



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

## Product Description Sheet

# FREKOTE<sup>®</sup> Rimlease 8 Mold Release Agent

Industrial Products, October 2003

### Description

Loctite<sup>®</sup> Frekote<sup>®</sup> 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

The data contained herein are furnished for information only and are believed to be reliable. We cannot assume responsibility for the results obtained by others over whose methods we have no control. It is the user's responsibility to determine suitability for the user's purpose of any production methods mentioned herein and to adopt such precautions as may be advisable for the protection of property and of persons against any hazards that may be involved in the handling and use thereof. In light of the foregoing, **Loctite Corporation specifically disclaims all warranties expressed or implied, including warranties of merchantability or fitness for a particular purpose, arising from sale or use of Loctite Corporation's products. Loctite Corporation specifically disclaims any liability for consequential or incidental damages of any kind, including lost profits.** The discussion herein of various processes or compositions is not to be interpreted as representation that they are free from domination of patents owned by others or as a license under any Loctite Corporation patents that may cover such processes or compositions. We recommend that each prospective user test his proposed application before repetitive use, using this data as a guide. This product may be covered by one or more, United States, or foreign patents or patent applications.

NOT FOR PRODUCT SPECIFICATIONS  
THE TECHNICAL DATA CONTAINED HEREIN ARE INTENDED AS REFERENCE ONLY.  
PLEASE CONTACT LOCTITE CORPORATION QUALITY DEPARTMENT FOR ASSISTANCE AND RECOMMENDATIONS ON SPECIFICATIONS FOR THIS PRODUCT.  
ROCKY HILL, CT FAX: +1 (860)-571-5473 DUBLIN, IRELAND FAX: +353-(1)-451 - 9959

Loctite and Frekote are Registered Trademarks of Loctite Corporation U.S.A.