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Product Description Sheet

FREKOTE® B-15

Mold Sealer

Industrial Products, September 2001

Description

Loctite® Frekote® B-15 is formulated as a sealer for metallic molds with micro porosity problems, small surface scratches or imperfections. Used in conjunction with other Frekote products, B-15 provides an excellent base coat enhancing the release advantages offered.

Features

Seals mold porosity, scratches or imperfections
No contaminating transfer

Properties

Appearance	Clear liquid
Odor	Sweet Ether
Solvents	Dibutyl Ether
Specific Gravity	0.760 +/-0.015
Flash Point	18°C (64°F) Pensky Marten Closed Cup
Special Cautions	Moisture sensitive, keep container tightly closed when not in use
Shelf Life	One year from date of manufacture

Mold Preparation

The mold surface must be clean and free of any release agent or sealer for Frekote B-15 to be completely effective.

New Molds: Remove any mold sealer with Frekote PMC or suitable solvent. Vapor degreasing may also be used if available. Special care should be taken not to damage resin molds. Molds coated with silicones can be cleaned with toluene, chlorinated solvents or mineral spirits, removing any trace of solvent with a clean cloth. Light industrial abrasives can be used to remove silicone build-up.

Application ****Consult MSDS prior to use****

Frekote B-15 can be applied to mold surfaces by spraying, brushing, dipping or wiping with a clean lint free cloth. When spraying, ensure a dry air source is used or use an airless spray system making sure the nozzles is 8" to 10" from the mold surface.

Brushing and dipping are effective methods of application, but care should be taken to avoid excessive pooling and to ensure that the part is well drained. Wiping on is the best method of application.

1. Only a thin wet film is required. It is suggested that small areas be coated, working progressively from one mold to the other.
2. Apply a minimum of two coats, allowing 30 minutes between coats.
3. The final coating will cure within 24 hours at room temperature, or the cure process can be shortened by baking the mold for 60 minutes at 94°C (200°F) after ensuring that the mold is dry and all solvents have flashed off.
4. The mold is now ready to be coated with Frekote Mold Release products.

Flammability/Storage

Frekote B-15 contains flammable solvents. The product should always be used in well-ventilated areas. Store in a cool, dry place. Keep container tightly closed when not in use. Consult MSDS for complete details.

Note

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