

# LOCTITE® Frekote® 800-NC

November 2015

## Product description

LOCTITE® Frekote® 800-NC provides the following product characteristics:

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. LOCTITE® 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). LOCTITE® 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 LOCTITE® Frekote® 800-NC to be completely effective. Remove any contaminants with LOCTITE® 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, LOCTITE® Frekote® B-15 aealer 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.

LOCTITE® 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 LOCTITE® 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 LOCTITE® Frekote® 800-NC. Performance will be improved by applying a touch-up coat after the first few multiple releases. LOCTITE® Frekote® 800-NC efficiency may be lessened in processes involving heavily filled polymers and additional touch-ups may be necessary in such areas.

## Mold Touch up

Touch up coats should only be applied to areas where poor release is noticed and should be applied using the same method as base coats. The frequency of touch ups will depend on the polymer type, mold configuration, and abrasion parameters. This will reduce the possibility of release agent or polymer build-up.

## Flammability/Storage

LOCTITE® 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.

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