, mold temperature and number of coats applied.

1. When applying Loctite® Frekote® Rotolease to a mold at room temperature (approximately 20°C/68°F), use a minimum of four coats. Allow each coat to dry (approximately 10 minutes) before applying the subsequent coat. The dry time may be decreased, by using a fan or infrared lamps. Post cure the final film for at least 35 minutes at 65°C (150°F), 25 minutes at 93°C (200°F), 15 minutes at 120°C (250°F) or 5 minutes at 150°C (300°F) prior to starting production.

2. Care should be taken to avoid emulsion accumulation and running due to over application. If spray application is to be used, high volume, low-pressure spray equipment (HVLP) is recommended to produce optimum transfer efficiency and reduce over-spray. Porous molds should be preheated to a minimum of 60°C (140°F) prior to release agent application.

3. When applying Loctite® Frekote® Rotolease to molds above room temperature (>40°C; 104°F), apply a minimum of three coats. Again, allow each to dry before applying the subsequent coat. At 60°C (140°F), Rotolease will dry in a few seconds; above 100°C (212°F), it will dry instantly. After applying the final coat, allow Rotolease to post-cure according to the chart below:

### Rotolease Cure Time

<table>
<thead>
<tr>
<th>Time (minutes)</th>
<th>Temperature (°F)</th>
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<tr>
<td>0</td>
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<td>10</td>
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<tr>
<td>30</td>
<td>300</td>
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<tr>
<td>40</td>
<td>400</td>
</tr>
</tbody>
</table>

Touch-up
The frequency of touch-up will depend on resin type, mold configuration and abrasion parameters. Touch up with Loctite® Frekote® Rotolease only to areas where poor release is noticed. Again, allow the touch-up coat to cure, for the minimum time given above, prior to commencing production.
LOCTITE® FREKOTE ROTOLEASE

Known as
FREKOTE® Aqualine Rotolease Mold Release Agent

September 2015

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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