



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

Product Description Sheet

FREKOTE[®] HMT-2 Mold Release Agent

Industrial Products, October 2003

Description

Loctite[®] Frekote[®] HMT-2 is a hot mold touch up version of Frekote 55-NC and is formulated for use on molds with temperatures above 60°C (140°F). After one touch up coat, HMT-2 continues to offer the same multiple releases per application as experienced with the other Frekote products. For constant mold temperatures over 60°C (140°F), Frekote HMT-2 performs effectively on its own.

Features

Multiple Release
No contaminating transfer
No mold build up
Minimum reject rates
Low odor
High temperature application

Properties

Appearance	Clear Liquid
Odor	Aliphatic Hydrocarbon
Solvents	Aliphatic Hydrocarbons
Specific Gravity	0.770 +/- 0.015
Shelf Life	One year from date of manufacture
Special Cautions	Moisture sensitive, keep container tightly closed when not in use.
Cured thermal stability	400°C (750°F)
Application Temp	60°C - 190°C (140°F -375°F)

Mold Preparation

The mold surface must be clean and free of any non-Frekote release agents or other contaminants for Frekote HMT-2 to be completely effective. Remove any contaminants with Frekote PMC or other suitable cleaning solvents. Light industrial abrasives can be used to remove heavy resin build up. No mold preparation is required when HMT-2 is used as a touch up coat over another Frekote Product.

Application *Consult MSDS prior to use*

Frekote HMT-2 is intended as a touch up on mold surfaces above 60°C (140°F) and applied by spraying or brushing. For spraying use conventional equipment, ensuring a dry air source or an airless spray system. Frekote HMT-2 dries very rapidly at elevated temperatures. Care should be taken to ensure complete coverage.

Touch-up

Spray or brush on one thin wet film coating over the entire mold surface or on the area that is experiencing difficult release. Allow time for complete solvent evaporation. Upon drying, the HMT-2 polymer is cured and ready for production.

Constant Use

1. If using Frekote HMT-2 as a releasing system on its own, apply a thin wet continuous film coating the entire mold. It is suggested that small areas be coated working progressively from one side of the mold to the other.

2. For the initial application 4 – 6 coats are recommended, allowing a few minutes between coats for solvent evaporation.
3. After the final coat, curing is completed through solvent evaporation and ready for production.
4. Maximum releases will be obtained as the mold surface becomes conditioned to Frekote HMT-2. Performance is enhanced by re-coating once, after the first few initial moldings.

Flammability/Storage

Frekote HMT-2 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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