Technical Data Sheet

LOCTITE® FREKOTE RC-321™

Known as Frekote Aqualine® RC-321™
October 2015

PRODUCT DESCRIPTION

LOCTITE® FREKOTE RC-321™ provides the following product characteristics:

Technology	Mold Release
Appearance	Translucent white emulsion[LMS]
Chemical Type	Water based emulsion
Odor	Mild
Cure	Heat cure
Cured Thermal Stability	≤315 °C
Application	Release Coatings
Application Temperature	60 to 200 °C
Specific Benefit	• Fast curing • Multiple releases • Non-flammable • Reduces rejection rates • No contaminating transfer • Freeze/Thaw stable

LOCTITE® FREKOTE RC-321™ is a water dilutable concentrate that provides a durable release film for most rubber molding applications. This product chemically bonds to the mold surface to provide a non-transferring film capable of releasing all natural and synthetic polymers (except silicone elastomers). LOCTITE® FREKOTE RC-321™ cures in 5 minutes at 150°C, gives minimal buildup on the mold surface, and does not transfer to the molded part.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	0.98 to 1.02
Flash Point - See SDS	
pH	3.9 to 4.1[LMS]

GENERAL INFORMATION

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 Frekote® PMC or other suitable cleaner. Frekote® 915WB™ or light abrasives can be used for heavy build-up.

NOTE: Optimum results will be achieved when molds are cleaned prior to use of LOCTITE® FREKOTE RC-321™

Directions for use:

1. Mixing - It is recommended that soft distilled or deionized water be used to dilute LOCTITE® FREKOTE RC-321™ prior to use. The use of hard water may lead to the buildup of mineral deposits on the mold surface. The preferred maximum dilution ration is three parts water to one part LOCTITE® FREKOTE RC-321™. Tests should be conducted to determine the most suitable concentration for a particular application.
2. Stability - Once diluted, LOCTITE® FREKOTE RC-321™ is stable for up to 2 weeks.
3. Apply LOCTITE® FREKOTE RC-321™ to molds pre-heated to a minimum of 60°C. LOCTITE® FREKOTE RC-321™ is suitable for mold temperatures up to 200°C.
4. Apply LOCTITE® FREKOTE RC-321™ using a finely atomized fan pattern. Regulate the gun output to 60 - 90 ml/minute for molds heated from 60°C - 150°C. Molds above 150°C regulate gun output to 120 - 150 ml/minute.
5. At 60°C, LOCTITE® FREKOTE RC-321™ will dry in a few seconds and be fully cured after 30 minutes. At 100°C, cure time is reduced to 10 minutes, and at 150°C LOCTITE® FREKOTE RC-321™ dries instantly and required only 5 minutes to fully cure.
6. For hot 120 to 200°C molds, or porous molds, apply a minimum of 6 coats. For temperatures ranging from 60 to 120°C, a minimum of four coats should be applied with care taken to avoid emulsion accumulation and run marks due to over application. Allow time for the relase agent to cure prior to production.

Mold Touch up

Touch up coats should only be applied to areas where poor release is noticed and should be applied using the same method as base coats. This will reduce the possibility of release agent or polymer build-up. The frequency of touch ups will depend on the polymer type, mold configuration, and abrasion parameters.

Loctite Material Specification[LMS]

LMS dated August 19, 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

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

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 Corporation 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.

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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