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# Product Description Sheet

## FREKOTE<sup>®</sup> Aqualine<sup>®</sup> PUR-100

### Mold Release Agent

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#### Description

Loctite<sup>®</sup> Frekote<sup>®</sup> Aqualine<sup>®</sup> PUR-100 mold release is a proprietary waterbased emulsion developed for releasing rigid, high-density polyurethane (PU) foam and cast polyurethane parts. Aqualine PUR-100's unique, polymer-based chemistry is capable of multiple releases from a single application. In addition, parts molded with Aqualine PUR-100 can be painted without any post-finishing or cleaning steps. This product is also capable of releasing some low-density PU foams.

#### Features

Non toxic waterbased system  
Non-flammable  
Freeze thaw stable  
Multiple releases per application  
Parts can be painted after molding without preparation  
Non settling/No agitation required  
Very low VOC

#### Properties

Appearance	Milky white emulsion
Odor	Mild
Specific Gravity	1.0 ± 0.03
Shelf Life	12 months from date of manufacture
Application Temperature	120°F (49°C) and above
VOC Content	1 %; 0.010 lbs./gal; 10 g/L

#### 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\*

Aqualine PUR-100 should be spray applied to molds preheated to a minimum of 60°C (140°F) and is suitable for application to molds up to 204°C (400°F).

Spray apply Aqualine PUR-100 using a finely atomized fan pattern. Regulate gun output to 2-3 fl. oz./minute for molds heated to 60°C - 150°C (140-300°F) or 4-5 fl. oz./minute for molds above 150°C (300°F).

At 60°C (140°F), the release agent will dry in a few seconds and will be fully cured after 30 minutes. At 100°C (212°F), this cure time is reduced to 10 minutes.

At 150°C (300°F), Aqualine PUR-100 dries instantly and requires only four minutes to fully cure.

For hot 121°C-204°C; (250°F-400°F) or porous molds, apply a minimum of six coats. For warm molds 60°C-121°C (140°F-250°F), 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 poor release is noticed. This will reduce the possibility of release agent or polymer build up. Again allow at least 5 minutes at 150°C (300°F), 10 minutes at 100°C (212°F) or 30 minutes at 60°C (140°F) for the touch-up coat to cure before restarting production. The frequency of touch up will depend on polymer type, mold configuration and abrasion parameters.

#### Note

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