

## Product Description

FK55 Mold Release Sheets combine textile and chemical technology to create an easy-to-use method of applying mold release agents. The 2-ply sheets provide an ideal amount of mold release agent for a typical application. Each sheet is saturated with the proven mold release agent, Henkel's Frekote® 55-NC. This ready-to-use product efficiently controls solvent use and application.

## Features

### Sheet/Package:

- 2-ply polypropylene sheet
  - Durable and flexible
  - High liquid holding capacity
  - Low linting
- Convenient single use pouch with 5 or 10 sheets

### Mold Release Agent:

- Satin finish
- Low odor
- Quick cure at room or elevated temperature
- Semi-permanent multiple releases with no contaminating transfer

## Directions for Use

### For industrial use only. Read MSDS carefully prior to use.

FK55 can be applied to mold surfaces at room temperature up to 60°C (140°F). Always use in a well ventilated area. Store in a cool, dry place.

1. Only a thin wet film is required. Wipe on a smooth, thin, continuous wet film. Avoid wiping over the same area that was just coated until the solvents have evaporated. It is suggested that small areas be coated working progressively from one side of the mold to the other.
2. Initially, apply 2-3 base coats allowing 5 minutes between coats for solvent evaporation.
3. Curing of the final coat takes 30 minutes at room temperature and can be shortened by baking the mold for only 5 minutes at 100°C-150°C (210°F-300°F).
4. Maximum releases will be obtained as the mold surface becomes conditioned to FK55. Performance is enhanced by recoating once, after the first few initial pulls.
5. When any release difficulty is experienced, the area in question can then be "touched-up" by re-coating the entire surface or by coating those areas where release difficulty is occurring.

## Recommended Applications

<b>Substrates</b>	Advanced composites/epoxy systems
<b>Mold Methods</b>	Compression molding/casting/vacuum bagging

## Other Applications

<b>Thermoplastics</b>	Polyethylene/polypropylene/nylon
<b>Thermosets</b>	Polyester gel coat/vinyl ester

## Chemical Properties

<b>Surface Finish</b>	Satin
<b>Application Temperature</b>	20°C-60°C (68°F-140°F)
<b>Minimum # base of coats</b>	2-3
<b>Dry time between coats</b>	5 minutes
<b>Cure Time @ Room Temperature</b>	30 minutes
<b>Cure Time @ High Temperature</b>	5 minutes @ 100°C-150°C (210°F-300°F)
<b>Flash Point</b>	7°C (45°F)
<b>Thermal Stability</b>	400°C (752°F)
<b>Appearance</b>	Clear liquid
<b>Odor</b>	Hydrocarbon
<b>Solvent</b>	Aliphatic Hydrocarbon

## Sheet Properties

<b>Type</b>	Spunbond polypropylene
<b>Design</b>	2-ply pinsonic bonded
<b>Dimensions</b>	11" x 7" - nominal
<b>Weight</b>	1.5 oz

## Products

Product Name	Product Code	Packaging
FK55-5	TX9406	5 sheets/pouch 20 pouches/case
FK55-10	TX9407	10 sheets/pouch 20 pouches/case

Frekote® is a registered trademark of Henkel Corporation, USA.

**Note:** This information is believed to be accurate. It is intended for professional end users having the skills to evaluate and use the data properly. ITW Texwipe® does not guarantee the accuracy of the data and assumes no liability in connection with damages incurred while using it.

A product of ITW Texwipe®  
300B Route 17 South • Mahwah, NJ 07430  
Tel: 1-800-TEXWIPE • 1-201-684-1800 • Fax: 1-201-684-1801  
www.texwipe.com Rev. 8056