

Loctite® Frekote® B-15™

Known as Frekote B-15
December 2013

PRODUCT DESCRIPTION

Loctite® Frekote® B-15™ provides the following product characteristics:

Technology	Mold Sealer
Appearance	Clear, colorless ^{LMS}
Chemical Type	Solvent Based Polymer
Odor	Solvent
Cure	Room temperature cure
Cured Thermal Stability	≤400 °C
Application	Mold Sealer
Application Temperature	20 to 60 °C
Specific Benefit	• No contaminating transfer • High thermal stability • Seals mold porosity, scratches or imperfections

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

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C 0.745 to 0.775^{LMS}

Flash Point - See SDS

Release Agent Transfer ≥4^{LMS}

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Mold Preparation Cleaning:

Mold surfaces must be thoroughly cleaned and dried. All traces of prior release must be removed. This may be accomplished by using Loctite® Frekote® PMC or other suitable cleaner. Loctite® Frekote® 915WB™ or light abrasives can be used for heavy build-up.

Directions for use:

1. Loctite® Frekote® B-15™ can be applied to mold surfaces by spraying, brushing, dipping or wiping with a clean, lint free, cotton wiping cloth. When spraying, ensure a dry air source is used or use an airless spray system making sure the nozzles is 20 to 25 cm from the mold surface.
2. 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.
3. Only a thin wet film is required. It is suggested that small areas be coated, working progressively from one mold to the other.
4. Apply a minimum of two coats, allowing 30 minutes between coats.
5. The final coat will cure within 24 hours at 23°C or the cure process can be shortened by baking the mold for 60 minutes at 95°C after ensuring that the mold is dry and all solvents have flashed off.
6. The mold is now ready to be coated with Frekote mold release products. Please refer to individual product data sheets for the proper application of the release agent.

Mold Touch up

Touch up coats with a sealer should only be applied to areas where the mold was repaired. On repaired areas apply the same number of sealer and release agent coats like for the base coating onto new or refurbished molds.

Loctite Material Specification^{LMS}

LMS dated December 18, 2002. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

The product is classified as flammable and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. Store product in the unopened container in a dry location. Storage information may also be indicated on the product container labelling.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.

Note:

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Reference 0.1