
Henkel’s coatings can be applied to the following surfaces:
- Phenolic spacings, pre-foamed and written
- Phenolic prepanes
- Phenolic plastics
- Phenolic spacings
- Natural or synthetic rubbers
- Silicones
- Polyester resins
- Teflon® (PFA) resins
- Silicones and composites
- Teflon® and composites
- Teflon® or composites
- Teflon® or composites
- Teflon® or composites

Henkel mold releases can be used in all composite manufacturing processes:
- Hand-lay-up
- Automated fiber placement & tape laying
- Resin transfer molding
- Vacuum bag only molding
- Meso transfer molding
- Vacuum infusion processes
- Hexa-foil infusions
- Filament winding
- Injection molding
- Compostable molding
- Polyurethanes
- Re-application
- Ceramic or composite molding
- Automated spray application

Troubleshooting Guide

<table>
<thead>
<tr>
<th>Problem</th>
<th>Cause</th>
<th>Solution</th>
</tr>
</thead>
<tbody>
<tr>
<td>Complete failure to obtain release</td>
<td>Insufficiently cleaned mold surface has precipitated and thus ineffective LOCTITE® FREKOTE®</td>
<td>Thoroughly clean mold and reapply LOCTITE® FREKOTE®.</td>
</tr>
<tr>
<td>Poor release accompanied by small patches of residue remaining on metal surface</td>
<td>Insufficiently cleaned plastic mold</td>
<td>Thoroughly clean mold, apply LOCTITE® FREKOTE® top coats.</td>
</tr>
<tr>
<td>Poor release accompanied by white blotches on parts</td>
<td>Insufficiently cleaned mold surface</td>
<td>Thoroughly clean mold and apply LOCTITE® FREKOTE® top coats.</td>
</tr>
<tr>
<td>Poor release accompanied by small blemishes on parts</td>
<td>Insufficiently cleaned mold surface</td>
<td>Thoroughly clean mold and apply LOCTITE® FREKOTE® top coats.</td>
</tr>
<tr>
<td>Poor release accompanied by distinct blisters on parts</td>
<td>Insufficiently cleaned mold surface</td>
<td>Thoroughly clean mold and apply LOCTITE® FREKOTE® top coats.</td>
</tr>
<tr>
<td>Poor release high-draft areas</td>
<td>Insufficiently cleaned mold surface</td>
<td>Thoroughly clean mold and apply LOCTITE® FREKOTE® top coats.</td>
</tr>
<tr>
<td>Mobility to achieve multiple releases</td>
<td>Insufficiently cleaned mold surface</td>
<td>Thoroughly clean mold and apply LOCTITE® FREKOTE® top coats.</td>
</tr>
</tbody>
</table>

Mold Release Agents for the Aerospace Composites Industry

LOCTITE® BONDERITE TECHNOLOGY. TESORON. AQUANCE.
customers throughout the globe. Henkel’s LOCTITE® FREKOTE® release agents, sealers and cleaners are based on over 50 years of technical experience and are the most trusted

**LOCTITE® FREKOTE®: The Aerospace Standard**

With support from its authorized aerospace distribution network, Henkel delivers LOCTITE®-FREKOTE® mold release agents to aerospace customers throughout the globe.

Henkel provides optimum solutions to meet the most rigorous requirements and is qualified worldwide at all major aircraft manufacturers. That is durable, chemically resistant and thermally stable. A minimal transfer to molded components, low clogging, easy application and the

**Key Factors to Consider When Choosing the Right LOCTITE® Product**

- Non-stick mold release
- High slip characteristics
- Use temperature
- Transfer characteristics

**Product Type**

<table>
<thead>
<tr>
<th>LOCTITE® FREKOTE®</th>
<th>LOCTITE® FREKOTE® (Formerly B-15™) Frekote</th>
<th>LOCTITE® FREKOTE® (Formerly 44-NC™) Frekote</th>
<th>LOCTITE® FREKOTE® (Formerly 55-NC™) Frekote</th>
<th>C-800™ Frekote</th>
<th>C-800™ AERO</th>
<th>770-NC AERO</th>
<th>B-15™ AERO</th>
<th>44-NC™ AERO</th>
<th>55-NC™ AERO</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mold Cleaner</td>
<td>Mold Sealer</td>
<td>Mold Cleaner</td>
<td>Mold Cleaner</td>
<td>Mold Cleaner</td>
<td>Mold Cleaner</td>
<td>Mold Cleaner</td>
<td>Mold Cleaner</td>
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</tr>
<tr>
<td>Applications</td>
<td>Wax Retaining</td>
<td>Liquid Retaining</td>
<td>Liquid Retaining</td>
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<td>Liquid Retaining</td>
<td>Liquid Retaining</td>
<td>Liquid Retaining</td>
</tr>
<tr>
<td>Silicone Free</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
<td>Yes</td>
</tr>
<tr>
<td>Product Appearance</td>
<td>Clear Liquid (Wax- and silicone-free)</td>
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<td>Clear Liquid</td>
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</tr>
</tbody>
</table>
| **LOCTITE® FREKOTE® Water-Based Mold Release**

<table>
<thead>
<tr>
<th>Product Type</th>
<th>Water-Based Mold Release</th>
</tr>
</thead>
<tbody>
<tr>
<td>Applications</td>
<td>Max Retaining</td>
</tr>
<tr>
<td>Finishing</td>
<td>Glass Finish</td>
</tr>
<tr>
<td>Silicone Free</td>
<td>No</td>
</tr>
<tr>
<td>Product Appearance</td>
<td>Clear Liquid</td>
</tr>
</tbody>
</table>
| **FREKOTE® Mold Release Benefits**

- No volatileorganic compounds (VOCs)
- No CFC releases
- Non-terpolymer mold release leads to mold surface for consistent release
- Higher productivity and part quality through reduced downtime and lower rework rates
- Spraying equipment required

**Regions Available**

- Asia Pacific
- Europe, Middle East, Africa
- Latin America
- North America

**New Product Names**

- **LOCTITE® FREKOTE®** (Formerly B-15™) Frekote
- **LOCTITE® FREKOTE®** (Formerly 44-NC™) Frekote
- **LOCTITE® FREKOTE®** (Formerly 55-NC™) Frekote
- **LOCTITE® FREKOTE®** (Formerly C-800™) Frekote
- **LOCTITE® FREKOTE®** (Formerly 770-NC™) Frekote
- **LOCTITE® FREKOTE®** (Formerly C-800™) AERO
- **LOCTITE® FREKOTE®** (Formerly 770-NC™) AERO

**Key Features**

- B-15™ Frekote
- 44-NC™ Frekote
- 55-NC™ Frekote
- C-800™ Frekote
- 770-NC™ Frekote

**Comprehensive Compendium**

- 50 years of technical experience
- Worldwide qualification at all major aircraft manufacturers
- Optimum solutions to meet the most rigorous requirements
- Durable, chemically resistant and thermally stable
- Minimal transfer to molded components
- Low clogging
- Easy application
- No mold build-up
- High slip characteristics
- No mold contamination
- Excellent release performance
- No mold build-up
- Highly effective release agents
- No mold contamination
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