

Description

Loctite® Frekote® HMT®, a hot mold touch up version of Loctite® Frekote® 44-NC is formulated for use on molds with temperatures above 60°C (140°F). After one touch up coat, HMT continues to offer multiple releases per application. For temperatures over 60°C (140°F), Loctite® Frekote® HMT performs effectively on its own. It is also compatible with all other Loctite® Frekote® products.

Features

Multiple Releases
No contaminating transfer
No mold build up
Minimum reject rates
Instant cure at temperatures above 140°F

Properties

Appearance	Clear liquid
Odor	Hydrocarbon
Solvents	DiButyl Ether, Aliphatic Hydrocarbon, Aromatic Hydrocarbon
Specific Gravity	0.78 +/- 0.020
Special Cautions	Moisture sensitive, keep container tightly closed when not in use
Shelf Life	Two years from date of manufacture
Cured Thermal Stability	400°C (750°F)
Application Temp	60°C - 190°C (140°F -375°F)

Mold Preparation

The mold surface must be clean and free of any release agent or other contaminants for Loctite® Frekote® HMT to be completely effective. Remove any contaminants with Loctite® Frekote® PMC or another suitable cleaning solvent. Light industrial abrasives can be used to remove heavy resin build up. No mold preparation is required when HMT is used as a touch up coat over another Loctite® Frekote® Product.

Note: For porous or repaired molds, a Loctite® Frekote® Sealer should be used - technical data is available. Consult with your Henkel Representative for assistance.

Touch up Application *Consult MSDS prior to use*

Loctite® Frekote® HMT is intended as a touch up on mold surfaces above 60°C (140°F) and applied by spraying or brushing. For spraying use conventional equipment, insuring a dry, oil free air source is used. Spray or brush on one thin wet film coating on the area that has a difficult release.

Loctite® Frekote® HMT dries very rapidly at elevated temperatures. Care should be taken to ensure complete coverage.

Release Application

1. If using Loctite® Frekote® HMT as a releasing system on its own, apply a thin wet continuous film coating the entire mold. It is suggested that small areas be coated working progressively from one side of the mold to the other.
2. For the initial application 4-6 coats are recommended, allowing a few minutes between coats for solvent evaporation. If using as a touch up coat over another Loctite® Frekote® product, only one light, uniform coat is needed.
3. After the final coat, curing is completed through solvent evaporation and ready for production within a few minutes.
4. Maximum releases will be obtained as the mold surface becomes conditioned to Loctite® Frekote® HMT. Performance is enhanced by re-coating once, after the first few initial pulls.

Flammability/Storage

Loctite® Frekote® HMT contains flammable solvents. The product should always be used in well-ventilated areas. Consult MSDS for complete details.

Note

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