Technical Data Sheet

LOCTITE® FREKOTE FMS™

Known as FMS™
August 2014

PRODUCT DESCRIPTION

LOCTITE® FREKOTE FMS™ provides the following product characteristics:

Technology	Mold Release
Appearance	Clear, colorless[LMS]
Chemical Type	Solvent Based Polymer
Odor	Hydrocarbon
Cure	Room temperature cure
Application	Mold Sealer
Application Temperature	13 to 35 °C
Specific Benefit	• High gloss finish • Easy application • Fast curing • Eliminates Porosity/Microporosity • Seals "green" molds and repaired areas

LOCTITE® FREKOTE FMS™ is formulated specifically as a sealer for fiberglass reinforced polyester, epoxy and other composite molds commonly used in the fiberglass molding industry. LOCTITE® FREKOTE FMS™ must be used when using green, or new, molds with microporosity and other slight surface imperfections.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25°C	0.757 to 0.771[LMS]
Flash Point - See SDS	

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.
Full curing of green/new molds is highly recommended to ensure optimal performance of the sealer.

Directions for use:

1. Apply LOCTITE® FREKOTE FMS™ with a clean, lint free, cotton wiping cloth. Wet the cloth with LOCTITE® FREKOTE FMS™ until it is damp but not dripping.
2. Wipe a smooth, wet film over the entire mold surface. For larger molds, apply LOCTITE® FREKOTE FMS™ to the surface one section at a time starting at one end and working towards the other. Using a clean cloth, wipe off the area that was just treated to obtain a smooth thin wet layer.
3. Allow a minimum of 15 minutes before applying next coat. New molds require 1 to 2 coats of sealer.
4. **NOTE:** Changes in temperature will affect solvent dry time. At temperatures below 18°C, waiting time between wiping on and drying off can be slightly longer than 20 seconds. At higher then normal temperatures (greater then 35°C) the wait time is significantly reduced and can be as quick as 1 to 2 seconds. In these conditions it is also advisable to reduce your wipe area to eliminate streaking due to the increased solvent evaporation and polymer cure times. A general guideline is to wait until the edges of the wiped area begins to creep inwards indicating the evaporation has just begun. Wipe from the outside and slowly work your way towards the center. Light hand pressure is all that is needed. No hard rubbing required. change cloth frequently to ensure proper drying of the mold. On small molds, allow up to 15 minutes between coats. If one coat takes more than 15 minutes, simply go back to starting point and begin to apply next coat. .
5. Allow the final coat to cure for 20 minutes at 20°C.

Loctite Material Specification[LMS]

LMS dated February 07, 2007. 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 Representive.

Conversions

(°C x 1.8) + 32 = °F
kV/mm x 25.4 = V/mil
mm / 25.4 = inches
µm / 25.4 = mil
N x 0.225 = lb
N/mm x 5.71 = lb/in
N/mm² x 145 = psi
MPa x 145 = psi
N·m x 8.851 = lb·in
N·m x 0.738 = lb·ft
N·mm x 0.142 = oz·in
mPa·s = cP

Note:
The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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