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Product Description Sheet

FREKOTE® 800-NC Mold Release Agent

Industrial Products, October 2003

Description

Loctite® Frekote® 800-NC has been designed to form a semi-permanent release film on mold surfaces above 150°C (300°F). The multiple release polymer system chemically bonds to the mold surface to form a micro thin chemically resistant coating. Frekote 800-NC will release all natural and synthetic organic rubber compounds and should be considered for all molding processes with mold temperatures continually above 150°C (300°F). Frekote 800-NC cures upon solvent evaporation when applied at temperatures above 150°C (300°F).

Features

No chlorinated solvents
Instant curing
No mold build-up
Releases most rubber compounds
Reduced reject rates

Properties

Color	Clear liquid
Odor	Hydrocarbon
Solvents	Aliphatic Naphtha
Specific Gravity	0.780 +/- 0.020
Shelf Life	18 month from date of manufacture
Cured thermal stability	400°C (750°F)
Special Cautions	Moisture Sensitive, keep container tightly closed when not in use

Mold Preparation

The mold surface must be clean and free of any release agent or other contaminants for Frekote 800-NC to be completely effective. Remove any contaminants with Frekote PMC or another suitable cleaning solvent. Grit blasting or other abrasive methods can be used to remove heavy resin build up. Always follow with a solvent wipe to remove residue.

Note: For porous or damaged molds, Frekote B-15 Sealer should be considered - technical data is available.

Application *Consult MSDS prior to use*

When the mold is clean and free from other release agent or contaminant, it should be heated to a minimum temperature of 150°C (300°F). This normally represents the minimum preheating temperature for rubber presses.

Frekote 800-NC may be applied by spraying (ensuring a dry air source), airless spray, brushing, dipping or wiping. Spray applications are the preferred method for applying Frekote 800-NC to a hot mold surface.

Spraying

1. When spraying bulk material, it is essential to always use a dry, oil free air source.
2. Keeping the nozzle 8-10" from the mold surface spray on a light uniform coating. At 150°C (300°F) solvents will evaporate within 30 seconds and at 180°C (355°F) evaporation will be instantaneous.
3. Apply a minimum of three base coats to the hot mold. Care should be taken not to over apply the material to the hot surface. Maximum releases will be obtained as the mold becomes conditioned to Frekote 800-NC. Performance will be improved by applying a touch-up coat after the first few multiple releases. Frekote 800-NC efficiency may be lessened in processes involving heavily filled polymers and additional touch-ups may be necessary in such areas.

Touch Up

Touch up coats should be applied at regular intervals determined by the operator. This will depend on the polymer type, mold configuration and abrasion parameters. Touch up coats will maintain the base coats, hence reduce the chance for compound or polymer build-up.

Flammability/Storage

Frekote 800-NC contains flammable solvents. The product should always be used in well-ventilated areas. Store in a cool dry place. Keep container tightly closed when not in use. Consult MSDS for complete details

Note

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