

# FK55 Mold Release Sheets

TX9406  
TX9407



## Also available:



7" x 11" Sheets  
Pre-wetted with 100%  
Frekote 710-NC



7" x 11" Sheets  
Pre-wetted with 100%  
Frekote 44-NC

## Description

Texwipe's FK55 Mold Release Sheets combine textile and chemical technology to create an effective point of use product for applying mold release agents. The 2-ply spunbond polypropylene sheets are pre-wetted with Henkel's Frekote 55-NC. Each saturated sheet is packaged in a point of use pouch to ensure a consistent and accurate amount of solvent for uniform application to mold surfaces.

## Features

- » Durable, low linting chemical resistant wiper
- » Wipers pre-wet with accurately measured volumes of Frekote 55-NC
- » Convenient, single use pouch – 5 or 10 sheets
- » Satin finish mold release
- » Quick cure at room temperature
- » Semi-permanent multiple releases

## Benefits

- » Reduced worker exposure to hazardous chemicals
- » Reduced VOC emissions
- » Optimized mold release usage
- » Reduced spill potential

## Applications

- » Compression Molding
- » Casting
- » Vacuum Bagging
- » Release of:
  - epoxies (thermosets and prepregs)
  - polyester resins
  - thermoplastics
  - adhesives
  - rotational molded plastics

## Products

TX Number	Description	Packaging
<b>TX9406</b>	7" x 11" sheets pre-wetted with 100% Frekote 55-NC	5 sheets/pouch 20 pouches per case
<b>TX9407</b>	7" x 11" sheets pre-wetted with 100% Frekote 55-NC	10 sheets/pouch 20 pouches per case

Aerospace

Printing

Automotive

Marine



**North America**  
1210 South Park Drive • Kernersville, NC 27284  
Tel (800) 839-9473 • (336) 996-7046  
Fax (336) 996-2297  
[www.texwipe.com](http://www.texwipe.com)  
[info@texwipe.com](mailto:info@texwipe.com)

**Asia/Pacific**  
50 Tagore Lane • #02-01 Entrepreneur Centre  
Singapore 787494  
Tel +65 6468 9433 • Fax +65 6468 6772

**Europe/Middle East**  
Saffierlaan 5  
2132 VZ Hoofddorp • The Netherlands  
Tel +31 88 1307 400 • Fax +31 88 1307 499

# FK55 Mold Release Sheets

---

## Recommended Applications

<b>Substrates</b>	Advanced composites/epoxy systems
<b>Mold Methods</b>	Casting/Hand lay up/Spray lay up/ Compression molding/transfer/vacuum bagging

---

## Other Applications

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

---

## Release Agent Properties

<b>Surface Finish</b>	Satin
<b>Application Temperature</b>	15°C-60°C (59°F-140°F)
<b>Minimum # of Base Coats</b>	3-6
<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 (212°F-302°F)
<b>Flash Point</b>	7°C (45°F)
<b>Cured Thermal Stability</b>	400°C (752°F)
<b>Appearance</b>	Clear liquid
<b>Odor</b>	Mild, solvent
<b>Solvent</b>	Naphtha, light alkylate

---

## Sheet Properties

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

## 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. Wipe on a smooth, thin, continuous wet film. Only a thin film is required. 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 3-6 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 5 minutes at 100°C-150°C (212°F-302°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.